

- 중저경도강(HRC52이하), 프리하든강 계열, 탄소강, 금형강 등 가공
- JCRO 코팅 처리하여 넓은 영역의 피삭재 가공에 적합합니다.
- 고정밀 공차 적용으로 초정밀 가공에 적합합니다.
- 코너R 형상을 날부치핑이 적도록 설계하였습니다.
- 다양한 코너R과 유효장으로 맞춤 가공이 가능합니다.
- 항절력이 높은 미립자 초경합금(0.5µm)을 채택, 엔드밀의 파손을 최소화

Endmills for various work materials (~HRC52), pre-hardened steels, carbon steels, mold steels

- Optimum for various work materials by JCRO coating.
- High precise edge tolerance.
- Designed for minimizing edge chipping by corner R shape.
- Various corner R and flute length for wide range application.
- Minimize fracturing by high TRS fine(0.5µm) WC grade.

G series

4

WC
미립자

JCRO
Coating

R

R

R

35°
Helix Angle

CUTTING
DATA

R0.05 ~ 0.5 R1 ~ 1.5 R2 ~ 3 461P

Condition	D Size	D Tolerance	Condition	D Size	D Tolerance
øD ≠ ød	ø1 ~ 12	+0 ~ -0.01mm	øD = ød	ø4 ~ 12	-0.005 ~ -0.015mm

