

Four Flute Standard
四齿标准型

Type & Specifications/类型与规格

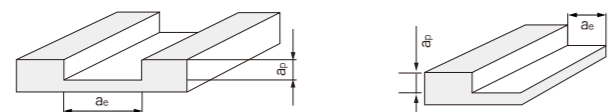
D1	D2 h6	L2 js14	L1 js14	Flute No.	Orde No.
4.0	4	10	50	4	C4SDML040004
5.0	6	15	50	4	C4SDML050006
6.0	6	15	50	4	C4SDML060006
8.0	8	20	60	4	C4SDML080008
10.0	10	25	75	4	C4SDML100010
12.0	12	30	75	4	C4SDML120012
16.0	16	40	100	4	C4SDML160016
20.0	20	45	100	4	C4SDML200020

Recommendation/推荐切削条件

Diameter D1 (mm)	Carbon Steel		Alloy Steel		Hardened Steel		Ni-Based Stainless Steel	
	Speed n(R/min)	Feed Vf(mm/min)	Speed n(R/min)	Feed Vf(mm/min)	Speed n(R/min)	Feed Vf(mm/min)	Speed n(R/min)	Feed Vf(mm/min)
4.0	9000	900	7160	710	4780	380	3980	230
5.0	7200	860	5730	690	3820	380	3180	250
6.0	6000	840	4780	670	3180	380	2650	260
8.0	4500	810	3580	640	2340	380	1990	200
10.0	3600	790	2860	630	1910	340	1590	190
12.0	3000	720	2390	570	1590	320	1320	180
16.0	2250	560	1790	450	1190	260	990	160
20.0	1800	470	1430	370	960	230	790	140
ap (Depth)	ap=1.0D		ap=1.0D		ap=0.5D		ap=0.5D	
ae (Width)	ae=1.0D		ae=1.0D		ae=1.0D		ae=1.0D	

Diameter D1 (mm)	Carbon Steel		Alloy Steel		Hardened Steel		Ni-Based Stainless Steel	
	Speed n(R/min)	Feed Vf(mm/min)	Speed n(R/min)	Feed Vf(mm/min)	Speed n(R/min)	Feed Vf(mm/min)	Speed n(R/min)	Feed Vf(mm/min)
4.0	9800	1170	7850	950	5550	550	4750	280
5.0	7900	1100	6300	850	4450	530	3820	300
6.0	6550	1050	5250	840	3700	520	3180	320
8.0	4900	980	3950	790	2780	500	2390	280
10.0	3950	950	3150	750	2230	450	1910	270
12.0	3300	850	2620	680	1850	400	1590	250
16.0	2450	630	1950	500	1390	330	1190	210
20.0	2000	560	1550	430	1110	290	950	190
ap (Depth)	ap=1.5D		ap=1.5D		ap=1.5D		ap=1.5D	
ae (Width)	ae=0.4D		ae=0.4D		ae=0.2D		ae=0.2D	

Illustration



- ⊙ 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							

Four Flute Long Length
四齿加长型

Type & Specifications/类型与规格

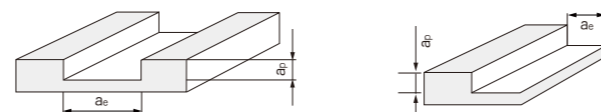
D1	D2 h6	L2 js14	L1 js14	D3	L3	Flute No.	Orde No.
6.0	6	20	75	5.7	35	4	C4SDLL060006
8.0	8	25	75	7.7	35	4	C4SDLL080008
10.0	10	35	100	9.5	50	4	C4SDLL100010
12.0	12	40	100	11.5	50	4	C4SDLL120012
16.0	16	50	150	15.0	70	4	C4SDLL160016
20.0	20	60	150	19.0	80	4	C4SDLL200020

Recommendation/推荐切削条件

Diameter D1 (mm)	Carbon Steel		Alloy Steel		Hardened Steel		Ni-Based Stainless Steel	
	Speed n(R/min)	Feed Vf(mm/min)	Speed n(R/min)	Feed Vf(mm/min)	Speed n(R/min)	Feed Vf(mm/min)	Speed n(R/min)	Feed Vf(mm/min)
6.0	5700	670	4540	540	3020	300	2520	240
8.0	4280	650	3400	510	2220	300	1830	180
10.0	3420	630	2700	500	1810	270	1510	170
12.0	2850	580	2270	460	1510	260	1250	160
16.0	2140	450	1700	360	1130	210	940	150
20.0	1710	380	1360	296	910	190	750	130
ap (Depth)	ap=1.0D		ap=1.0D		ap=0.5D		ap=0.5D	
ae (Width)	ae=1.0D		ae=1.0D		ae=1.0D		ae=1.0D	

Diameter D1 (mm)	Carbon Steel		Alloy Steel		Hardened Steel		Ni-Based Stainless Steel	
	Speed n(R/min)	Feed Vf(mm/min)	Speed n(R/min)	Feed Vf(mm/min)	Speed n(R/min)	Feed Vf(mm/min)	Speed n(R/min)	Feed Vf(mm/min)
6.0	6220	900	5000	710	3500	440	3000	270
8.0	4650	830	3750	670	2650	420	2270	240
10.0	3750	800	3000	630	2110	380	1800	230
12.0	3150	720	2500	580	1750	340	1510	210
16.0	2300	530	1850	420	1320	280	1130	180
20.0	1900	470	1480	360	1050	250	900	160
ap (Depth)	ap=2.0D		ap=2.0D		ap=2.0D		ap=2.0D	
ae (Width)	ae=0.3D		ae=0.3D		ae=0.15D		ae=0.15D	

Illustration



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- ⊙ 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							

HI-EFFICIENCY
END MILL in DOUBLE
GROOVE渐变芯厚
高效加工铣刀

Multi-Function: The distinctive physical design broadens the adaptability of end mills, which can perform outstandingly both in slotting and side milling, both for roughing and finishing.

Hi-Efficiency: The flute geometry (double groove) enlarges the chip pocket and keeps the tool's strength as well, during the milling process. The Unequal Blade Spacing eliminates the harmonic vibration. Thusly the Cutting Depth, Width and Feed Speed can be boosted with the slotting efficiency increased in 4 times and side milling in more than 70%.

Ultra-Precision: The High Helix & Anti-Vibration Geometry makes the machining stable and smooth, improves the work-piece's finish and precision ultra better.

Four Flute Standard 四齿标准型

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

Type & Specifications/类型与规格

D1	D2 h6	L2 js14	L1 js14	Corner Chamfer	Flute No.	Order No.
3	6	8	57	0.045x45°	4	C4SDML030006-DIN
4	6	11	57	0.06x45°	4	C4SDML040006-DIN
5	6	13	57	0.075x45°	4	C4SDML050006-DIN
6	6	15	57	0.09x45°	4	C4SDML060006-DIN
8	8	20	63	0.12x45°	4	C4SDML080008-DIN
10	10	24	72	0.15x45°	4	C4SDML100010-DIN
12	12	28	83	0.18x45°	4	C4SDML120012-DIN
16	16	36	92	0.24x45°	4	C4SDML160016-DIN
20	20	38	104	0.30x45°	4	C4SDML200020-DIN



Carbide End Mills