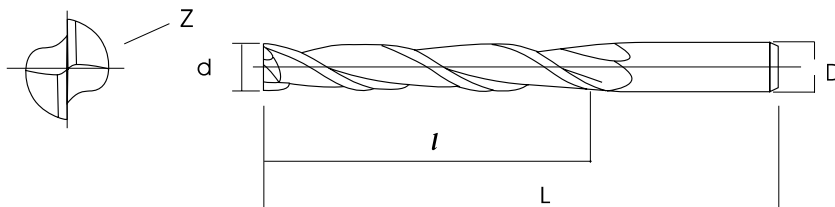


RS

For Multiple Materials

SQUARE TYPE LONG FLUTE - 2 flutes

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



● SULET 2 Flutes - RS ●



MODE	Diameter d	Flute Length l	Shank Diameter D	Flute Quantity Z	Full Length L
SULET 0102	1	7	4	2	50
SULET 0152	1.5	9	4	2	50
SULET 0202	2	12	4	2	50
SULET 0252	2.5	12	4	2	50
SULET 0302	3	15	6	2	60
SULET 0352	3.5	15	6	2	60
SULET 0402	4	20	6	2	75
SULET 0452	4.5	20	6	2	75
SULET 0502	5	25	6	2	75
SULET 0552	5.5	25	6	2	75
SULET 0602	6	30	6	2	75
SULET 0702	7	30	8	2	100
SULET 0802	8	40	8	2	100
SULET 0902	9	40	10	2	100
SULET 1002	10	40	10	2	100
SULET 1102	11	40	12	2	100
SULET 1202	12	50	12	2	100
SULET 1402	14	50	16	2	150
SULET 1602	16	60	16	2	150
SULET 2002	20	90	20	2	200

SULET 2 Flutes ■ Standard Cutting Conditions

Work Material	Carbon Steels, Alloy Steels (~30HRC) S50C, SCM, Cast Iron 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	30~50m/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	13,000	60	60	9,500	45	45	8,000	35	35	6,400	25	25
1.5	8,500	60	60	6,400	45	45	5,300	35	35	4,200	25	25
2	6,400	60	60	4,800	45	45	4,000	35	35	3,200	25	25
2.5	5,100	60	60	3,800	45	45	3,200	40	40	2,500	25	25
3	4,200	65	60	3,400	55	45	2,600	40	40	2,100	25	25
4	3,400	80	60	2,700	65	45	2,100	50		1,700	35	25
							1,600		30			
5	2,900	100	60	2,300	80	45	1,800	60		1,500	40	25
							1,350		30			
6	2,500	120	60	2,000	100	50	1,500	75		1,300	50	25
							1,100		30			
8	1,900	130	60	1,500	100	50	1,200	80		1,000	50	25
							900		30			
10	1,600	130	60	1,300	100	50	950	75		800	50	25
							710		30			
12	1,300	120	60	1,100	100	50	800	75		670	50	25
							600		30			
16	1,000	80	40	820	65	30	600	45		500	30	15
							450		20			

1. Please use Si coating tools for work materials of 50~60HRC.
2. In cutting Austenitic stainless steels, the use of non-water-soluble cutting fluid is especially effective.
3. 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.
4. When drilling, please set the feed rate at 1/3 or below of the above value.