단위 : mm

Order Number	날경 D × R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샹크 Shank Dia d	비고	Order Number	날경 D × R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샹크 Shank Dia d	비고
4CREG 010 0005 040	1 X R0.05	1.2	4	45	4		4CREG 015 001 080	1.5 X R0.1	1.8	8	45	4	
4CREG 010 0005 060	1 X R0.05	1.2	6	45	4		4CREG 015 001 100	1.5 X R0.1	1.8	10	50	4	
4CREG 010 0005 080	1 X R0.05	1.2	8	45	4		4CREG 015 001 120	1.5 X R0.1	1.8	12	50	4	
4CREG 010 0005 100	1 X R0.05	1.2	10	50	4		4CREG 015 001 160	1.5 X R0.1	1.8	16	50	4	
4CREG 010 0005 120	1 X R0.05	1.2	12	50	4		4CREG 015 001 200	1.5 X R0.1	1.8	20	50	4	
4CREG 010 0005 160	1 X R0.05	1.2	16	50	4		4CREG 015 001 220	1.5 X R0.1	1.8	22	60	4	
4CREG 010 0005 200	1 X R0.05	1.2	20	50	4		4CREG 015 001 250	1.5 X R0.1	1.8	25	60	4	
4CREG 010 001 040	1 X R0.1	1.2	4	45	4		4CREG 015 002 060	1.5 X R0.2	1.8	6	45	4	
4CREG 010 001 060	1 X R0.1	1.2	6	45	4		4CREG 015 002 080	1.5 X R0.2	1.8	8	45	4	
4CREG 010 001 080	1 X R0.1	1.2	8	45	4		4CREG 015 002 100	1.5 X R0.2	1.8	10	50	4	
4CREG 010 001 100	1 X R0.1	1.2	10	50	4		4CREG 015 002 120	1.5 X R0.2	1.8	12	50	4	
4CREG 010 001 120	1 X R0.1	1.2	12	50	4		4CREG 015 002 160	1.5 X R0.2	1.8	16	50	4	
4CREG 010 001 160	1 X R0.1	1.2	16	50	4		4CREG 015 002 200	1.5 X R0.2	1.8	20	50	4	
4CREG 010 001 200	1 X R0.1	1.2	20	50	4		4CREG 015 002 220	1.5 X R0.2	1.8	22	60	4	
4CREG 010 002 040	1 X R0.2	1.2	4	45	4		4CREG 015 002 250	1.5 X R0.2	1.8	25	60	4	
4CREG 010 002 060	1 X R0.2	1.2	6	45	4		4CREG 015 003 060	1.5 X R0.3	1.8	6	45	4	
4CREG 010 002 080	1 X R0.2	1.2	8	45	4		4CREG 015 003 080	1.5 X R0.3	1.8	8	45	4	
4CREG 010 002 100	1 X R0.2	1.2	10	50	4		4CREG 015 003 100	1.5 X R0.3	1.8	10	50	4	
4CREG 010 002 120	1 X R0.2	1.2	12	50	4		4CREG 015 003 120	1.5 X R0.3	1.8	12	50	4	
4CREG 010 002 160	1 X R0.2	1.2	16	50	4		4CREG 015 003 160	1.5 X R0.3	1.8	16	50	4	
4CREG 010 002 200	1 X R0.2	1.2	20	50	4		4CREG 015 003 200	1.5 X R0.3	1.8	20	50	4	
4CREG 010 003 040	1 X R0.3	1.2	4	45	4		4CREG 015 003 220	1.5 X R0.3	1.8	22	60	4	
4CREG 010 003 060	1 X R0.3	1.2	6	45	4		4CREG 015 003 250	1.5 X R0.3	1.8	25	60	4	
4CREG 010 003 080	1 X R0.3	1.2	8	45	4		4CREG 015 005 060	1.5 X R0.5	1.8	6	45	4	
