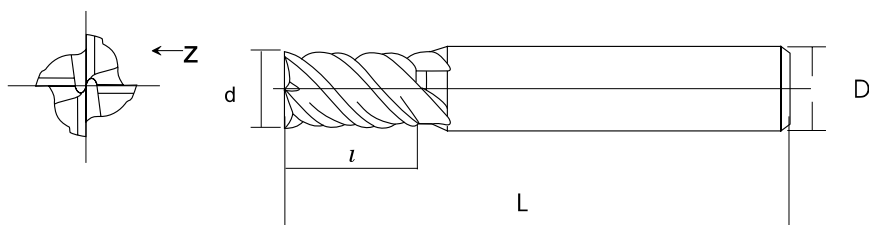


RS

For Multiple Materials

SQUARE TYPE - 4 flutes

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

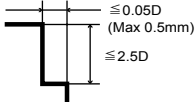
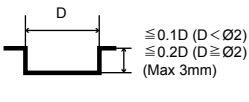
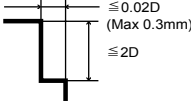
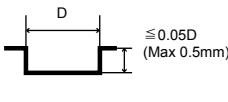


● SULPE 4 Flutes - RS ●



MODE	Diameter d	Flute Length l	Shank Diameter D	Flute Quantity Z	Full Length L
SULPE0104	1	4	6	4	60
SULPE0154	1.5	6	6	4	60
SULPE0204	2	8	6	4	60
SULPE0254	2.5	10	6	4	60
SULPE0304	3	12	6	4	60
SULPE0404	4	16	6	4	60
SULPE0504	5	21	6	4	60
SULPE0604	6	26	6	4	75
SULPE0804	8	31	8	4	75
SULPE1004	10	35	10	4	100
SULPE1204	12	40	12	4	100
SULPE1604	16	61	16	4	150
SULPE2004	20	76	20	4	150

SULPE ■ Standard Cutting Conditions

Work Material	Carbon Steels, Alloy Steels (~30HRC) S50C, SCM, FC250 etc AISI 1049, Cast iron			Alloy Steels, Tool Steels (30~45HRC) Prehardened Steels, SKD61, NAK etc AISI H13			Austenitic stainless Steels SUS304, SUS316 etc AISI 304, AISI 316			Hardened Steels (45~50HRC) SKD61, SKD11, NAK, STAVAX etc AISI H13		
Cutting Speed	35~50m/min			30~40m/min			20~30m/min			15~25m/min		
Diameter (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)	
		Side Milling	Slotting		Side Milling	Slotting		Side Milling	Slotting		Side Milling	Slotting
1	11,000	85	40	9,500	65	30	8,000	50		6,400	35	17
							6,400		20			
1.5	7,400	85	40	6,400	90	45	5,300	50		4,200	35	17
							4,240		20			
2	5,600	85	40	4,800	90	45	4,000	50		3,200	35	17
							3,200		20			
2.5	4,500	85	40	3,800	90	45	3,200	55		2,500	35	17
							2,560		22			
3	4,200	100	50	3,400	90	45	2,600	60		2,100	35	17
							2,080		24			
4	3,400	125	60	2,700	90	45	2,100	70		1,700	50	25
							1,680		28			
5	2,900	155	75	2,300	110	55	1,800	85		1,500	55	27
							1,440		34			
6	2,500	180	90	2,000	140	70	1,500	110		1,300	70	35
							1,200		44			
8	1,900	200	100	1,500	140	70	1,200	110		1,000	70	35
							960		44			
10	1,600	205	100	1,300	140	70	950	110		800	70	35
							760		44			
12	1,300	180	90	1,100	140	70	800	110		670	70	35
							640		44			
16	1,000	120	60	820	100	50	600	80		500	50	25
							480		32			
20	800	95	45	650	75	35	480	70		400	40	20
							384		28			
25	650	75	35	520	60	30	380	50		320	35	17
							280		20			
Depth of cut (D: Dia)	 						 					

1. In cutting Austenitic stainless steels, the use of non-water-soluble cutting fluid is especially effective.
2. If the rigidity of the machine or the work material installation is very low, or chattering is generated, please reduce the revolution and the feed rate proportionately.
3. When drilling, please set the feed rate at 1/3 or below of the above value.