

Soft Materials Cutting Series

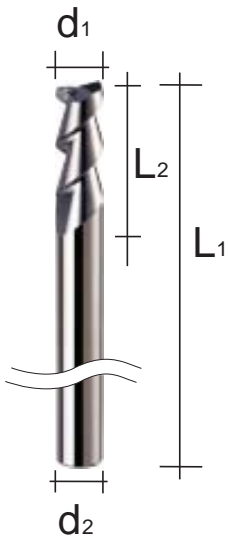
2 Flutes Long Shank Square End Mills



鋁合金專用 2刃長刃立銑刀 超微粒碳化鎢 軟金屬系列



型號 type No.	直徑(D1) Diameter	刃長(L2) Flute Length	全長(L1) O.A.L	柄徑(d2) Shank Dia
LAE 0302	3.0	12	75	6
LAE 0402	4.0	16	75	6
LAE 0502	5.0	20	75	6
LAE 0602	6.0	25	75	6
LAE 0802	8.0	32	75	8
LAE 0802A	8.0	35	100	8
LAE 1002	10.0	50	100	10
LAE 1202	12.0	50	100	12
LAE 1602	16.0	65	150	16
LAE 2002	20.0	75	150	20



Recommended cutting condition for Long Flute 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	
DIAMETER	SPEED (mm-1)	FEED mm/min	SPEED (mm-1)	FEED mm/min	SPEED (mm-1)	FEED mm/min
2	30000	600(500)	15000	250(250)	18000	300(300)
3	26000	600(500)	11000	250(250)	13500	300(350)
4	20000	600(550)	8500	250(200)	10000	300(350)
5	15600	600(550)	6700	250(200)	8000	300(350)
6	13500	600(550)	5500	250(200)	6700	300(350)
8	10000	600(600)	4200	250(200)	5000	300(350)
10	7500	600(600)	3300	250(200)	4000	300(350)
12	6700	600(600)	2700	250(200)	3400	300(350)
16	5000	600(500)	2300	250(200)	2500	300(350)
20	4000	600(500)	1700	250(200)	2000	300(350)

DEPTH OF CUT

