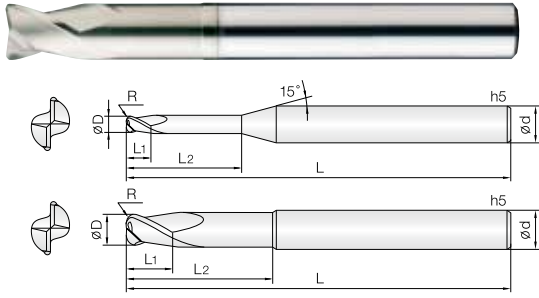


2날 동가공용 리브 코너 레디우스 엔드밀



- 동 및 동합금, 알루미늄 합금, 비철합금 가공용 엔드밀
- JCRO 코팅 처리하여 다양한 피삭재 가공시 인선부에 스트레스가 적으며, 피삭재의 면조도가 향상됩니다.
- 깊은 포켓으로 설계하여 칩배출이 원활합니다.
- 항절력이 높은 미립자 초경합금 (0.5 μ m)을 채택, 엔드밀의 파손을 최소화 하였습니다.
- Endmills for copper, copper alloys, non-ferrous and non-metallic materials
- JCRO coating provides wear resistance improvement as well as avoid edge stress in various applications.
- Smooth chip outflow by deep chip pocket.
- Minimize fracturing by high TRS fine(0.5 μ m) WC grade.

2

WC
미립자

JCRO
Coating

R
± 0.005

R
± 0.01

30°
Helix Angle

CUTTING
DATA

R0.1 ~ 0.5 R1 ~ 1.5 481P

Condition	D Size	D Tolerance	Condition	D Size	D Tolerance
ØD ≠ Ød	Ø1 ~ 12	+0 ~ -0.01mm	ØD = Ød	Ø6 ~ 12	-0.005 ~ -0.015mm

