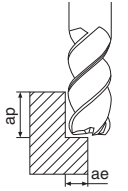
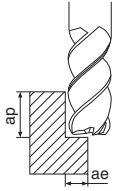
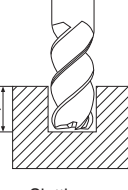


4UGSM, 6UGSM (Shouldering)

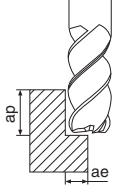
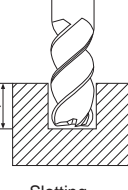
Application	Workpiece Material		Depth of Cut (apxae) (mm)	Outside Dia. Dc (mm)	ø4	ø6	ø8	ø10	ø12	ø16
 <p>Shouldering</p>	Steel	45-55HRC	1Dc×0.05Dc	Spindle Revolution (min ⁻¹)	11,900	8,000	6,000	4,800	4,000	3,000
		Feed Rate (mm/min)		810	1,200	1,200	1,000	980	900	
		55-60HRC	1Dc×0.2mm	Spindle Revolution (min ⁻¹)	8,000	5,300	4,000	3,200	2,700	2,000
		Feed Rate (mm/min)		510	760	740	610	610	540	
		60-65HRC	1Dc×0.2mm	Spindle Revolution (min ⁻¹)	5,200	3,500	2,600	2,100	1,700	1,300
		Feed Rate (mm/min)		290	480	450	390	370	330	
		65-70HRC	1Dc×0.2mm	Spindle Revolution (min ⁻¹)	2,800	1,900	1,400	1,100	900	700
		Feed Rate (mm/min)		150	250	230	200	200	170	

Slotting is not recommended.

3NESM

Application	Workpiece Material	Application	Depth of Cut (apxae) (mm)	Outside Dia. Dc (mm)	ø3	ø6	ø8	ø10	ø12	ø16	ø20
 <p>Shouldering</p>	Aluminum Alloys	Shouldering	1.5Dc×0.5Dc	Spindle Revolution (min ⁻¹)	34,000	17,000	13,000	10,200	8,500	6,400	5,100
				Feed Rate (mm/min)	2,750	2,750	2,750	2,750	2,750	2,750	
 <p>Slotting</p>		Slotting	1Dc	Spindle Revolution (min ⁻¹)	26,500	13,000	9,800	8,000	6,600	5,000	4,000
				Feed Rate (mm/min)	1,100	1,100	1,100	1,100	1,100	1,100	

2NFSM

Application	Workpiece Material	Application	Depth of Cut (apxae) (mm)	Outside Dia. Dc (mm)	ø3	ø6	ø8	ø10	ø12	ø16	ø20	
 <p>Shouldering</p>	Aluminum Alloys	Shouldering	1Dc×0.5Dc	Spindle Revolution (min ⁻¹)	26,500	13,300	10,000	8,000	6,600	5,000	4,000	
				Feed Rate (mm/min)	690	950	950	1,130	1,260	1,000	880	
		Slotting	Slotting	1Dc	Spindle Revolution (min ⁻¹)	21,200	10,600	8,000	6,400	5,300	4,000	3,200
					Feed Rate (mm/min)	550	750	750	900	1,010	800	700
 <p>Slotting</p>	High-silicon Aluminum Alloys	Shouldering	1Dc×0.5Dc	Spindle Revolution (min ⁻¹)	19,100	9,600	7,200	5,700	4,800	3,600	2,900	
				Feed Rate (mm/min)	420	500	500	600	670	770	570	
		Slotting	Slotting	1Dc	Spindle Revolution (min ⁻¹)	15,900	7,900	5,900	4,800	4,000	3,000	2,400
					Feed Rate (mm/min)	350	420	420	500	560	640	480



Solid End Mill