

4FEKM

Number of Flutes: 4

General use / Finishing

Tough corner edge (Medium)

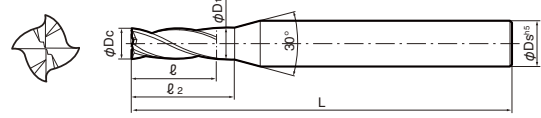


MEGACOAT is applied

Super Micro-grain carbide

Recommended Material

★ 1st Recommendation



Lineup

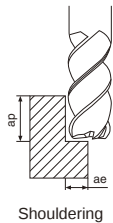
(Unit: mm)

Description	Std.	Outside Dia. ØDc	Outside Dia. tolerance	Length of edge ℓ	Neck Dia. ØD1	Under Neck Length t2	Shank Dia. ØDs	Overall length L	Number of Flutes Z
4FEKM030-100-06	●	3.0	0 -0.015	10.0	3.15	12	6	50	4
4FEKM035-100-06	●	3.5	0 -0.015	10.0	3.68	12	6	50	4
4FEKM040-110-06	●	4.0	0 -0.015	11.0	4.2	13.2	6	50	4
4FEKM045-110-06	●	4.5	0 -0.015	11.0	4.7	13.2	6	50	4
4FEKM050-130-06	●	5.0	0 -0.015	13.0	5.2	15.6	6	50	4
4FEKM055-130-06	●	5.5	0 -0.015	13.0	5.7	15.6	6	50	4
4FEKM060-130-06	●	6.0	0 -0.020	13.0	-	-	6	50	4

(Unit: mm)

Description	Std.	Outside Dia. ØDc	Outside Dia. tolerance	Length of edge ℓ	Neck Dia. ØD1	Under Neck Length t2	Shank Dia. ØDs	Overall length L	Number of Flutes Z
4FEKM080-190-08	●	8.0	-0.005 -0.025	19.0	-	-	8	60	4
4FEKM100-220-10	●	10.0	-0.005 -0.025	22.0	-	-	10	70	4
4FEKM120-260-12	●	12.0	-0.010 -0.030	26.0	-	-	12	75	4
4FEKM140-260-16	●	14.0	-0.010 -0.030	26.0	14.2	36.4	16	75	4
4FEKM150-300-16	●	15.0	-0.010 -0.030	30.0	15.2	42	16	90	4
4FEKM160-320-16	●	16.0	-0.010 -0.030	32.0	-	-	16	90	4

Recommended Cutting Conditions



Shouldering

Shouldering

Workpiece Materials	Depth of Cut (ap×ae) (mm)	Outside Dia. (mm)	Ø3	Ø4	Ø6	Ø8	Ø10	Ø12	Ø16
Carbon Steel	1.5Dc×0.1Dc	Spindle Revolution (min ⁻¹)	10,600	8,000	5,300	4,000	3,200	2,700	2,100
		Feed Rate (mm/min)	680	690	770	770	770	770	770
Alloy Steel	1.5Dc×0.1Dc	Spindle Revolution (min ⁻¹)	8,800	6,600	4,400	3,300	2,600	2,200	2,000
		Feed Rate (mm/min)	500	550	620	630	630	630	610
Pre-hardened Steel 30~45HRC	1.5Dc×0.1Dc	Spindle Revolution (min ⁻¹)	6,400	4,800	3,200	2,400	1,900	1,600	1,200
		Feed Rate (mm/min)	180	180	180	190	190	190	190
Stainless Steel	1.5Dc×0.1Dc	Spindle Revolution (min ⁻¹)	8,000	6,000	4,000	3,000	2,300	2,000	1,500
		Feed Rate (mm/min)	190	200	200	200	210	210	210

* Machining with coolant is recommended for stainless steel.

Not Recommended for Slotting.

