

200NaNo Series



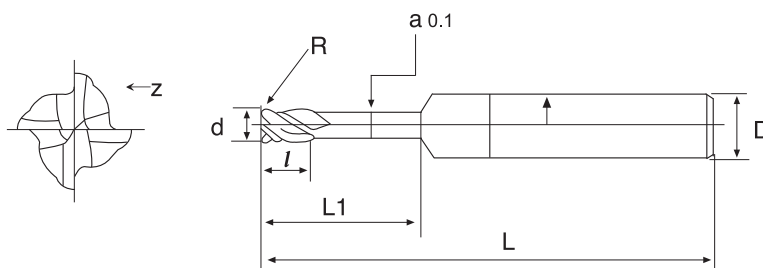
Corner Radius Medium Flute & Long Neck End Mill - 4 flutes

Super Ultra Fine Micro Grain Carbide

WC = 91 Co = 9 HRA = 93.2 Rupture = 4000N/mm² Grain Size = 0.2μm

Application Iron, Carbon steel, Cast Iron, Alloy Steel, Tool Steel, Heat treatment Steel, Welding Steel

Main Character Super Ultra Fine Micro Grain Carbide that has high toughness, coating ALTIN (TiAIN) and wear-resisting, non-general titanium aluminium is specialized in milling on M/C high hardness at a high speed and can carry on rough machining get to detailed process directly for heat treatment mould to reduce change times, improve machine flexible rate and shorten producing time.



MODE	Diameter d	Flute Length l	Full Length L	Shank Diameter D	Efficient Length L1	Corner Radius R	Packing Quantity	Price
SFUCRM060024-HSC	6	9	75	6	18	0.2R	2	
SFUCRM060034-HSC	6	9	75	6	18	0.3R	2	
SFUCRM060054-HSC	6	9	75	6	18	0.5R	2	
SFUCRM060104-HSC	6	9	75	6	18	1.0R	2	
SFUCRM060204-HSC	6	9	75	6	18	2.0R	2	
SFUCRM080034-HSC	8	12	100	8	20	0.3R	2	
SFUCRM080054-HSC	8	12	100	8	20	0.5R	2	
SFUCRM080104-HSC	8	12	100	8	20	1.0R	2	
SFUCRM080204-HSC	8	12	100	8	20	2.0R	2	
SFUCRM100054-HSC	10	15	100	10	25	0.5R	2	
SFUCRM100104-HSC	10	15	100	10	25	1.0R	2	
SFUCRM100154-HSC	10	15	100	10	25	1.5R	2	
SFUCRM100204-HSC	10	15	100	10	25	2.0R	2	
SFUCRM100304-HSC	10	15	100	10	25	3.0R	2	
SFUCRM120054-HSC	12	18	100	12	30	0.5R	2	
SFUCRM120104-HSC	12	18	100	12	30	1.0R	2	
SFUCRM120154-HSC	12	18	100	12	30	1.5R	2	
SFUCRM120204-HSC	12	18	100	12	30	2.0R	2	
SFUCRM120304-HSC	12	18	100	12	30	3.0R	2	

SFUCRM 4 Flute 切削條件



Attention : In order to get better cutting surface and lengthen the life-time of the end mill, please use high accuracy, high rigidity and dynamic equilibrium of holder.

1. Before using the end mill, please examine the end mill to lean towards and put, when the precision of the leaning towards of end mill exceeds 0.01mm, please cut after correcting.
2. It is better that end mill stretches out shorter from chuck, when the end mill stretches out longer, please adjust the rotational speed, feeding speed or cutting amount.
3. Unusual vibrations or sound happen when cutting, please adjust and lower the rotational speed of the main shaft one by one, feeding speed and cutting amount until improving the situation, or change the high-quality end mill.
4. It is the best way to cool steel material by spraying or air in order to make TiAlN efficiently; we commend to adopt non-water cutting liquid to cool the stainless steel, titanium alloy or heat-resisting alloy liquid.
5. Cutting will be influenced by work piece, machine and software; the above-mentioned data are only for reference, please improve feeding speed by 30%~50% up after cutting situation steadily.

SFUCRM 4 Flutes Recommended Milling conditions

Working material hardness	HRC30°		HRC40°		HRC50°		HRC55°		HRC60°	
	Rotational speed	Feeding speed	Rotational speed	Feeding speed	Rotational speed	Feeding speed	Rotational speed	Feeding speed	Rotational speed	Feeding speed
	RPM	mm/min.	RPM	mm/min.	RPM	mm/min.	RPM	mm/min.	RPM	mm/min.
D3.0 x 0.1R	6006	831	5082	693	4527	554	3788	485	3465	231
D3.0 x 0.2R	6006	831	5802	693	4527	554	3788	485	3465	231
D3.0 x 0.3R	6006	831	5082	693	4527	554	3788	485	3465	231
D4.0 x 0.3R	5775	924	4851	831	4296	485	3626	392	3141	231
D4.0 x 0.3R	5775	924	4851	831	4296	485	3626	392	3141	231
D2.0 x 0.5R	7392	554	6699	508	6006	415	5082	346	4250	277
D3.0 x 0.5R	6006	924	5082	831	4527	693	3788	508	3465	231
D4.0 x 0.5R	5775	924	4581	831	4296	485	3626	392	3141	231
D6.0 x 0.5R	5313	1386	4620	1201	4065	924	3326	693	2125	346
D8.0 x 0.5R	3996	1570	3672	1247	2471	785	2148	554	1778	378
D10.0 x 0.5R	2541	1293	1940	877	1478	508	1247	438	762	268
D12.0 x 0.5R	2148	1339	1593	785	1016	438	831	369	600	245
D3.0 x 1R	6906	1062	5844	955	5206	797	4357	584	3985	266
D4.0 x 1R	6641	1062	5579	957	4941	557	4171	452	3612	266
D6.0 x 1R	6110	1593	5313	1381	4675	1062	3825	797	2444	398
D8.0 x 1R	4595	1806	4224	1434	2842	903	2470	638	2046	398
D10.0 x 1R	2922	1478	2231	1009	1700	584	1431	504	876	308
D12.0 x 1R	2470	1541	1833	903	1169	658	955	424	690	281
D6.0 x 1.5R	6375	1663	5544	1441	4878	1108	3991	831	2549	415
D8.0 x 1.5R	4796	1885	4407	1497	2965	942	2578	665	2134	454
D10.0 x 1.5R	3049	1552	2328	1053	1774	609	1479	526	915	321
D12.0 x 1.5R	2578	1608	1912	942	1219	526	997	443	720	293
D6.0 x 2R	6900	1801	6006	1502	5285	1201	4324	900	2763	451
D8.0 x 2R	5195	2041	4775	1621	3213	1020	2792	2312	2312	492
D10.0 x 2R	3303	1681	2522	1140	1921	661	1621	991	991	384
D12.0 x 2R	2792	1741	2072	1020	1321	570	1081	781	781	317
D8.0 x 3R	5395	2120	4958	1684	3337	1060	2900	748	2402	511
D10.0 x 3R	3430	1746	2619	1184	1995	686	1684	592	1029	361
D12.0 x 3R	2900	1808	2151	1060	1371	592	1123	499	810	331