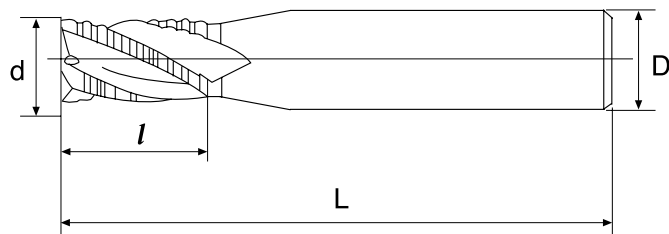


RS

For Multiple Materials

FINE PITCH ROUGHING CUTTER

WC=88 Co=12 HRA = 92.4 Rupture=3950N/mm² Grain Size=0.5μm

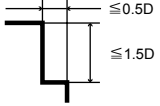
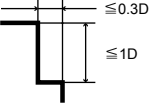


● SUNTA 4 Flutes - RS ●

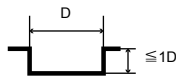
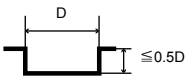


MODE	Diameter d	Flute Length l	Shank Diameter D	Flute Quantity Z	Full Length L
SUNTA 0504	5	13	6	4	50
SUNTA 0604	6	16	6	4	50
SUNTA 0704	7	16	8	4	60
SUNTA 0804	8	19	8	4	60
SUNTA 0904	9	25	10	4	75
SUNTA 1004	10	25	10	4	75
SUNTA 1104	11	30	12	4	75
SUNTA 1204	12	30	12	4	75
SUNTA 1404	14	35	16	4	100
SUNTA 1504	15	35	16	4	100
SUNTA 1604	16	35	16	4	100
SUNTA 2004	20	45	20	4	100

SUNTA ■ Side Milling

Work Material	Structure Steels, Carbon Steels (~30HRC) SS400, AISI 1050, SCM, FC250 etc		Alloy Steels, Tool Steels, Prehardened Steels (30~35HRC) AISI H13, AISI D2 etc		Austenitic stainless Steels AISI 304, AISI 316 etc		Chilled Steels (45~50HRC) SKD61 etc		Heat-resisting alloy Inconel etc	
(mm)	Speed (min ⁻¹)	Feed Rate (mm/min)	Speed (min ⁻¹)	Feed Rate (mm/min)	Speed (min ⁻¹)	Feed Rate (mm/min)	Speed (min ⁻¹)	Feed Rate (mm/min)	Speed (min ⁻¹)	Feed Rate (mm/min)
5	7,600	740	4,500	380	3,800	260	3,200	100	2,500	70
6	6,400	750	3,700	390	3,200	290	2,700	110	2,100	75
8	4,800	780	2,800	420	2,400	340	2,000	140	1,600	95
10	3,800	790	2,200	420	1,900	340	1,600	150	1,300	105
12	3,200	790	1,900	420	1,600	320	1,300	150	1,100	110
16	2,400	770	1,400	390	1,200	300	1,000	150	800	110
20	1,900	760	1,100	370	1,000	300	800	140	600	100
Depth of cut										

SUNTA ■ Slotting

Work Material	Structure Steels, Carbon Steels (~30HRC) SS400, AISI 1050, SCM, FC250 etc		Alloy Steels, Tool Steels, Prehardened Steels (30~35HRC) AISI H13, AISI D2 etc		Austenitic stainless Steels AISI 304, AISI 316 etc		Chilled Steels (45~50HRC) SKD61 etc		Heat-resisting alloy Inconel etc	
(mm)	Speed (min ⁻¹)	Feed Rate (mm/min)	Speed (min ⁻¹)	Feed Rate (mm/min)	Speed (min ⁻¹)	Feed Rate (mm/min)	Speed (min ⁻¹)	Feed Rate (mm/min)	Speed (min ⁻¹)	Feed Rate (mm/min)
5	6,400	570	3,800	280	3,200	190	1,900	50	1,300	25
6	5,300	580	3,200	290	2,700	200	1,600	55	1,100	30
8	4,000	600	2,400	320	2,000	220	1,200	70	800	35
10	3,200	600	1,900	310	1,600	220	1,000	70	600	35
12	2,700	600	1,600	310	1,300	210	800	75	500	40
16	2,000	570	1,200	320	1,000	180	600	75	400	45
20	1,600	540	1,000	270	800	160	500	70	300	40
Depth of cut										

1. In cutting Austenitic stainless steels, the use of non-water-soluble cutting fluid is especially effective; in cutting heat-resisting alloy, it is more effective to use water-soluble cutting fluid.
2. It can improve the speed and feed to cut non-deep depth.
3. If the installation rigidity of machine tool or working material is very low, or shaking and noise happen, please in accordance with reducing the and feeding proportionally, or reduce the depth of cutting.
4. Suggest to right o'clock cutting when side working.