단위 : mm

Order Number	날경 Diameter D × R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샙크 Shank Dia d	비고	Order Number	날경 Diameter D × R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샙크 Shank Dia d	비고
2COR 010 001 040	1 X R0.1	1.5	4	50	4		2COR 020 001 250	2 X R0.1	3	25	60	4	
2COR 010 001 060	1 X R0.1	1.5	6	50	4		2COR 020 002 060	2 X R0.2	3	6	50	4	
2COR 010 001 080	1 X R0.1	1.5	8	50	4		2COR 020 002 100	2 X R0.2	3	10	50	4	
2COR 010 001 100	1 X R0.1	1.5	10	50	4		2COR 020 002 120	2 X R0.2	3	12	50	4	
2COR 010 001 120	1 X R0.1	1.5	12	50	4		2COR 020 002 160	2 X R0.2	3	16	50	4	
2COR 010 001 160	1 X R0.1	1.5	16	50	4		2COR 020 002 200	2 X R0.2	3	20	50	4	
2COR 010 001 200	1 X R0.1	1.5	20	50	4		2COR 020 002 250	2 X R0.2	3	25	60	4	
2COR 010 002 040	1 X R0.2	1.5	4	50	4		2COR 020 003 060	2 X R0.3	3	6	50	4	
2COR 010 002 060	1 X R0.2	1.5	6	50	4		2COR 020 003 100	2 X R0.3	3	10	50	4	
2COR 010 002 080	1 X R0.2	1.5	8	50	4		2COR 020 003 120	2 X R0.3	3	12	50	4	
2COR 010 002 100	1 X R0.2	1.5	10	50	4		2COR 020 003 160	2 X R0.3	3	16	50	4	
2COR 010 002 120	1 X R0.2	1.5	12	50	4		2COR 020 003 200	2 X R0.3	3	20	50	4	
2COR 010 002 160	1 X R0.2	1.5	16	50	4		2COR 020 003 250	2 X R0.3	3	25	60	4	
2COR 010 002 200	1 X R0.2	1.5	20	50	4		2COR 020 005 060	2 X R0.5	3	6	50	4	
2COR 010 003 040	1 X R0.3	1.5	4	50	4		2COR 020 005 100	2 X R0.5	3	10	50	4	
2COR 010 003 060	1 X R0.3	1.5	6	50	4		2COR 020 005 120	2 X R0.5	3	12	50	4	
2COR 010 003 080	1 X R0.3	1.5	8	50	4		2COR 020 005 140	2 X R0.5	3	14	50	4	
2COR 010 003 100	1 X R0.3	1.5	10	50	4		2COR 020 005 160	2 X R0.5	3	16	50	4	
2COR 010 003 120	1 X R0.3	1.5	12	50	4		2COR 020 005 200	2 X R0.5	3	20	50	4	
2COR 010 003 160	1 X R0.3	1.5	16	50	4		2COR 020 005 250	2 X R0.5	3	25	60	4	
2COR 010 003 200	1 X R0.3	1.5	20	50	4		2COR 025 001 060	2.5 X R0.1	3.5	6	50	4	
2COR 015 001 060	1.5 X R0.1	2	6	50	4		2COR 025 001 100	2.5 X R0.1	3.5	10	50	4	
2COR 015 001 100	1.5 X R0.1	2	10	50	4		2COR 025 001 120	2.5 X R0.1	3.5	12	50	4	
2COR 015 001 120	1.5 X R0.1	2	12	50	4		2COR 025 001 160	2.5 X R0.1	3.5	16	50	4	
2COR 015 001 160	1.5 X R0.1	2	16	50	4		2COR 025 001 200	2.5 X R0.1	3.5	20	50	4	
2COR 015 001 200	1.5 X R0.1	2	20	50	4		2COR 025 001 250	2.5 X R0.1	3.5	25	60	4	
2COR 015 001 250	1.5 X R0.1	2	25	60	4		2COR 025 002 060	2.5 X R0.2	3.5	6	50	4	
2COR 015 002 060	1.5 X R0.2	2	6	50	4		2COR 025 002 100	2.5 X R0.2	3.5	10	50	4	
2COR 015 002 100	1.5 X R0.2	2	10	50	4		2COR 025 002 120	2.5 X R0.2	3.5	12	50	4	
2COR 015 002 120	1.5 X R0.2	2	12	50	4		2COR 025 002 160	2.5 X R0.2	3.5	16	50	4	
2COR 015 002 160	1.5 X R0.2	2	16	50	4		2COR 025 002 200	2.5 X R0.2	3.5	20	50	4	
2COR 015 002 200	1.5 X R0.2	2	20	50	4		2COR 025 002 250	2.5 X R0.2	3.5	25	60	4	
2COR 015 002 250	1.5 X R0.2	2	25	60	4		2COR 025 003 060	2.5 X R0.3	3.5	6	50	4	
2COR 015 003 060	1.5 X R0.3	2	6	50	4		2COR 025 003 100	2.5 X R0.3	3.5	10	50	4	
2COR 015 003 100	1.5 X R0.3	2	10	50	4		2COR 025 003 120	2.5 X R0.3	3.5	12	50	4	
2COR 015 003 120	1.5 X R0.3	2	12	50	4		2COR 025 003 160	2.5 X R0.3	3.5	16	50	4	
2COR 015 003 160	1.5 X R0.3	2	16	50	4		2COR 025 003 200	2.5 X R0.3	3.5	20	50	4	
2COR 015 003 200	1.5 X R0.3	2	20	50	4		2COR 025 003 250	2.5 X R0.3	3.5	25	60	4	
2COR 015 003 250	1.5 X R0.3	2	25	60	4		2COR 025 005 060	2.5 X R0.5	3.5	6	50	4	
2COR 015 005 060	1.5 X R0.5	2	6	50	4		2COR 025 005 100	2.5 X R0.5	3.5	10	50	4	
2COR 015 005 100	1.5 X R0.5	2	10	50	4		2COR 025 005 120	2.5 X R0.5	3.5	12	50	4	
2COR 015 005 120	1.5 X R0.5	2	12	50	4		2COR 025 005 160	2.5 X R0.5	3.5	16	50	4	
2COR 015 005 160	1.5 X R0.5	2	16	50	4		2COR 025 005 200	2.5 X R0.5	3.5	20	50	4	
2COR 015 005 200	1.5 X R0.5	2	20	50	4		2COR 025 005 250	2.5 X R0.5	3.5	25	60	4	
2COR 015 005 250	1.5 X R0.5	2	25	60	4		2COR 030 001 100	3 X R0.1	4	10	55	6	
2COR 020 001 060	2 X R0.1	3	6	50	4		2COR 030 001 120	3 X R0.1	4	12	55	6	
2COR 020 001 100	2 X R0.1	3	10	50	4		2COR 030 001 160	3 X R0.1	4	16	55	6	
2COR 020 001 120	2 X R0.1	3	12	50	4		2COR 030 001 200	3 X R0.1	4	20	60	6	
2COR 020 001 160	2 X R0.1	3	16	50	4		2COR 030 001 250	3 X R0.1	4	25	65	6	
2COR 020 001 200	2 X R0.1	3	20	50	4		2COR 030 001 300	3 X R0.1	4	30	70	6	

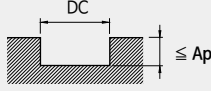
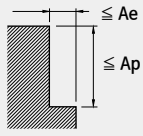


