

Two Flute Standard 二齿标准型

SF

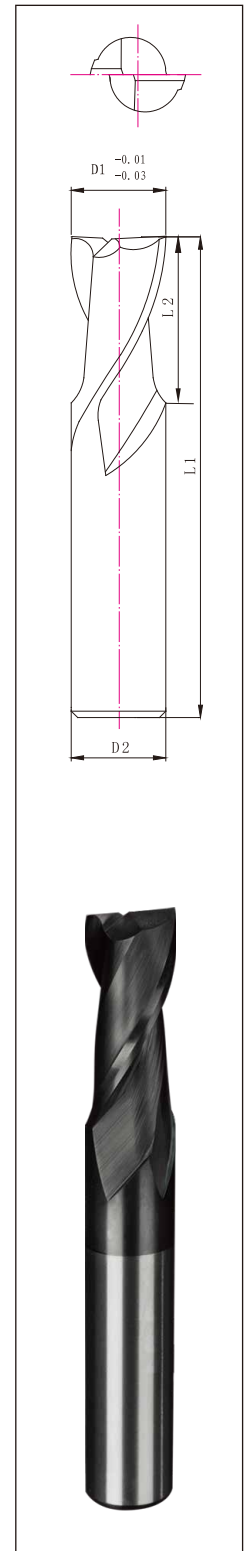
TYPE
N

HRC
60

RUN
OUT
<0.02

Type & Specifications/类型与规格

D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
1.0	4	3	50	2	P1180101020
1.5	4	4	50	2	P1180102020
2.0	4	6	50	2	P1180103020
2.5	4	8	50	2	P1180104020
3.0	4	8	50	2	P1180105020
3.5	4	10	50	2	P1180106020
4.0	4	10	50	2	P1180107020
1.0	6	4	50	2	P1180108020
1.5	6	6	50	2	P1180109020
2.0	6	6	50	2	P1180110020
2.5	6	8	50	2	P1180111020
3.0	6	8	50	2	P1180112020
3.5	6	10	50	2	P1180113020
4.0	6	12	50	2	P1180114020
4.5	6	12	50	2	P1180115020
5.0	6	13	50	2	P1180116020
5.5	6	13	50	2	P1180117020
6.0	6	13	50	2	P1180118020
6.5	8	20	60	2	P1180119020
7.0	8	20	60	2	P1180120020
7.5	8	20	60	2	P1180121020
8.0	8	20	60	2	P1180122020
8.5	10	25	75	2	P1180123020
9.0	10	25	75	2	P1180124020
9.5	10	25	75	2	P1180125020
10.0	10	25	75	2	P1180126020
11.0	12	25	75	2	P1180127020
12.0	12	25	75	2	P1180128020
13.0	14	30	90	2	P1180129020
14.0	14	30	90	2	P1180130020
15.0	16	35	100	2	P1180131020
16.0	16	35	100	2	P1180132020
17.0	18	40	100	2	P1180133020
18.0	18	40	100	2	P1180134020
19.0	20	40	100	2	P1180135020
20.0	20	40	100	2	P1180136020
22.0	22	40	100	2	P1180137020
25.0	25	40	100	2	P1180138020



Carbide End Mills

Work Materials/被加工材质

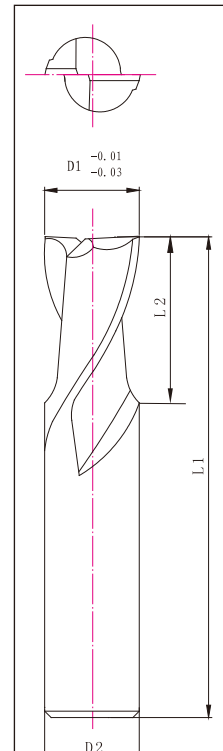
Steels			Cast Iron	Aluminium Alloys	Copper Alloys	Stainless Steel	Titanium Alloys	Graphite
<HRC45	<HRC60	<HRC65						
○	◎		○			○		
◎ Preferential ○ Suitable								

Two Flute Standard 二齿标准型



Recommendation/推荐切削条件

Diameter	Hardened Steel HRC45~55				Hardened Steel HRC55~60			
	Slotting		Side Milling		Slotting		Side Milling	
D1 (mm)	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)
2.0	5570	110	10025	200	4775	95	8595	170
3.0	3715	110	6690	200	3180	65	5730	115
4.0	1950	78	3510	140	1670	50	3000	95
5.0	1560	78	2810	140	1335	53	2400	95
6.0	1300	65	2340	120	1115	45	2000	80
8.0	975	68	1755	120	835	42	1500	75
10.0	780	70	1400	125	665	47	1200	85
12.0	650	72	1170	130	560	45	1000	80
16.0	490	64	880	115	415	42	750	75
20.0	390	59	700	105	335	20	600	70
ap (Depth)	ap=0.3D		ap=1.5D		ap=0.2D		ap=1.0D	
ae (Width)	ae=1.0D		ae=0.05D		ae=1.0D		ae=0.05D	