4CREG 010 003 100	1 X R0.3	1.2	10	50	4		4CREG 015 005 080	1.5 X R0.5	1.8	8	45	4	
4CREG 010 003 120	1 X R0.3	1.2	12	50	4		4CREG 015 005 100	1.5 X R0.5	1.8	10	50	4	
4CREG 010 003 160	1 X R0.3	1.2	16	50	4		4CREG 015 005 120	1.5 X R0.5	1.8	12	50	4	
4CREG 010 003 200	1 X R0.3	1.2	20	50	4		4CREG 015 005 160	1.5 X R0.5	1.8	16	50	4	
4CREG 012 001 040	1.2 X R0.1	1.4	4	45	4		4CREG 015 005 200	1.5 X R0.5	1.8	20	50	4	
4CREG 012 001 060	1.2 X R0.1	1.4	6	45	4		4CREG 015 005 220	1.5 X R0.5	1.8	22	60	4	
4CREG 012 001 080	1.2 X R0.1	1.4	8	45	4		4CREG 015 005 250	1.5 X R0.5	1.8	25	60	4	
4CREG 012 001 100	1.2 X R0.1	1.4	10	50	4		4CREG 020 001 060	2 X R0.1	2.4	6	45	4	
4CREG 012 001 120	1.2 X R0.1	1.4	12	50	4		4CREG 020 001 080	2 X R0.1	2.4	8	45	4	
4CREG 012 001 160	1.2 X R0.1	1.4	16	50	4		4CREG 020 001 100	2 X R0.1	2.4	10	50	4	
4CREG 012 001 200	1.2 X R0.1	1.4	20	50	4		4CREG 020 001 120	2 X R0.1	2.4	12	50	4	
4CREG 012 002 040	1.2 X R0.2	1.4	4	45	4		4CREG 020 001 160	2 X R0.1	2.4	16	50	4	
4CREG 012 002 060	1.2 X R0.2	1.4	6	45	4		4CREG 020 001 200	2 X R0.1	2.4	20	50	4	
4CREG 012 002 080	1.2 X R0.2	1.4	8	45	4		4CREG 020 001 250	2 X R0.1	2.4	25	60	4	
4CREG 012 002 100	1.2 X R0.2	1.4	10	50	4		4CREG 020 001 300	2 X R0.1	2.4	30	70	4	
4CREG 012 002 120	1.2 X R0.2	1.4	12	50	4		4CREG 020 001 350	2 X R0.1	2.4	35	70	4	
4CREG 012 002 160	1.2 X R0.2	1.4	16	50	4		4CREG 020 002 060	2 X R0.2	2.4	6	45	4	
4CREG 012 002 200	1.2 X R0.2	1.4	20	50	4		4CREG 020 002 080	2 X R0.2	2.4	8	45	4	
4CREG 012 003 040	1.2 X R0.3	1.4	4	45	4		4CREG 020 002 100	2 X R0.2	2.4	10	50	4	
4CREG 012 003 060	1.2 X R0.3	1.4	6	45	4		4CREG 020 002 120	2 X R0.2	2.4	12	50	4	
4CREG 012 003 080	1.2 X R0.3	1.4	8	45	4		4CREG 020 002 160	2 X R0.2	2.4	16	50	4	
4CREG 012 003 100	1.2 X R0.3	1.4	10	50	4		4CREG 020 002 200	2 X R0.2	2.4	20	50	4	
4CREG 012 003 120	1.2 X R0.3	1.4	12	50	4		4CREG 020 002 250	2 X R0.2	2.4	25	60	4	
4CREG 012 003 160	1.2 X R0.3	1.4	16	50	4		4CREG 020 002 300	2 X R0.2	2.4	30	70	4	
4CREG 012 003 200	1.2 X R0.3	1.4	20	50	4		4CREG 020 002 350	2 X R0.2	2.4	35	70	4	
4CREG 015 001 060	1.5 X R0.1	1.8	6	45	4		4CREG 020 003 060	2 X R0.3	2.4	6	45	4	