단위 : mm

Order Number	날경 Diameter D×R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샙크 Shank Dia d	비고	Order Number	날경 Diameter D×R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샙크 Shank Dia d	비고
2COR 030 001 350	3 X R0.1	4	35	75	6		2COR 040 005 160	4 X R0.5	5	16	55	6	
2COR 030 001 400	3 X R0.1	4	40	80	6		2COR 040 005 200	4 X R0.5	5	20	60	6	
2COR 030 002 100	3 X R0.2	4	10	55	6		2COR 040 005 300	4 X R0.5	5	30	70	6	
2COR 030 002 120	3 X R0.2	4	12	55	6		2COR 040 005 400	4 X R0.5	5	40	80	6	
2COR 030 002 160	3 X R0.2	4	16	55	6		2COR 040 010 120	4 X R1	5	12	55	6	
2COR 030 002 200	3 X R0.2	4	20	60	6		2COR 040 010 160	4 X R1	5	16	55	6	
2COR 030 002 250	3 X R0.2	4	25	65	6		2COR 040 010 200	4 X R1	5	20	60	6	
2COR 030 002 300	3 X R0.2	4	30	70	6		2COR 040 010 300	4 X R1	5	30	70	6	
2COR 030 002 350	3 X R0.2	4	35	75	6		2COR 040 010 400	4 X R1	5	40	80	6	
2COR 030 002 400	3 X R0.2	4	40	80	6		2COR 060 001 200	6 X R0.1	7	20	60	6	
2COR 030 003 100	3 X R0.3	4	10	55	6		2COR 060 002 200	6 X R0.2	7	20	60	6	
2COR 030 003 120	3 X R0.3	4	12	55	6		2COR 060 003 200	6 X R0.3	7	20	60	6	
2COR 030 003 160	3 X R0.3	4	16	55	6		2COR 060 005 200	6 X R0.5	7	20	60	6	
2COR 030 003 200	3 X R0.3	4	20	60	6		2COR 060 010 200	6 X R1	7	20	60	6	
2COR 030 003 250	3 X R0.3	4	25	65	6		2COR 060 015 200	6 X R1.5	7	20	60	6	
2COR 030 003 300	3 X R0.3	4	30	70	6		2COR 080 005 250	8 X R0.5	9	25	65	8	
2COR 030 003 350	3 X R0.3	4	35	75	6		2COR 080 010 250	8 X R1	9	25	65	8	
2COR 030 003 400	3 X R0.3	4	40	80	6		2COR 080 015 250	8 X R1.5	9	25	65	8	
2COR 030 005 100	3 X R0.5	4	10	55	6		2COR 100 005 320	10 X R0.5	11	32	70	10	
2COR 030 005 120	3 X R0.5	4	12	55	6		2COR 100 010 320	10 X R1	11	32	70	10	
2COR 030 005 160	3 X R0.5	4	16	55	6		2COR 100 015 320	10 X R1.5	11	32	70	10	
2COR 030 005 200	3 X R0.5	4	20	60	6		2COR 120 005 380	12 X R0.5	12	38	80	12	
2COR 030 005 250	3 X R0.5	4	25	65	6		2COR 120 010 380	12 X R1	12	38	80	12	
2COR 030 005 300	3 X R0.5	4	30	70	6		2COR 120 015 380	12 X R1.5	12	38	80	12	
2COR 030 005 350	3 X R0.5	4	35	75	6								
2COR 030 005 400	3 X R0.5	4	40	80	6								
2COR 030 010 100	3 X R1	4	10	55	6								
2COR 030 010 120	3 X R1	4	12	55	6								
2COR 030 010 160	3 X R1	4	16	55	6								
2COR 030 010 200	3 X R1	4	20	60	6								
2COR 030 010 250	3 X R1	4	25	65	6								
2COR 030 010 300	3 X R1	4	30	70	6								
2COR 030 010 350	3 X R1	4	35	75	6								
2COR 030 010 400	3 X R1	4	40	80	6								
2COR 040 001 120	4 X R0.1	5	12	55	6								
2COR 040 001 160	4 X R0.1	5	16	55	6								
2COR 040 001 200	4 X R0.1	5	20	60	6								
2COR 040 001 300	4 X R0.1	5	30	70	6								
2COR 040 001 400	4 X R0.1	5	40	80	6								
2COR 040 002 120	4 X R0.2	5	12	55	6								
2COR 040 002 160	4 X R0.2	5	16	55	6								
2COR 040 002 200	4 X R0.2	5	20	60	6								
2COR 040 002 300	4 X R0.2	5	30	70	6								
2COR 040 002 400	4 X R0.2	5	40	80	6								
2COR 040 003 120	4 X R0.3	5	12	55	6								
2COR 040 003 160	4 X R0.3	5	16	55	6								
2COR 040 003 200	4 X R0.3	5	20	60	6								
2COR 040 003 300	4 X R0.3	5	30	70	6								
2COR 040 003 400	4 X R0.3	5	40	80	6								
2COR 040 005 120	4 X R0.5	5	12	55	6								

