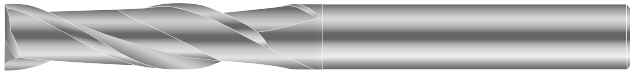


2FESL

Number of Flutes: 2

General use / Finishing (Long)

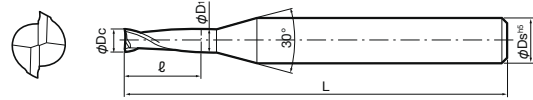


MEGACOAT is applied

Super Micro-grain carbide

Recommended Material

★ 1st Recommendation



Lineup

(Unit: mm)

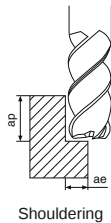
Description	Std.	Outside Dia. ØDc	Outside Dia. tolerance	Length of edge ℓ	Neck Dia. ØD1	Shank Dia. ØDs	Overall length L	Number of Flutes Z
2FESL010-040-04	●	1.0	0 -0.015	4.0	1.1	4	45	2
2FESL015-060-04	●	1.5	0 -0.015	6.0	1.6	4	45	2
2FESL020-090-04	●	2.0	0 -0.015	9.0	2.1	4	45	2
2FESL025-120-04	●	2.5	0 -0.015	12.0	2.6	4	45	2
2FESL030-140-06	●	3.0	0 -0.015	14.0	3.2	6	50	2
2FESL040-170-06	●	4.0	0 -0.015	17.0	4.2	6	50	2

(Unit: mm)

Description	Std.	Outside Dia. ØDc	Outside Dia. tolerance	Length of edge ℓ	Neck Dia. ØD1	Shank Dia. ØDs	Overall length L	Number of Flutes Z
2FESL050-200-06	●	5.0	0 -0.015	20.0	5.2	6	60	2
2FESL060-240-06	●	6.0	-0.005 -0.025	24.0	-	6	60	2
2FESL080-280-08	●	8.0	-0.005 -0.025	28.0	-	8	70	2
2FESL100-340-10	●	10.0	-0.005 -0.025	34.0	-	10	90	2
2FESL120-400-12	●	12.0	-0.010 -0.030	40.0	-	12	90	2
2FESL160-480-16	●	16.0	-0.010 -0.030	48.0	-	16	115	2

Recommended Cutting Conditions

Shouldering



Workpiece Materials	Depth of Cut (ap×ae) (mm)	Outside Dia. (mm)	Ø1	Ø2	Ø4	Ø6	Ø8	Ø12	Ø16
Carbon Steel	2.5Dc×0.05Dc (Dc<Ø3)	Spindle Revolution (min ⁻¹)	19,000	9,500	4,800	3,200	2,400	1,600	1,200
	2.5Dc×0.1Dc (Dc≥Ø3)	Feed Rate (mm/min)	210	210	210	210	210	210	210
Alloy Steel	2.5Dc×0.05Dc (Dc<Ø3)	Spindle Revolution (min ⁻¹)	14,300	7,200	3,600	2,400	2,000	1,300	1,000
	2.5Dc×0.1Dc (Dc≥Ø3)	Feed Rate (mm/min)	155	160	160	160	170	170	150
Pre-hardened Steel 30~45HRC	2.5Dc×0.05Dc (Dc<Ø3)	Spindle Revolution (min ⁻¹)	11,200	5,600	2,800	1,900	1,600	1,000	800
	2.5Dc×0.1Dc (Dc≥Ø3)	Feed Rate (mm/min)	85	85	90	90	100	95	80
Stainless Steel	2.5Dc×0.05Dc (Dc<Ø3)	Spindle Revolution (min ⁻¹)	14,300	7,200	3,600	2,400	2,000	1,300	1,000
	2.5Dc×0.1Dc (Dc≥Ø3)	Feed Rate (mm/min)	95	95	95	95	105	105	80

* Machining with coolant is recommended for stainless steel.

Not Recommended for Slotting.