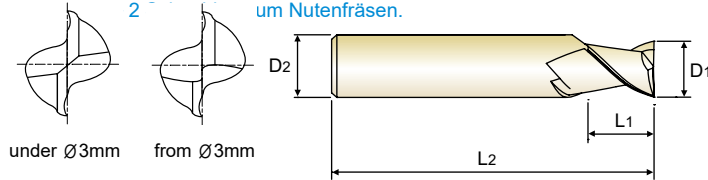


CARBIDE, 2 FLUTE SHORT LENGTH

- VOLLHARTMETALL, 2 SCHNEIDEN KURZ
- FRAISE CARBURE, 2 DENTS, COURTE
- ◌ 2 TAGLIENTI, CORTA

- ▶ Suitable for dry milling applications at high temperatures.
- ▶ Excellent high-performance end mills.
- ▶ 2 flute design for slotting.

- ▶ Für die Trockenbearbeitung.
- ▶ Hervorragendes Preis - Leistungsverhältnis. um Nutenfräsen.



CARBIDE 2 30° DIN 6535HA X Coating

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0 ~ - 0,030	h6

RECOMMENDED CUTTING CONDITIONS
EMPFOLHENE SCHNEIDPARAMETER
SLOTING

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				ALLOY STEELS PRE-HARDEND STEELS				STAINLESS STEELS				CAST IRON			
	HARDNESS	~ HRc30				HRc30 ~ HRc50										
STRENGTH	~ 1000N/mm ²				1000 ~ 1500N/mm ²											
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
1	15450	115	49	0,004	9200	70	29	0,004	7700	55	24	0,004	20200	220	63	0,005
1,5	10100	160	48	0,008	6000	90	28	0,008	6050	85	29	0,007	13050	220	61	0,008
2	8500	170	53	0,010	5550	110	35	0,010	4650	85	29	0,009	10100	240	63	0,012
2,5	7380	180	58	0,012	4710	120	37	0,013	3820	90	30	0,012	7890	235	62	0,015
3	6600	190	62	0,014	4100	130	39	0,016	3400	110	32	0,016	6550	240	62	0,018
3,5	6000	240	66	0,020	3730	150	41	0,020	3090	125	34	0,020	5640	240	62	0,021
4	5550	275	70	0,025	3400	165	43	0,024	2850	140	36	0,025	4950	240	62	0,024
4,5	5090	285	72	0,028	3040	165	43	0,027	2550	140	36	0,028	4390	240	62	0,027
5	4650	290	73	0,031	2750	170	43	0,031	2300	145	36	0,032	3950	240	62	0,030
5,5	4340	305	75	0,035	2600	190	45	0,036	2200	160	38	0,036	3530	260	61	0,037
6	4100	325	77	0,040	2500	205	47	0,041	2100	165	40	0,039	3200	275	60	0,043
6,5	3770	360	77	0,048	2250	205	46	0,045	1910	175	39	0,046	2940	305	60	0,052
8	3100	350	78	0,056	1850	185	46	0,050	1550	165	39	0,053	2400	295	60	0,061
9	2690	325	76	0,060	1630	165	46	0,050	1380	150	39	0,055	2190	305	62	0,069
10	2350	300	74	0,064	1450	145	46	0,050	1250	145	39	0,058	2000	310	63	0,078
12	2000	260	75	0,065	1250	120	47	0,048	1050	120	40	0,057	1550	320	58	0,103
14	1850	230	81	0,062	1150	110	51	0,048	900	110	40	0,061	1400	335	62	0,120
16	1600	200	80	0,063	1000	100	50	0,050	750	100	38	0,067	1200	345	60	0,144
20	1250	155	79	0,062	750	75	47	0,050	600	75	38	0,063	950	365	60	0,192
Ap : 0.5D(UP to φ3 : 0.2D), Ae : D													Ap : D, Ae : D			

* The FEED, in long & extra long types, should be reduced by around 50%

RPM = rev./min. FEED = mm/min. Vc = m/min. fz = mm/t