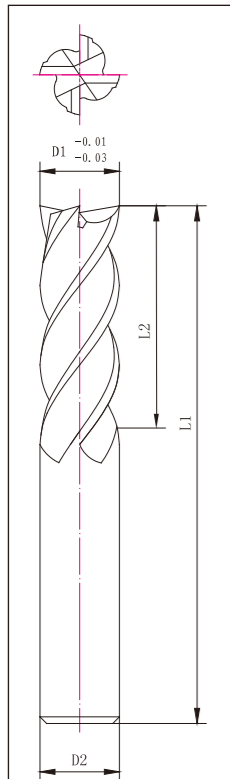


Four Flute Standard 四齿标准型



Type & Specifications/类型与规格



D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
1.0	4	4	50	4	P1180501020
1.5	4	5	50	4	P1180502020
2.0	4	6	50	4	P1180503020
2.5	4	8	50	4	P1180504020
3.0	4	8	50	4	P1180505020
3.5	4	10	50	4	P1180506020
4.0	4	10	50	4	P1180507020
1.0	6	4	50	4	P1180508020
1.5	6	6	50	4	P1180509020
2.0	6	6	50	4	P1180510020
2.5	6	8	50	4	P1180511020
3.0	6	8	50	4	P1180512020
3.5	6	10	50	4	P1180513020
4.0	6	12	50	4	P1180514020
4.5	6	12	50	4	P1180515020
5.0	6	15	50	4	P1180516020
5.5	6	15	50	4	P1180517020
6.0	6	15	50	4	P1180518020
6.5	8	20	60	4	P1180519020
7.0	8	20	60	4	P1180520020
7.5	8	20	60	4	P1180521020
8.0	8	20	60	4	P1180522020
8.5	10	25	75	4	P1180523020
9.0	10	25	75	4	P1180524020
9.5	10	25	75	4	P1180525020
10.0	10	25	75	4	P1180526020
11.0	12	30	75	4	P1180527020
12.0	12	30	75	4	P1180528020
13.0	14	35	90	4	P1180529020
14.0	14	35	90	4	P1180530020
15.0	16	40	100	4	P1180531020
16.0	16	40	100	4	P1180532020
17.0	18	45	100	4	P1180533020
18.0	18	45	100	4	P1180534020
19.0	20	45	100	4	P1180535020
20.0	20	45	100	4	P1180536020
22.0	22	45	100	4	P1180537020
25.0	25	45	100	4	P1180538020

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

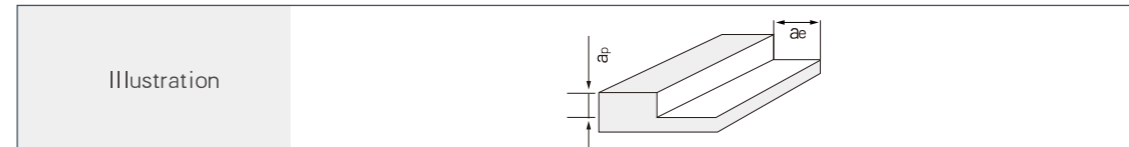
Four Flute Standard 四齿标准型



Recommendation/推荐切削条件

Diameter D1 (mm)	Hardened Steel HRC45~55		Hardened Steel HRC55~60	
	Speed n (R/min)	Feed Vf (mm/min)	Speed n (R/min)	Feed Vf (mm/min)
1.0	15600	750	13360	535
1.5	10400	540	8900	355
2.0	7800	435	6680	320
2.5	6240	375	5345	260
3.0	5200	330	4450	250
3.5	4460	300	3810	230
4.0	3900	310	3340	200
5.0	3120	310	2670	215
6.0	2600	260	2230	175
8.0	1950	270	1670	165
10.0	1560	280	1335	185
12.0	1300	290	1120	180
16.0	975	255	835	165
18.0	870	260	745	180
20.0	780	235	670	160

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

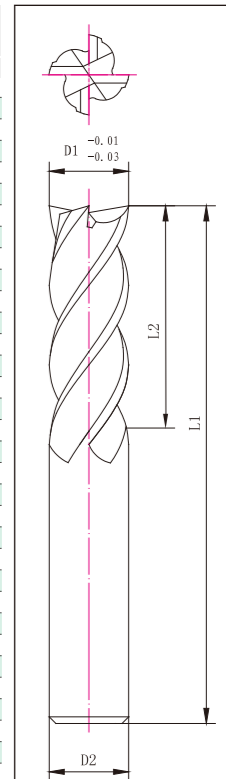


- ◎ Please use rigid and precision equipments and chucks
- ◎ Be in climb milling. Please lower the recommendations simultaneously in case cutting tools shake badly
- ◎ Please use suitable coolants