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
4CREG 020 003 080	2 X R0.3	2.4	8	45	4		4CREG 030 005 250	3 X R0.5	3.6	25	65	6	
4CREG 020 003 100	2 X R0.3	2.4	10	50	4		4CREG 030 005 300	3 X R0.5	3.6	30	70	6	
4CREG 020 003 120	2 X R0.3	2.4	12	50	4		4CREG 030 005 350	3 X R0.5	3.6	35	75	6	
4CREG 020 003 160	2 X R0.3	2.4	16	50	4		4CREG 030 005 400	3 X R0.5	3.6	40	80	6	
4CREG 020 003 200	2 X R0.3	2.4	20	50	4		4CREG 030 005 500	3 X R0.5	3.6	50	100	6	
4CREG 020 003 250	2 X R0.3	2.4	25	60	4		4CREG 030 010 100	3 X R1	3.6	10	50	6	
4CREG 020 003 300	2 X R0.3	2.4	30	70	4		4CREG 030 010 160	3 X R1	3.6	16	55	6	
4CREG 020 003 350	2 X R0.3	2.4	35	70	4		4CREG 030 010 200	3 X R1	3.6	20	60	6	
4CREG 020 005 060	2 X R0.5	2.4	6	45	4		4CREG 030 010 250	3 X R1	3.6	25	65	6	
4CREG 020 005 080	2 X R0.5	2.4	8	45	4		4CREG 030 010 300	3 X R1	3.6	30	70	6	
4CREG 020 005 100	2 X R0.5	2.4	10	50	4		4CREG 030 010 350	3 X R1	3.6	35	75	6	
4CREG 020 005 120	2 X R0.5	2.4	12	50	4		4CREG 030 010 400	3 X R1	3.6	40	80	6	
4CREG 020 005 160	2 X R0.5	2.4	16	50	4		4CREG 030 010 500	3 X R1	3.6	50	100	6	
4CREG 020 005 200	2 X R0.5	2.4	20	50	4		4CREG 040 001 050	4 X R0.1	4.8	12	50	4	
4CREG 020 005 250	2 X R0.5	2.4	25	60	4		4CREG 040 001 070	4 X R0.1	4.8	20	70	4	
4CREG 020 005 300	2 X R0.5	2.4	30	70	4		4CREG 040 001 120	4 X R0.1	4.8	12	50	6	
4CREG 020 005 350	2 X R0.5	2.4	35	70	4		4CREG 040 001 160	4 X R0.1	4.8	16	55	6	
4CREG 025 001 100	2.5 X R0.1	3	10	50	4		4CREG 040 001 200	4 X R0.1	4.8	20	60	6	
4CREG 025 001 160	2.5 X R0.1	3	16	50	4		4CREG 040 001 250	4 X R0.1	4.8	25	65	6	
4CREG 025 001 200	2.5 X R0.1	3	20	50	4		4CREG 040 001 300	4 X R0.1	4.8	30	70	6	
4CREG 025 001 250	2.5 X R0.1	3	25	60	4		4CREG 040 001 350	4 X R0.1	4.8	35	75	6	
4CREG 025 001 300	2.5 X R0.1	3	30	70	4		4CREG 040 001 400	4 X R0.1	4.8	40	80	6	
4CREG 025 002 100	2.5 X R0.2	3	10	50	4		4CREG 040 001 450	4 X R0.1	4.8	45	90	6	
4CREG 025 002 160	2.5 X R0.2	3	16	50	4		4CREG 040 001 500	4 X R0.1	4.8	50	100	6	
4CREG 025 002 200	2.5 X R0.2	3	20	50	4		4CREG 040 002 050	4 X R0.2	4.8	12	50	4	
4CREG 025 002 250	2.5 X R0.2	3	25	60	4		4CREG 040 002 070	4 X R0.2	4.8	20	70	4	
4CREG 025 002 300	2.5 X R0.2	3	30	70	4		4CREG 040 002 120	4 X R0.2	4.8	12	50	6	
4CREG 025 003 100	2.5 X R0.3	3	10	50	4		4CREG 040 002 160	4 X R0.2	4.8	16	55	6	
4CREG 025 003 160	2.5 X R0.3	3	16	50	4		4CREG 040 002 200	4 X R0.2	4.8	20	60	6	
4CREG 025 003 200	2.5 X R0.3	3	20	50	4		4CREG 040 002 250	4 X R0.2	4.8	25	65	6	
4CREG 025 003 250	2.5 X R0.3	3	25	60	4		4CREG 040 002 300	4 X R0.2	4.8	30	70	6	
4CREG 025 003 300	2.5 X R0.3	3	30	70	4		4CREG 040 002 350	4 X R0.2	4.8	35	75	6	
