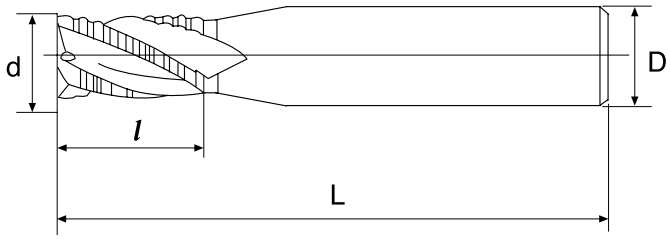
RS For Multiple Materials

ROUGHING CUTTER

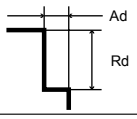
WC=88 Co=12 HRA = 92.4 Rupture=3950N/mm² Grain Size=0.5μm



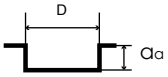
● SUXTA 4 Flutes - RS ●

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

SUXTA ■ Side Milling

Work Material	Cast iron FC FCD		Mild Steels, Carbon Steels SS400 SS55C(~750N/mm)		Alloy Steels, Tool Steels SCM SKT SKS SKD (~30HRC)		Hardened Steels (30~38HRC) Prehardened Steels (Free-cutting) SKT SKD NAK55 HPM1		Hardened Steels (38~45HRC) Stainless Steels SUS304 SKD	
Cutting Speed	100~140m/min		80~120m/min		70~100m/min		50~80m/min		35~65m/min	
(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)
6	6,350	760	5,300	640	4,500	360	3,450	280	2,650	210
8	4,750	760	4,000	640	3,400	410	2,600	310	2,000	240
10	3,800	760	3,200	640	2,700	430	2,050	330	1,600	260
12	3,200	770	2,650	640	2,250	450	1,700	340	1,350	270
14	2750	770	2,250	650	1,950	470	1,500	360	1,150	280
16	2,400	770	2,000	640	1,700	480	1,300	360	1,000	280
18	2,100	760	1,750	630	1,500	480	1,150	350	900	270
20	1,900	760	1,600	610	1,350	470	1,050	350	800	260
Depth of cut	Ad: 1.5D, Rd: 0.4D 						Ad: 1.5D, Rd: 0.3D			

SUXTA ■ Slotting

Work Material	Cast Iron FC FCD		Mild Steels, Carbon Steels SS400 SS55C(~750N/mm)		Alloy Steels, Tool Steels SCM SKT SKS SKD (~30HRC)		Hardened Steels (30~38HRC) Prehardened Steels (Free-cutting) SKT SKD NAK55 HPM1		Hardened Steels (38~45HRC) Stainless Steels SUS304 SKD	
Cutting Speed	80~120m/min		70~100m/min		55~85m/min		40~70m/min		30~60m/min	
(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)
6	5,300	640	4,500	540	3,700	300	2,900	230	2,400	190
8	4,000	640	3,400	540	2,800	340	2,200	260	1,800	220
10	3,200	640	2,700	540	2,250	360	1,750	280	1,450	230
12	2,650	640	2,250	540	1,850	370	1,450	290	1,200	240
14	2,250	630	1,950	570	1,600	380	1,250	300	1,000	240
16	2,000	640	1,700	540	1,400	390	1,100	310	900	250
18	1,750	630	1,500	540	1,250	400	950	290	800	240
20	1,600	640	1,350	510	1,100	390	900	300	700	230
Depth of cut	Ad 0.75D Ad Max=12mm 						Ad 0.5D			

1.Use air blow. When using cutting fluids. Use high-guality fluid with high smoke retardant properties.
2.When chattering occurs. Reduce the speed and feed simultaneously.
3.Use a rigid and precision machine and holder.