Work Materials/被加工材质

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

◎ Preferential ○ Suitable

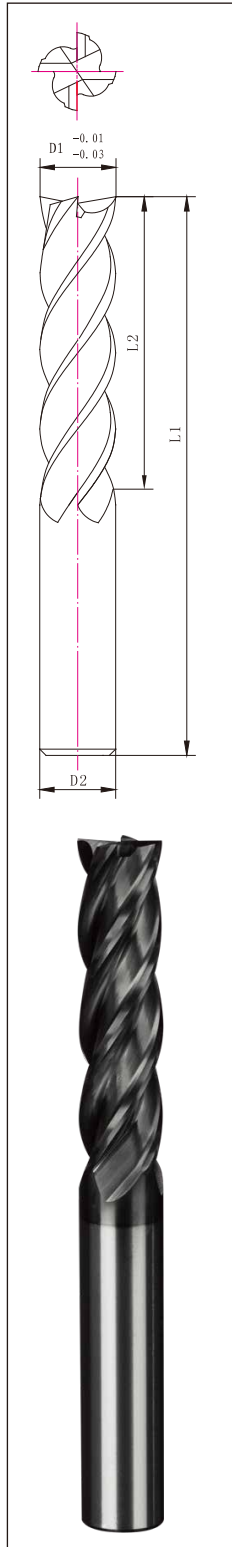


Carbide End Mills

Four Flute Long Length 四齿加长型



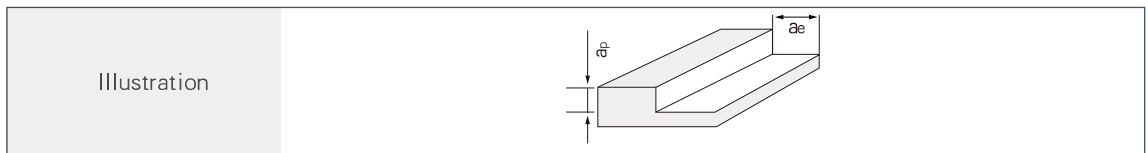
Type & Specifications/类型与规格



D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
2.5	4	10	60	4	P1182604020
3.0	4	12	60	4	P1182605020
3.5	4	15	60	4	P1182606020
4.0	4	15	60	4	P1182607020
4.5	6	25	75	4	P1182608020
5.0	6	25	75	4	P1182609020
6.0	6	25	75	4	P1182610020
7.0	8	30	75	4	P1182611020
8.0	8	30	75	4	P1182612020
9.0	10	40	100	4	P1182613020
10.0	10	40	100	4	P1182614020
11.0	12	45	100	4	P1182615020
12.0	12	45	100	4	P1182616020
13.0	14	45	100	4	P1182617020
14.0	14	45	100	4	P1182618020
15.0	16	60	150	4	P1182619020
16.0	16	60	150	4	P1182620020
18.0	18	60	150	4	P1182621020
20.0	20	60	150	4	P1182622020
25.0	25	70	150	4	P1182623020

Recommendation/推荐切削条件

Diameter D1 (mm)	Hardened Steel HRC45~55		Hardened Steel HRC55~60	
	Speed n (R/min)	Feed Vf (mm/min)	Speed n (R/min)	Feed Vf (mm/min)
4.0	2925	280	2505	180
5.0	2340	280	2000	195
6.0	1950	235	1675	160
8.0	1465	245	1250	155
10.0	1170	238	1000	155
12.0	975	245	840	150
16.0	730	215	625	140
20.0	585	200	500	136
ap (Depth)	ap=1.5D		ap=1.0D	
ae (Width)	ae=0.05D		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								

Four Flute Standard

四齿标准型



Type & Specifications/类型与规格



D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
1	3	3	38	4	1180560020
1.5	3	5	38	4	1180560520
2.0	3	6	38	4	1180561020
2.5	3	7	38	4	1180561520
3.0	3	7	38	4	1180562020
3.5	4	10	50	4	1180562520
4.0	4	10	50	4	1180563020
4.5	5	11	50	4	1180563520
5.0	5	11	50	4	1180564020
5.5	6	13	57	4	1180564520
6.0	6	13	57	4	1180565020
7.0	8	16	63	4	1180565520
8.0	8	19	63	4	1180566020
9.0	10	19	72	4	1180566520
10.0	10	22	72	4	1180567020
12.0	12	26	83	4	1180567520
14.0	14	26	83	4	1180568020
16.0	16	32	92	4	1180568520
18.0	18	32	92	4	1180569020
20.0	20	38	104	4	1180569520
25.0	25	38	104	4	1180570020

Four Flute Long Length

四齿加长型



Type & Specifications/类型与规格

D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
3.0	3	15	57	4	1182631120
3.5	4	19	57	4	1182631620
4.0	4	19	57	4	1182632120
4.5	5	25	63	4	1182632620
5.0	5	25	63	4	1182633120
5.5	6	25	75	4	1182633620
6.0	6	25	75	4	1182634120
8.0	8	30	75	4	1182634620
10.0	10	35	90	4	1182635120
12.0	12	45	100	4	1182635620
14.0	14	45	100	4	1182636120
16.0	16	50	100	4	1182636620
18.0	18	50	100	4	1182637120
20.0	20	60	120	4	1182637620
25.0	25	60	120	4	1182638120