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								

Two Flute Long Length 二齿加长型



Type & Specifications/类型与规格

D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
1	4	6	60	2	P1182201020
1.5	4	8	60	2	P1182202020
2.0	4	8	60	2	P1182203020
2.5	4	10	60	2	P1182204020
3.0	4	12	60	2	P1182205020
3.5	4	15	60	2	P1182206020
4.0	4	15	60	2	P1182207020
4.5	6	25	75	2	P1182208020
5.0	6	25	75	2	P1182209020
6.0	6	25	75	2	P1182210020
7.0	8	30	75	2	P1182211020
8.0	8	30	75	2	P1182212020
9.0	10	40	100	2	P1182213020
10.0	10	40	100	2	P1182214020
11.0	12	45	100	2	P1182215020
12.0	12	45	100	2	P1182216020
13.0	14	45	100	2	P1182217020
14.0	14	45	100	2	P1182218020
15.0	16	60	150	2	P1182219020
16.0	16	60	150	2	P1182220020
18.0	18	60	150	2	P1182221020
20.0	20	60	150	2	P1182222020
25.0	25	65	150	2	P1182223020

Recommendation/推荐切削条件

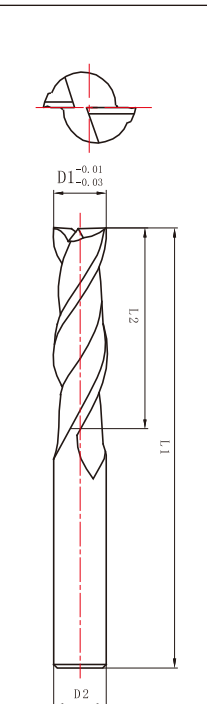
Diameter	Hardened Steel HRC45~55				Hardened Steel HRC55~60			
	Slotting		Side Milling		Slotting		Side Milling	
D1 (mm)	Speed n (R/min)	Feed Vf (mm/min)	Speed n (R/min)	Feed Vf (mm/min)	Speed n (R/min)	Feed Vf (mm/min)	Speed n (R/min)	Feed Vf (mm/min)
4.0	1460	58	2630	125	1250	38	2255	80
6.0	975	49	1755	105	840	42	1500	70
8.0	730	51	1320	110	625	31	1125	70
10.0	585	53	1050	110	500	35	900	70
12.0	490	54	890	110	420	34	755	70
16.0	365	47	655	95	310	31	560	65
18.0	325	46	585	85	280	35	500	60
20.0	290	44	530	90	250	30	450	60
ap (Depth)	ap=0.3D		ap=1.5D		ap=0.2D		ap=1.0D	
ae (Width)	ae=1.0D		ae=0.05D		ae=1.0D		ae=0.05D	

Illustration

- Please optimize the over-hang
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Work Materials/被加工材质

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

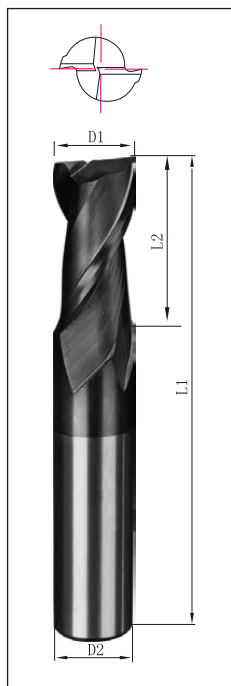


Two Flute Standard

二齿标准型



Type & Specifications/类型与规格



D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
1	3	3	38	2	11801660020
1.5	3	5	38	2	11801660520
2.0	3	6	38	2	11801661020
2.5	3	7	38	2	11801661520
3.0	3	7	38	2	11801662020
3.5	4	10	50	2	11801662520
4.0	4	10	50	2	11801663020
4.5	5	11	50	2	11801663520
5.0	5	11	50	2	11801664020
5.5	6	13	57	2	11801664520
6.0	6	13	57	2	11801665020
7.0	8	16	63	2	11801665520
8.0	8	19	63	2	11801666020
9.0	10	19	72	2	11801666520
10.0	10	22	72	2	11801667020
12.0	12	26	83	2	11801667520
14.0	14	26	83	2	11801668020
16.0	16	32	92	2	11801668520
18.0	18	32	92	2	11801669020
20.0	20	38	104	2	11801669520
25.0	25	38	104	2	11801670020

Two Flute Long Length 二齿加长型



Type & Specifications / 类型与规格

D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
3.0	3	15	57	2	1182241120
3.5	4	19	57	2	1182241620
4.0	4	19	57	2	1182242120
4.5	5	25	63	2	1182242620
5.0	5	25	63	2	1182243120
5.5	6	25	75	2	1182243620
6.0	6	25	75	2	1182244120
8.0	8	30	75	2	1182244620
10.0	10	35	90	2	1182245120
12.0	12	45	100	2	1182245620
14.0	14	45	100	2	1182246120
16.0	16	50	100	2	1182246620
18.0	18	50	100	2	1182247120
20.0	20	60	120	2	1182247620
25.0	25	60	120	2	1182248120



Carbide End Mills