

4RFSM, 6RFSM

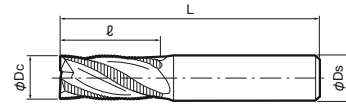
Number of Flutes: 4, 6

Roughing of Hard Materials



Recommended Material

★ 1st Recommendation



Lineup

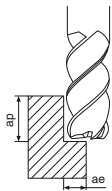
(Unit: mm)

Description	Std.	Outside Dia.	Outside Dia. tolerance	Edge Length	Shank Dia.	Total length	Number of Flutes
		øDc		l	øDs	L	Z
4RFSM060-130-06	●	6	-0.030 -0.105	13	6	57	4
4RFSM080-160-08	●	8	-0.040 -0.130	16	8	63	4
4RFSM100-220-10	●	10	-0.040 -0.130	22	10	72	4
4RFSM120-260-12	●	12	-0.050 -0.160	26	12	83	4
4RFSM160-320-16	●	16	-0.050 -0.160	32	16	92	4
4RFSM200-380-20	●	20	-0.065 -0.195	38	20	104	4
6RFSM160-320-16	●	16	-0.050 -0.160	32	16	92	6
6RFSM200-380-20	●	20	-0.065 -0.195	38	20	104	6
6RFSM250-450-25	●	25	-0.065 -0.195	45	25	121	6

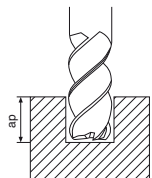
- Due to the strong cutting edge with large flat surface, it is suitable for machining of hardened materials and titanium alloy. Four flute type and 6 flute type are available.

Recommended Cutting Conditions

Shouldering



Shouldering



Slotting

Workpiece Materials		Depth of Cut (apxae) (mm)	Outside Dia. (mm)	ø6	ø8	ø10	ø12	ø16		ø20		ø25
								4 Flute	6 Flute	4 Flute	6 Flute	
Steel	35~45HRC	1.5Dc×0.4Dc	Spindle Revolution (min ⁻¹)	8,000	6,000	4,800	4,000	3,000	3,000	2,400	2,400	1,900
			Feed Rate (mm/min)	630	630	630	640	640	900	640	930	800
	45~55HRC	1.5Dc×0.33Dc	Spindle Revolution (min ⁻¹)	5,800	4,400	3,500	2,900	2,200	2,200	1,800	1,800	1,400
			Feed Rate (mm/min)	350	350	350	350	350	530	350	530	460
	55~60HRC	1.5Dc×0.25Dc	Spindle Revolution (min ⁻¹)	4,800	3,600	2,900	2,400	1,800	1,800	1,400	1,400	1,100
			Feed Rate (mm/min)	190	220	230	240	220	320	230	340	310
Titanium Alloy	< 40HRC	1.5Dc×0.33Dc	Spindle Revolution (min ⁻¹)	3,700	2,800	2,200	1,900	1,400	1,400	1,100	1,100	900
			Feed Rate (mm/min)	390	390	390	390	390	590	390	540	450
	> 40HRC	1.5Dc×0.25Dc	Spindle Revolution (min ⁻¹)	3,200	2,400	1,900	1,600	1,200	1,200	1,000	1,000	800
			Feed Rate (mm/min)	300	300	300	300	300	430	300	430	370
Inconel		1Dc×0.2Dc	Spindle Revolution (min ⁻¹)	1,600	1,200	1,000	800	600	600	500	500	400
			Feed Rate (mm/min)	100	100	100	100	100	140	100	140	130

Please refer to page L46 about Slotting.

● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)

