



URTA Corner Radius Cutter-2 flutes

Ultra Fine Micro Grain Carbide

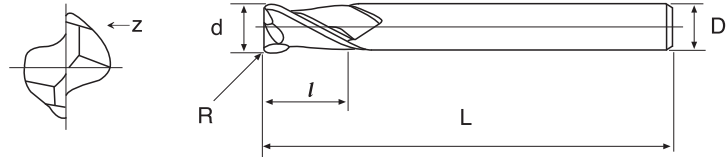
WC = 87 Co = 12 HRA = 92.1 Rupture = 3800N/mm² Grain size = 0.4μm

Application

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

Main Character

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	Corner Radius R	Packing Quantity	Price
URTA010022-HSC	1	2	50	4	0.2R	6	
URTA010032-HSC	1	2	50	4	0.3R	6	
URTA015022-HSC	1.5	3	50	4	0.2R	6	
URTA015032-HSC	1.5	3	50	4	0.3R	6	
URTA020022-HSC	2	5	50	4	0.2R	6	
URTA020032-HSC	2	5	50	4	0.3R	6	
URTA020052-HSC	2	5	50	4	0.5R	6	
URTA030022-HSC	3	8	50	4	0.2R	6	
URTA030032-HSC	3	8	50	4	0.3R	6	
URTA030052-HSC	3	8	50	4	0.5R	6	
URTA040022-HSC	4	10	50	4	0.2R	6	
URTA040032-HSC	4	10	50	4	0.3R	6	
URTA040052-HSC	4	10	50	4	0.5R	6	
URTA040102-HSC	4	10	50	4	1.0R	6	
URTA050032-HSC	5	13	50	6	0.3R	6	
URTA050052-HSC	5	13	50	6	0.5R	6	
URTA050102-HSC	5	13	50	6	1.0R	6	
URTA060022-HSC	6	16	75	6	0.2R	2	
URTA060032-HSC	6	16	75	6	0.3R	2	
URTA060052-HSC	6	16	75	6	0.5R	2	
URTA060102-HSC	6	16	75	6	1.0R	2	
URTA060202-HSC	6	16	75	6	2.0R	2	
URTA080032-HSC	8	20	75	8	0.3R	2	
URTA080052-HSC	8	20	75	8	0.5R	2	
URTA080102-HSC	8	20	75	8	1.0R	2	
URTA080202-HSC	8	20	75	8	2.0R	2	
URTA100052-HSC	10	25	75	10	0.5R	2	
URTA100102-HSC	10	25	75	10	1.0R	2	
URTA100152-HSC	10	25	75	10	1.5R	2	
URTA100202-HSC	10	25	75	10	2.0R	2	
URTA100302-HSC	10	25	75	10	3.0R	2	
URTA120052-HSC	12	30	75	12	0.5R	2	
URTA120102-HSC	12	30	75	12	1.0R	2	
URTA120152-HSC	12	30	75	12	1.5R	2	
URTA120202-HSC	12	30	75	12	2.0R	2	
URTA120302-HSC	12	30	75	12	3.0R	2	

400 nano series



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.

URTA Recommended Milling conditions

Working material hardness Corner Radius	HRC30°		HRC50°		HRC60°	
	Rotational speed	Feeding speed	Rotational speed	Feeding speed	Rotational speed	Feeding speed
	RPM	mm/min.	RPM	mm/min.	RPM	mm/min.
D1.0 x 0.1R	11088	549	8120	364	5488	252
D1.0 x 0.2R	11088	549	8120	364	5488	252
D1.0 x 0.3R	11088	549	8120	364	5488	252
D1.5 x 0.2R	9800	672	7728	392	4760	280
D1.5 x 0.3R	9800	672	7728	392	4760	280
D2.0 x 0.1R	8960	840	7056	504	4032	280
D2.0 x 0.2R	8960	840	7056	504	4032	280
D2.0 x 0.3R	8960	840	7056	504	4032	280
D3.0 x 0.1R	6370	882	4082	588	3675	245
D3.0 x 0.2R	6370	882	4802	588	3675	245
D3.0 x 0.3R	6370	882	4802	588	3675	245
D4.0 x 0.2R	6125	980	4557	515	3332	245
D4.0 x 0.3R	6125	980	4557	515	3332	245
D2.0 x 0.5R	7840	588	6370	441	4508	294
D3.0 x 0.5R	6370	980	4802	735	3675	245
D4.0 x 0.5R	6125	980	4557	515	3332	245
D6.0 x 0.5R	5635	1470	4312	980	2254	368
D8.0 x 0.5R	4239	1666	2622	833	1887	402
D10.0 x 0.5R	2695	1372	1568	539	809	284
D12.0 x 0.5R	2279	1421	1078	466	637	260
D3.0 x 1R	7326	1127	5522	845	4226	282
D4.0 x 1R	7044	1127	5241	592	3832	282
D6.0 x 1R	6480	1691	4959	1127	2592	423
D8.0 x 1R	4875	1916	3015	958	2170	462
D10.0 x 1R	3099	1568	1803	620	930	327
D12.0 x 1R	2621	1634	1240	698	733	299
D6.0 x 1.5R	6762	1764	5174	1176	2705	441
D8.0 x 1.5R	5086	1999	3146	1000	2264	482
D10.0 x 1.5R	3234	1646	1882	647	970	341
D12.0 x 1.5R	2734	1705	1294	559	764	312
D6.0 x 2R	7326	1911	5606	1274	2930	478
D8.0 x 2R	5510	2166	3408	1083	2452	522
D10.0 x 2R	3504	1784	2038	701	1051	369
D12.0 x 2R	2962	1847	1401	605	828	338
D8.0 x 3R	5722	2249	3539	1125	2548	542
D10.0 x 3R	3638	1852	2117	728	1092	384
D12.0 x 3R	3076	1918	1455	629	860	351