4CREG 025 005 100	2.5 X R0.5	3	10	50	4		4CREG 040 002 400	4 X R0.2	4.8	40	80	6	
4CREG 025 005 160	2.5 X R0.5	3	16	50	4		4CREG 040 002 450	4 X R0.2	4.8	45	90	6	
4CREG 025 005 200	2.5 X R0.5	3	20	50	4		4CREG 040 002 500	4 X R0.2	4.8	50	100	6	
4CREG 025 005 250	2.5 X R0.5	3	25	60	4		4CREG 040 003 050	4 X R0.3	4.8	12	50	4	
4CREG 025 005 300	2.5 X R0.5	3	30	70	4		4CREG 040 003 070	4 X R0.3	4.8	20	70	4	
4CREG 030 001 100	3 X R0.1	3.6	10	50	6		4CREG 040 003 120	4 X R0.3	4.8	12	50	6	
4CREG 030 001 160	3 X R0.1	3.6	16	55	6		4CREG 040 003 160	4 X R0.3	4.8	16	55	6	
4CREG 030 001 200	3 X R0.1	3.6	20	60	6		4CREG 040 003 200	4 X R0.3	4.8	20	60	6	
4CREG 030 001 250	3 X R0.1	3.6	25	65	6		4CREG 040 003 250	4 X R0.3	4.8	25	65	6	
4CREG 030 001 300	3 X R0.1	3.6	30	70	6		4CREG 040 003 300	4 X R0.3	4.8	30	70	6	
4CREG 030 001 350	3 X R0.1	3.6	35	75	6		4CREG 040 003 350	4 X R0.3	4.8	35	75	6	
4CREG 030 001 400	3 X R0.1	3.6	40	80	6		4CREG 040 003 400	4 X R0.3	4.8	40	80	6	
4CREG 030 001 500	3 X R0.1	3.6	50	100	6		4CREG 040 003 450	4 X R0.3	4.8	45	90	6	
4CREG 030 002 100	3 X R0.2	3.6	10	50	6		4CREG 040 003 500	4 X R0.3	4.8	50	100	6	
4CREG 030 002 160	3 X R0.2	3.6	16	55	6		4CREG 040 005 050	4 X R0.5	4.8	12	50	4	
4CREG 030 002 200	3 X R0.2	3.6	20	60	6		4CREG 040 005 070	4 X R0.5	4.8	20	70	4	
4CREG 030 002 250	3 X R0.2	3.6	25	65	6		4CREG 040 005 120	4 X R0.5	4.8	12	50	6	
4CREG 030 002 300	3 X R0.2	3.6	30	70	6		4CREG 040 005 160	4 X R0.5	4.8	16	55	6	
4CREG 030 002 350	3 X R0.2	3.6	35	75	6		4CREG 040 005 200	4 X R0.5	4.8	20	60	6	
4CREG 030 002 400	3 X R0.2	3.6	40	80	6		4CREG 040 005 250	4 X R0.5	4.8	25	65	6	
4CREG 030 002 500	3 X R0.2	3.6	50	100	6		4CREG 040 005 300	4 X R0.5	4.8	30	70	6	
4CREG 030 003 100	3 X R0.3	3.6	10	50	6		4CREG 040 005 350	4 X R0.5	4.8	35	75	6	
4CREG 030 003 160	3 X R0.3	3.6	16	55	6		4CREG 040 005 400	4 X R0.5	4.8	40	80	6	
4CREG 030 003 200	3 X R0.3	3.6	20	60	6		4CREG 040 005 450	4 X R0.5	4.8	45	90	6	
4CREG 030 003 250	3 X R0.3	3.6	25	65	6		4CREG 040 005 500	4 X R0.5	4.8	50	100	6	
4CREG 030 003 300	3 X R0.3	3.6	30	70	6		4CREG 040 010 050	4 X R1	4.8	12	50	4	
4CREG 030 003 350	3 X R0.3	3.6	35	75	6		4CREG 040 010 070	4 X R1	4.8	20	70	4	
4CREG 030 003 400	3 X R0.3	3.6	40	80	6		4CREG 040 010 120	4 X R1	4.8	12	50	6	
4CREG 030 003 500	3 X R0.3	3.6	50	100	6		4CREG 040 010 160	4 X R1	4.8	16	55	6	
4CREG 030 005 100	3 X R0.5	3.6	10	50	6		4CREG 040 010 200	4 X R1	4.8	20	60	6	
4CREG 030 005 160	3 X R0.5	3.6	16	55	6		4CREG 040 010 250	4 X R1	4.8	25	65	6	
4CREG 030 005 200	3 X R0.5	3.6	20	60	6		4CREG 040 010 300	4 X R1	4.8	30	70	6	

