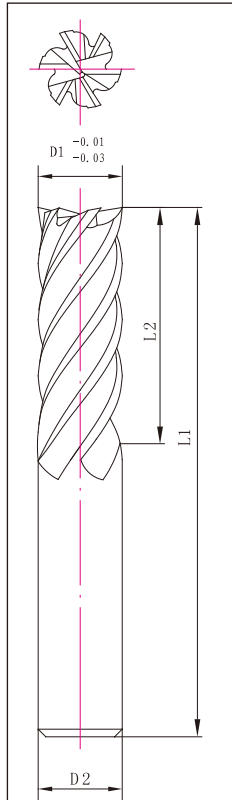


Multiple Flute Standard for Super Finishing

多齿精加工标准型

MG
TYPE N
HRC 45
50°
RUN OUT <0.02
AlCrN

Type & Specifications / 类型与规格

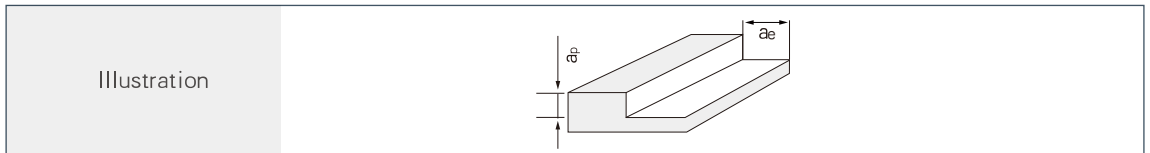


D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
6.0	6	15	50	6	D1180906020
8.0	8	20	60	6	D1180908020
10.0	10	25	75	6	D1180910020
12.0	12	30	75	6	D1180912020
14.0	14	35	100	6	D1180914020
16.0	16	40	100	6	D1180916020
18.0	18	45	100	6	D1180918020
20.0	20	45	100	8	D1180920020
25.0	25	45	100	8	D1181125020

Recommendation / 推荐切削条件

Diameter D1	Carbon Steel		Alloy Steel		Hardened Steel HRC30-45	
	Speed n	Feed Vf	Speed n	Feed Vf	Speed n	Feed Vf
6.0	6365	2300	5220	1750	3690	1195
8.0	4775	2300	3920	1750	2770	1195
10.0	3820	2300	3130	1750	2220	1195
12.0	3185	2300	2610	1750	1850	1195
14.0	2730	2200	2240	1670	1580	1145
16.0	2390	2100	1960	1600	1390	1090
18.0	2120	1860	1740	1410	1230	965
20.0	1910	1770	1570	1350	1110	920
25.0	1530	1530	1250	1160	890	795

ap (Depth) ap=1.5D
 ae (Width) ae=0.05D



- ⊙ Please optimize the over-hang
- ⊙ Be in climb milling. Please lower the recommendations simultaneously in case cutting tools shake badly
- ⊙ Please use suitable coolants

Work Materials / 被加工材质

Steels			Cast Iron	Aluminium Alloys	Copper Alloys	Stainless Steel	Titanium Alloys	Graphite
<HRC45	<HRC60	<HRC65						
⊙			⊙	○	○	○		

⊙ Preferential ○ Suitable

Carbide End Mills



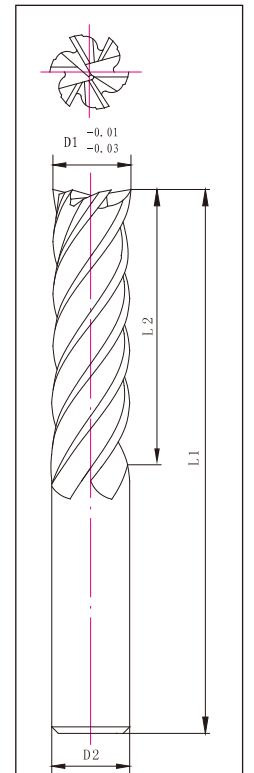
Multiple Flute Long Length for Super Finishing