FOR COPPER

			홈절삭 Slotting				측면절삭 Side Cutting			
피삭재 Material			동/ 동합금 C1100 Copper / Copper Alloys				동/ 동합금 C1100 Copper / Copper Alloys			
외경 Outside Diameter	반경 Corner Radius	유효장 Effective Length	RPM	FEED	Ap Axial Depth	Ap Radial Depth	RPM	FEED	Ap Axial Depth	Ap Radial Depth
∅ 1	R0.1, R0.2	3	45,000	2,500	0.036	1	45,000	4,500	0.036	0.2
"	"	6	40,000	2,000	0.03	1	40,000	3,000	0.03	0.2
"	"	10	35,000	1,600	0.025	1	35,000	2,000	0.025	0.2
∅ 1.5	R0.1, R0.2	5	23,000	1,800	0.08	1.5	50,000	6,000	0.08	0.3
"	"	8	26,000	1,600	0.06	1.5	45,000	5,500	0.06	0.3
"	"	12	30,000	1,500	0.05	1.5	40,000	4,500	0.04	0.3
∅ 2	R0.1, R0.2	6	35,000	1,800	0.14	2	45,000	5,000	0.12	0.8
"	"	10	30,000	1,600	0.12	2	40,000	4,700	0.1	0.6
"	"	14	30,000	1,200	0.08	2	30,000	3,800	0.06	0.4
∅ 3	R0.2, R0.3	10	30,000	2,200	0.14	3	40,000	6,500	0.12	1
"	"	16	20,000	2,000	0.12	3	35,000	6,000	0.1	0.6
"	"	20	20,000	2,000	0.12	3	35,000	6,000	0.1	0.6
"	R0.5	10	20,000	2,600	0.14	3	38,000	10,000	0.12	0.8
"	"	16	20,000	2,200	0.12	3	35,000	8,000	0.1	0.6
"	"	20	20,000	2,200	0.12	3	35,000	8,000	0.1	0.6
∅ 4	R0.2, R0.3	12	20,000	2,600	0.5	4	40,000	8,000	0.18	0.12
"	"	16	15,000	2,400	0.3	4	32,000	5,000	0.16	0.1
"	"	20	15,000	2,000	0.25	4	32,000	5,000	0.15	0.8
"	R0.5	12	20,000	2,400	0.5	4	35,000	10,000	0.3	0.1
"	"	16	15,000	2,200	0.25	4	32,000	7,000	0.15	0.8
"	"	20	15,000	2,200	0.25	4	32,000	7,000	0.15	0.8
∅ 6	R0.3, R0.5	20	10,000	1,400	0.6	6	20,000	5,200	0.25	1.2
"	"	30	10,000	1,200	0.4	6	20,000	5,000	0.25	1.2
"	R10	20	10,000	1,800	0.6	6	20,000	9,000	0.25	1.2
"	"	30	10,000	1,500	0.4	6	20,000	7,000	0.25	1.2
∅ 8	R0.3, R0.5	25	8,000	1,000	0.3	8	15,000	5,000	0.3	1.5
"	R1	25	8,000	1,300	0.3	8	15,000	10,000	0.3	1.5
∅ 10	R0.5	30	7,000	1,300	0.3	10	13,000	7,000	0.2	1.5
"	R1.0	30	7,000	1,500	0.3	10	13,000	12,000	0.2	1.5
∅ 12	R0.5	35	6,000	1,100	0.2	12	10,000	9,000	0.15	2
"	R1.0	35	6,000	1,300	0.2	12	10,000	15,000	0.15	2

절입량 Depth of Cut		
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- 절삭 시 코너R 부분을 참고하여 절삭하시기 바랍니다.
- 유효장이 긴 경우에는 회전수와 이송속도를 최대 20% 이하로 줄이십시오.
- 위 절삭 조건은 2날 절삭 조건이며, 3날 가공 시 회전수는 유지하고, 피드는 안정적인 속도내에서 최대 20%까지 UP 해주십시오.
- 홈 절삭 시 날 경의 코너R 대비 Ae값을 설정 하십시오.

- Please refer to the corner R when cutting.
- If the effective length is long, reduce the rotation speed and feed rate by up to 20%.
- The above cutting conditions are for 2-flute cutting. For 3-flute cutting, maintain the rotation speed and increase the feed by up to 20% within a stable speed range.
- When cutting grooves, set the Ae value relative to the corner R of the tool's edge.