단위 : mm

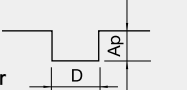
Order Number	날경 D×R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샙크 Dia d	비고	Order Number	날경 D×R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샙크 Dia d	비고
4CREG 040 010 350	4 X R1	4.8	35	75	6		4CREG 120 010 260	12 X R1	13	26	80	12	
4CREG 040 010 400	4 X R1	4.8	40	80	6		4CREG 120 010 400	12 X R1	13	40	110	12	
4CREG 040 010 450	4 X R1	4.8	45	90	6		4CREG 120 015 260	12 X R1.5	13	26	80	12	
4CREG 040 010 500	4 X R1	4.8	50	100	6		4CREG 120 015 400	12 X R1.5	13	40	110	12	
4CREG 050 001 150	5 X R0.1	6	15	55	6		4CREG 120 020 260	12 X R2	13	26	80	12	
4CREG 050 001 300	5 X R0.1	6	30	70	6		4CREG 120 030 260	12 X R3	13	26	80	12	
4CREG 050 001 400	5 X R0.1	6	40	80	6								
4CREG 050 001 500	5 X R0.1	6	50	100	6								
4CREG 050 002 150	5 X R0.2	6	15	55	6								
4CREG 050 002 300	5 X R0.2	6	30	70	6								
4CREG 050 002 400	5 X R0.2	6	40	80	6								
4CREG 050 002 500	5 X R0.2	6	50	100	6								
4CREG 050 003 150	5 X R0.3	6	15	55	6								
4CREG 050 003 300	5 X R0.3	6	30	70	6								
4CREG 050 003 400	5 X R0.3	6	40	80	6								
4CREG 050 003 500	5 X R0.3	6	50	100	6								
4CREG 050 005 150	5 X R0.5	6	15	55	6								
4CREG 050 005 300	5 X R0.5	6	30	70	6								
4CREG 050 005 400	5 X R0.5	6	40	80	6								
4CREG 050 005 500	5 X R0.5	6	50	100	6								
4CREG 050 010 150	5 X R1	6	15	55	6								
4CREG 050 010 300	5 X R1	6	30	70	6								
4CREG 050 010 400	5 X R1	6	40	80	6								
4CREG 050 010 500	5 X R1	6	50	100	6								
4CREG 060 001 200	6 X R0.1	7	20	60	6								
4CREG 060 001 400	6 X R0.1	7	40	80	6								
4CREG 060 001 500	6 X R0.1	7	50	100	6								
4CREG 060 002 200	6 X R0.2	7	20	60	6								
4CREG 060 002 400	6 X R0.2	7	40	80	6								
4CREG 060 002 500	6 X R0.2	7	50	100	6								
4CREG 060 003 200	6 X R0.3	7	20	60	6								
4CREG 060 003 400	6 X R0.3	7	40	80	6								
4CREG 060 003 500	6 X R0.3	7	50	100	6								
4CREG 060 005 200	6 X R0.5	7	20	60	6								
4CREG 060 005 400	6 X R0.5	7	40	80	6								
4CREG 060 005 500	6 X R0.5	7	50	100	6								
4CREG 060 010 200	6 X R1	7	20	60	6								
4CREG 060 010 400	6 X R1	7	40	80	6								
4CREG 060 010 500	6 X R1	7	50	100	6								
4CREG 060 015 200	6 X R1.5	7	20	60	6								
4CREG 060 015 400	6 X R1.5	7	40	80	6								
4CREG 060 015 500	6 X R1.5	7	50	100	6								
4CREG 080 002 220	8 X R0.2	9	22	65	8								
4CREG 080 003 220	8 X R0.3	9	22	65	8								
4CREG 080 005 220	8 X R0.5	9	22	65	8								
4CREG 080 005 400	8 X R0.5	9	40	100	8								
4CREG 080 010 220	8 X R1	9	22	65	8								
4CREG 080 010 400	8 X R1	9	40	100	8								
4CREG 080 015 220	8 X R1.5	9	22	65	8								
4CREG 080 015 400	8 X R1.5	9	40	100	8								
4CREG 080 020 220	8 X R2	9	22	65	8								
4CREG 100 002 240	10 X R0.2	11	24	70	10								
4CREG 100 003 240	10 X R0.3	11	24	70	10								
4CREG 100 005 240	10 X R0.5	11	24	70	10								
4CREG 100 005 400	10 X R0.5	11	40	100	10								
4CREG 100 010 240	10 X R1	11	24	70	10								
4CREG 100 010 400	10 X R1	11	40	100	10								
4CREG 100 015 240	10 X R1.5	11	24	70	10								
4CREG 100 015 400	10 X R1.5	11	40	100	10								
4CREG 100 020 240	10 X R2	11	24	70	10								
4CREG 100 025 240	10 X R2.5	11	24	70	10								
4CREG 120 003 260	12 X R0.3	13	26	80	12								
4CREG 120 005 260	12 X R0.5	13	26	80	12								
4CREG 120 005 400	12 X R0.5	13	40	110	12								

