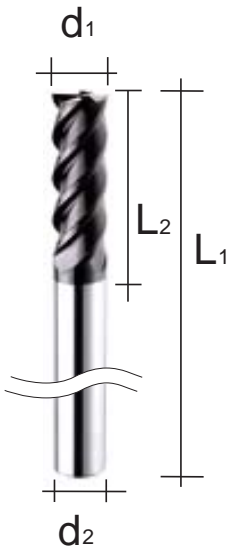


# End Mills Series

## 4 Flutes Square End Mills



### 4刃立銑刀 超微粒碳化鎢 立銑刀系列



型號 type No.	直徑(φ1) Diameter	刃長(L2) Flute Length	全長(L1) O.A.L	柄徑(φ2) Shank Dia
JE 0104	1.0	3	50	4
JE 0154	1.5	4	50	4
JE 0204	2.0	6	50	4
JE 0254	2.5	7	50	4
JE 0304	3.0	8	50	4
JE 0304A	3.0	8	50	3
JE 0404	4.0	11	50	4
JE 0504	5.0	13	50	6
JE 0604	6.0	15	50	6
JE 0804	8.0	20	60	8
JE 1004	10.0	30	75	10
JE 1204	12.0	30	75	12
JE 1404	14.0	35	100	16
JE 1604	16.0	40	100	16
JE 1804	18.0	40	100	20
JE 2004	20.0	45	100	20
JE 2504	25.0	45	100	25

### Recommended cutting condition for Square 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	
	~HRC30		~HRC50		~HRC60	
Hardness						
DIAMETER	SPEED (mm-1)	FEED mm/min	SPEED (mm-1)	FEED mm/min	SPEED (mm-1)	FEED mm/min
1	20000	80	15000	45	11000	30
1.5	13600	135	10000	60	9000	40
2	9600	150	8500	50	6000	45
3	6500	200	5800	75	4000	60
4	5500	250	4000	80	3200	60
5	4500	300	3000	80	2500	70
6	4000	300	2500	80	2200	70
8	3500	350	2200	90	1700	70
10	3000	400	2000	90	1500	70
12	2500	400	1500	100	1000	70
16	2000	400	1200	100	800	70

### DEPTH OF CUT