多齿精加工加长型



Type & Specifications/类型与规格

D1	D2	L2	L1	Flute No.	Order No.
6.0	6	25	75	6	D1183006020
8.0	8	30	75	6	D1183008020
10.0	10	40	100	6	D1183010020
12.0	12	45	100	6	D1183012020
14.0	14	45	100	6	D1183014020
16.0	16	60	150	6	D1183016020
18.0	18	60	150	6	D1183018020
20.0	20	60	150	8	D1183020020
25.0	25	70	150	8	D1183225020



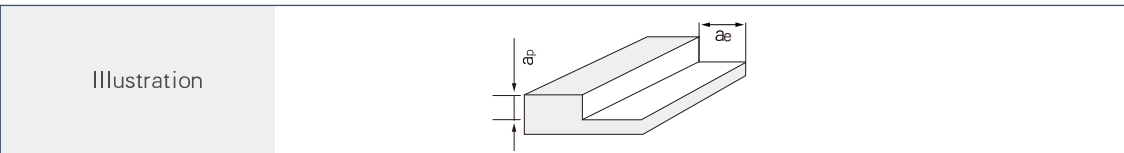
Carbide End Mills



Recommendation/推荐切削条件

Diameter D1	Carbon Steel		Alloy Steel		Hardened Steel HRC30~45	
	Speed n	Feed Vf	Speed n	Feed Vf	Speed n	Feed Vf
6.0	5090	1840	4180	1400	2950	955
8.0	3820	1840	3140	1400	2220	955
10.0	3060	1840	2500	1400	1780	955
12.0	2550	1840	2090	1400	1480	955
14.0	2180	1760	1790	1330	1260	915
16.0	1910	1680	1570	1280	1110	870
18.0	1700	1490	1390	1130	985	770
20.0	1530	1410	1260	1080	890	735
25.0	1220	1220	1000	930	710	635

ap (Depth) ap=1.5D
 ae (Width) ae=0.05D



- ⊙ Please optimize the over-hang
- ⊙ Be in climb milling. Please lower the recommendations simultaneously in case cutting tools shake badly
- ⊙ Please use suitable coolants

Work Materials/被加工材质

Steels			Cast Iron	Aluminium Alloys	Copper Alloys	Stainless Steel	Titanium Alloys	Graphite
<HRC45	<HRC60	<HRC65						
⊙			⊙	○	○	○		

⊙ Preferential ○ Suitable

Multiple Flute Stub Length for Super Finishing

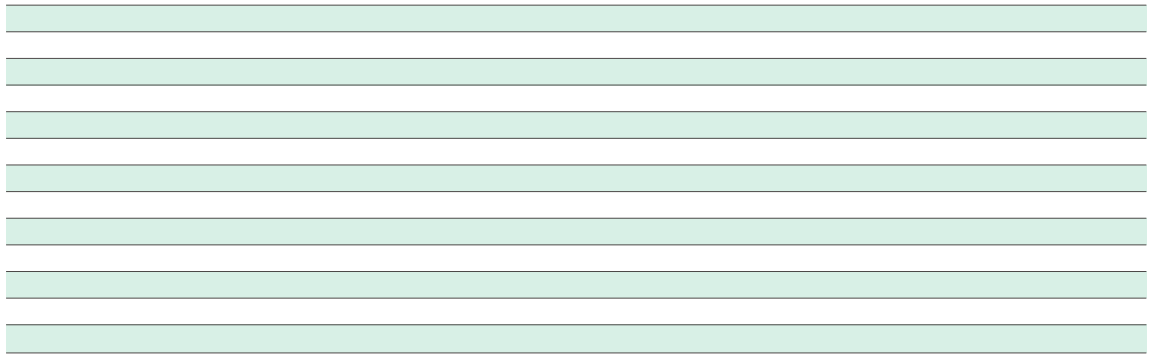
多齿精加工短刃型



Type & Specifications/类型与规格



D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
6.0	6	10	54	6	1180921120
8.0	8	12	59	6	1180921620
10.0	10	14	67	6	1180922120
12.0	12	16	73	6	1180922620
14.0	14	18	73	6	1180923120
16.0	16	22	83	6	1180923620
18.0	18	24	83	6	1180924120
20.0	20	26	93	8	1180924620