G series

피삭재 Material		공구강/금형강 Tool steels / Mold steels SCM/HPM				합금강/프리하든강 Alloy Steels / Pre-hardened Steels NAK80 / KP4M				고경도강 Hardened Steels STAVX / SKD11			
경도 Hardness		30 ~ 40HRc				40 ~ 45HRc				45 ~ 55HRc			
외경 Outside Diameter	유효장 Effective Length	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
∅ 1	4	13,110	1,884	0.216	0.435	13,110	700	0.038	0.290	13,000	650	0.032	0.290
"	10	8,194	727	0.052	0.339	8,194	404	0.014	0.135	7,101	343	0.012	0.135
∅ 1.2	4	12,500	1,346	0.200	0.503	8,740	950	0.024	0.097	12,500	750	0.019	0.097
"	10	8,000	861	0.058	0.435	6,337	650	0.009	0.077	5,681	389	0.008	0.077
∅ 1.5	6	12,236	2,503	0.323	0.726	12,236	1,390	0.065	0.484	11,144	900	0.048	0.484
"	12	7,866	1,722	0.161	0.610	7,866	957	0.045	0.310	7,211	822	0.034	0.310
∅ 2	6	11,908	2,341	0.345	0.919	11,908	1,301	0.065	0.871	11,144	1,181	0.046	0.871
"	12	8,740	1,884	0.200	0.774	8,740	1,047	0.047	0.484	7,866	942	0.033	0.484
∅ 2.5	10	9,833	2,341	0.365	0.919	9,833	1,301	0.081	0.581	9,286	1,226	0.056	0.581
"	20	5,900	1,023	0.074	0.677	5,900	568	0.017	0.194	5,572	538	0.012	0.194
∅ 3	10	9,833	2,637	0.419	0.914	9,833	1,465	0.113	0.720	9,286	1,136	0.113	0.678
"	20	7,757	2,018	0.280	0.839	5,748	1,121	0.078	0.624	3,249	867	0.078	0.624
∅ 4	12	8,303	2,476	0.441	1.677	8,303	1,375	0.129	1.237	6,992	1,196	0.089	1.237
"	20	6,446	1,895	0.413	1.457	5,586	1,053	0.086	0.968	5,463	1,091	0.058	0.968
"	30	5,463	978	0.215	1.331	2,803	543	0.046	0.738	2,413	852	0.031	0.738
∅ 6	20	5,681	2,852	0.660	2.414	5,187	1,585	0.524	1.491	3,387	1,346	0.205	1.491
"	40	4,370	2,126	0.622	2.254	2,261	1,181	0.451	1.435	2,052	987	0.180	1.435
∅ 8	22	5,244	2,530	0.581	2.796	5,244	1,405	0.461	1.670	3,059	1,181	0.180	1.670
∅ 10	24	4,370	2,153	0.494	3.175	4,261	1,196	0.392	1.809	2,622	1,002	0.153	1.809
∅ 12	26	3,605	1,803	0.415	3.314	3,605	1,002	0.329	2.226	2,185	837	0.129	2.226

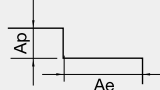
절입량
Depth of Cut

Slotting
• Ap : Axial Depth
• D : Outside Diameter




Side Milling

• Ap : Axial Depth
• Ae : Radial Depth



경사진면절삭
Inclined Cutting



- HRC52 이상인 경우 같은 직경의 같은 비율로 20% DOWN 시켜 주십시오.
- 유효장이 긴 경우에는 회전수와 이송속도를 최대30% 이하로 줄이십시오.
- Ae 값 설정시 코너R 치수를 고려해 주십시오.
- 곡면 절삭시 날경의 코너R 보다 낮은 이동 PITCH를 설정 하십시오.
- 곡면 절삭시 안정적인 속도 내에서 피드를 최대 30%까지 UP 해주십시오.
- When milling workpiece HRC over 52 hardened steel , reduce 20% of the RPM and feed compared to the same diameter.
- If the effective length is long, reduce the RPM and feed maximum 30%.
- Consider the corner radius value when you set up the Ae value.
- For curved milling, set up the lower value of the pitch than the corner radius value of tool diameter.
- For curved milling, raise up the feed up to 30% in stable milling condition.