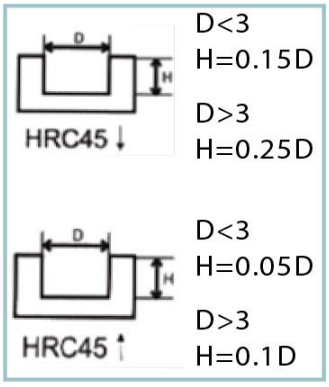
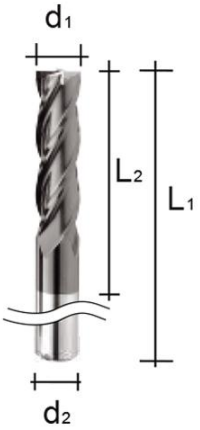
END MILLS SERIES-55103939, 55103940, 55103941, 55103942, 55103943, 55103944, 55103945, 55103946, 55103947 ~ 55103954



DEPTH OF CUT





4 FLUTES SHORT LENGTH LONG SQUARE END MILLS

UNIT: mm

ITEM NO.	TYPE NO.	DIAMETER (D1)	FLUTE LENGTH(L2)	O.A.L (L1)	SHANK DIA(d2)
55103939	JELF 0204	2.0	15	75	4
55103940	JELF 0304	3.0	15	75	6
55103941	JELF 0404	4.0	20	75	6
55103942	JELF 0504	5.0	25	75	6
55103943	JELF 0604	6.0	25	75	6
55103944	JELF 0604A	6.0	30	100	6
55103945	JELF 0804	8.0	25	75	8
55103946	JELF 0804A	8.0	35	100	8
55103947	JELF 1004	10.0	45	100	10
55103948	JELF 1004A	10.0	50	150	10
55103949	JELF 1204	12.0	45	100	12
55103950	JELF 1204A	12.0	50	150	12
55103951	JELF 1404	14.0	60	150	16
55103952	JELF 1604	16.0	60	150	16
55103953	JELF 1804	18.0	60	150	20
55103954	JELF 2004	20.0	60	150	20

RECOMMENED CUTTING CONDITION FOR SUQARE END MILLS

MATERIAL	CARBON STEELS. ALLOY STEELS S45C,FC,FCD,SCM,S50C,SKS...		ALLOY STEELS.TOOL STEELS.SCR, SNCM,SKD11,SKD61,NAK80...		HARDENED STEELS SKD11	
HARDNESS	~HRC30		~HRC50		~HRC60	
DIAMETER (mm)	SPEED (mm-1)	FEED mm/min	SPEED (mm-1)	FEED mm/min	SPEED (mm-1)	FEED mm/min
2	3000	25	1700	20	1000	15
3	2300	35	1900	25	800	10
4	2000	45	1600	35	650	15
5	1800	40	1400	40	600	20
6	1700	60	1300	50	550	25
8	1300	60	1000	50	450	25
10	1000	60	800	50	350	25
12	800	60	700	50	300	25
16	700	50	600	40	250	20
20	500	40	400	30	200	20