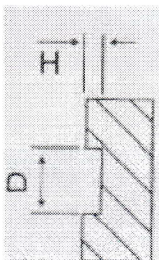


Solid Carbide with TiAlN coating End Mills Data Sheet

2F end mills

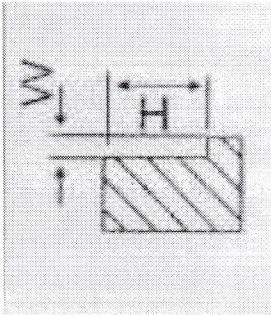
Workpiece	heat treat steel heat-resistance alloy nickel base alloy Inconel	
	HRC 45-50	Feed speed mm/min
Diameter	rpm	Feed speed
mm		mm/min
D1.0	3200	13
D2.0	1900	19
D3.0	1500	25
D4.0	1270	32
D5.0	1150	40
D6.0	1060	50
D8.0	800	50
D10.0	640	50
D12.0	530	50
D16.0	400	38
D20.0	320	30



$D \leq 3.0 \text{ mm}, H \leq 0.05$
 $D > 3.0 \text{ mm}, H \leq 0.10$

4F end mills

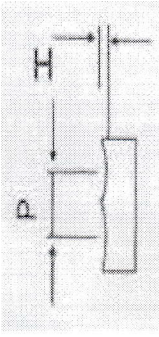
Workpiece	heat treat steel Ti alloy Ti-6Al-4V		heat treat steel heat-resistance alloy nickel base alloy Inconel	
	HRC 45-50	Feed speed mm/min	HRC 45-50	Feed speed mm/min
Diameter	rpm	Feed speed	rpm	Feed speed
mm		mm/min		mm/min
D3.0	3600	110	1500	46
D4.0	3000	150	1270	60
D5.0	2700	220	1150	96
D6.0	2500	220	1060	96
D8.0	1900	220	800	96
D10.0	1500	220	640	96
D12.0	1300	220	530	96
D16.0	950	170	400	72
D20.0	760	135	320	57



$H \leq 1D, W \leq 0.05D$

2F ball nose end mills

Workpiece	equal height cutting		heat treat steel HRC 45-55	
	Spindle speed rpm	Feed speed mm/min	Spindle speed rpm	Feed speed mm/min
Radius	rpm	Feed speed	Spindle speed	Feed speed
mm		mm/min	rpm	mm/min
R0.5	19000	210	13300	150
R1.0	9500	210	6600	150
R1.5	6400	210	4500	150
R2.0	4800	270	3400	190
R2.5	3800	290	2700	200
R3.0	3200	300	2200	210
R4.0	2300	320	1600	220
R5.0	1900	330	1300	230
R6.0	1600	310	1100	220
R8.0	1100	270	770	190
R10.0	950	250	660	180
R12.5	760	210	530	150



$H \leq 0.03R, P \leq 0.05R$