Multiple Flute Standard for Super Finishing

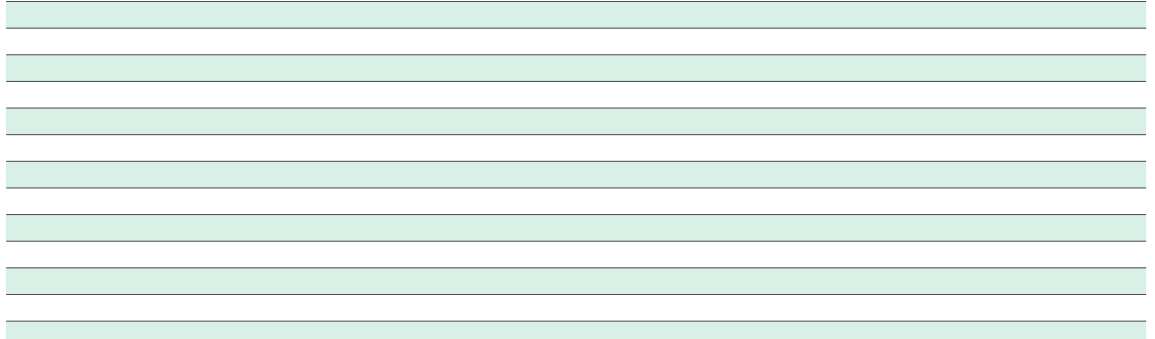
多齿精加工标准型



Type & Specifications/类型与规格



D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
6.0	6	13	57	6	1180931120
8.0	8	19	63	6	1180931620
10.0	10	22	72	6	1180932120
12.0	12	26	83	6	1180932620
14.0	14	26	83	6	1180933120
16.0	16	32	92	6	1180933620
18.0	18	32	92	6	1180934120
20.0	20	38	104	8	1180934620
25.0	25	38	104	8	1180935120



Multiple Flute long Length for Super Finishing

多齿精加工加长型



Type & Specifications/类型与规格

D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
6.0	6	18	62	6	1183021120
8.0	8	24	68	6	1183022120
10.0	10	30	80	6	1183022620
12.0	12	36	93	6	1183023120
14.0	14	42	99	6	1183023620
16.0	16	48	108	6	1183024120
18.0	18	54	114	6	1183024620
20.0	20	60	126	8	1183025120
25.0	25	60	126	8	1183025120



Carbide End Mills

Multiple Flute Long Length for Super Finishing

多齿精加工加长型

MG

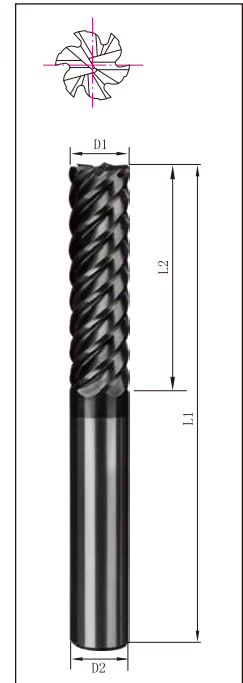
TYPE
N

HRC
45

AlCrN

Type & Specifications / 类型与规格

D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
1/2	1/2	2	4	6	1060301120
1/2	1/2	3	6	6	1060301320
5/8	5/8	2	5	6	1060301520
5/8	5/8	3-1/4	6	6	1060301720
3/4	3/4	2-1/2	5	6	1060301920
3/4	3/4	3	6	6	1060302120
3/4	3/4	3-1/4	6	6	1060302320
3/4	3/4	2-1/2	5	8	1060302520
3/4	3/4	3	6	8	1060302720
3/4	3/4	3-1/4	6	8	1060302920
1	1	2-1/4	6	8	1060303120
1	1	3-1/4	6	8	1060303320



Carbide End Mills