

2FEKS

Number of Flutes: 2

General use / Finishing

Tough corner edge (Short)

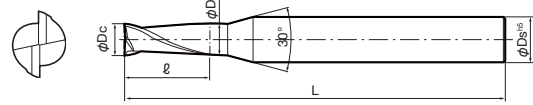


MEGACOAT is applied

Super Micro-grain carbide

Recommended Material

★ 1st Recommendation



Lineup

(Unit: mm)

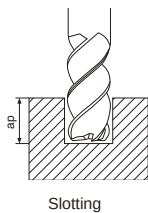
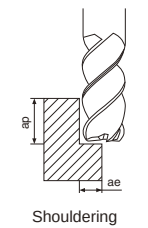
Description	Std.	Outside Dia. ØDc	Outside Dia. tolerance	Length of edge t	Neck Dia. ØD1	Under Neck Length t2	Shank Dia. ØDs	Overall length L	Number of Flutes Z
2FEKS030-045-06	●	3.0	0 -0.015	4.5	3.15	6.5	6	50	2
2FEKS035-052-06	●	3.5	0 -0.015	5.2	3.68	7.2	6	50	2
2FEKS040-060-06	●	4.0	0 -0.015	6.0	4.2	8.2	6	50	2
2FEKS045-067-06	●	4.5	0 -0.015	6.7	4.7	8.9	6	50	2
2FEKS050-075-06	●	5.0	0 -0.015	7.5	5.2	10.1	6	50	2
2FEKS055-082-06	●	5.5	0 -0.015	8.2	5.7	10.8	6	50	2
2FEKS060-090-06	●	6.0	0 -0.020	9.0	-	-	6	50	2

(Unit: mm)

Description	Std.	Outside Dia. ØDc	Outside Dia. tolerance	Length of edge t	Neck Dia. ØD1	Under Neck Length t2	Shank Dia. ØDs	Overall length L	Number of Flutes Z
2FEKS080-120-08	●	8.0	-0.005 -0.025	12.0	-	-	8	60	2
2FEKS100-150-10	●	10.0	-0.005 -0.025	15.0	-	-	10	70	2
2FEKS120-180-12	●	12.0	-0.010 -0.030	18.0	-	-	12	75	2
2FEKS140-210-16	●	14.0	-0.010 -0.030	21.0	14.2	31.4	16	75	2
2FEKS150-230-16	●	15.0	-0.010 -0.030	23.0	15.2	35	16	90	2
2FEKS160-240-16	●	16.0	-0.010 -0.030	24.0	-	-	16	90	2

- Corner lands improve the cutting edge strength.

Recommended Cutting Conditions



Shouldering

Workpiece Materials	Depth of Cut (ap×ae) (mm)	Outside Dia. (mm)	Ø3	Ø4	Ø6	Ø8	Ø10	Ø12	Ø16
Carbon Steel	1.2Dc×0.1Dc	Spindle Revolution (min ⁻¹)	9,300	7,000	4,600	3,500	3,000	2,700	2,200
		Feed Rate (mm/min)	450	450	470	470	470	470	440
Alloy Steel	1.2Dc×0.1Dc	Spindle Revolution (min ⁻¹)	8,800	6,600	4,400	3,300	2,600	2,200	1,800
		Feed Rate (mm/min)	370	370	380	380	380	380	360
Pre-hardened Steel 30~45HRC	1.2Dc×0.1Dc	Spindle Revolution (min ⁻¹)	6,400	4,800	3,200	2,400	1,900	1,600	1,200
		Feed Rate (mm/min)	130	130	130	140	140	140	140
Stainless Steel	1.2Dc×0.1Dc	Spindle Revolution (min ⁻¹)	8,000	6,000	4,000	3,000	2,400	2,000	1,500
		Feed Rate (mm/min)	140	140	140	140	140	140	140

* Machining with coolant is recommended for stainless steel.

For Slotting, see page L44.