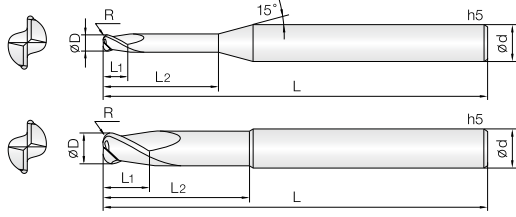


2CREG 2 Flutes Rib Corner Radius End Mills for Multi Purpose

2날 범용 리브 코너 레디우스 엔드밀



- 중저경도강(HRc52이하), 프리하드강 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.

2

WC
미립자

JCRO
Coating

R
±0.005

R
±0.01

R
±0.015

35°
Helix Angle

CUTTING
DATA

R0.02 ~ 0.5 R1 ~ 1.5 R2 ~ 3 460P

Condition	D Size	D Tolerance
ØD ≠ Ød	Ø0.2 ~ 16	+0 ~ -0.01mm

Condition	D Size	D Tolerance
ØD = Ød	Ø4 - 12	-0.005 ~ -0.015mm
	Ø16	-0.01 ~ -0.02mm

단위 : mm

Order Number	날경 D × R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샙크 Shank Dia d	비고	Order Number	날경 D × R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샙크 Shank Dia d	비고
2CREG 002 0002 010	0.2 X R0.02	0.2	1	40	4		2CREG 008 002 040	0.8 X R0.2	0.9	4	45	4	
2CREG 002 0002 015	0.2 X R0.02	0.2	1.5	40	4		2CREG 008 002 060	0.8 X R0.2	0.9	6	45	4	
2CREG 002 0005 010	0.2 X R0.05	0.2	1	40	4		2CREG 008 002 080	0.8 X R0.2	0.9	8	45	4	
2CREG 002 0005 015	0.2 X R0.05	0.2	1.5	40	4		2CREG 010 001 040	1 X R0.1	1.2	4	45	4	
2CREG 003 0005 010	0.3 X R0.05	0.3	1	40	4		2CREG 010 001 060	1 X R0.1	1.2	6	45	4	
2CREG 003 0005 020	0.3 X R0.05	0.3	2	40	4		2CREG 010 001 080	1 X R0.1	1.2	8	45	4	
2CREG 003 0005 030	0.3 X R0.05	0.3	3	40	4		2CREG 010 001 100	1 X R0.1	1.2	10	50	4	
2CREG 004 0005 010	0.4 X R0.05	0.5	1	40	4		2CREG 010 001 120	1 X R0.1	1.2	12	50	4	
2CREG 004 0005 020	0.4 X R0.05	0.5	2	40	4		2CREG 010 001 160	1 X R0.1	1.2	16	50	4	
2CREG 004 0005 030	0.4 X R0.05	0.5	3	40	4		2CREG 010 001 200	1 X R0.1	1.2	20	50	4	
2CREG 004 0005 040	0.4 X R0.05	0.5	4	40	4		2CREG 010 002 040	1 X R0.2	1.2	4	45	4	
2CREG 004 001 010	0.4 X R0.1	0.5	1	40	4		2CREG 010 002 060	1 X R0.2	1.2	6	45	4	
2CREG 004 001 015	0.4 X R0.1	0.5	1.5	40	4		2CREG 010 002 080	1 X R0.2	1.2	8	45	4	
2CREG 004 001 020	0.4 X R0.1	0.5	2	40	4		2CREG 010 002 100	1 X R0.2	1.2	10	50	4	
2CREG 004 001 030	0.4 X R0.1	0.5	3	40	4		2CREG 010 002 120	1 X R0.2	1.2	12	50	4	
2CREG 004 001 040	0.4 X R0.1	0.5	4	40	4		2CREG 010 002 160	1 X R0.2	1.2	16	50	4	
2CREG 005 0005 010	0.5 X R0.05	0.6	1	45	4		2CREG 010 002 200	1 X R0.2	1.2	20	50	4	
2CREG 005 0005 015	0.5 X R0.05	0.6	1.5	45	4		2CREG 010 003 040	1 X R0.3	1.2	4	45	4	
2CREG 005 0005 020	0.5 X R0.05	0.6	2	45	4		2CREG 010 003 060	1 X R0.3	1.2	6	45	4	
2CREG 005 0005 025	0.5 X R0.05	0.6	2.5	45	4		2CREG 010 003 080	1 X R0.3	1.2	8	45	4	
2CREG 005 0005 030	0.5 X R0.05	0.6	3	45	4		2CREG 010 003 100	1 X R0.3	1.2	10	50	4	
2CREG 005 0005 040	0.5 X R0.05	0.6	4	45	4		2CREG 010 003 120	1 X R0.3	1.2	12	50	4	
2CREG 005 0005 050	0.5 X R0.05	0.6	5	45	4		2CREG 010 003 160	1 X R0.3	1.2	16	50	4	
2CREG 005 0005 060	0.5 X R0.05	0.6	6	45	4		2CREG 010 003 200	1 X R0.3	1.2	20	50	4	
2CREG 005 001 010	0.5 X R0.1	0.6	1	45	4		2CREG 012 001 040	1.2 X R0.1	1.4	4	45	4	
2CREG 005 001 015	0.5 X R0.1	0.6	1.5	45	4		2CREG 012 001 060	1.2 X R0.1	1.4	6	45	4	
2CREG 005 001 020	0.5 X R0.1	0.6	2	45	4		2CREG 012 001 080	1.2 X R0.1	1.4	8	45	4	
2CREG 005 001 025	0.5 X R0.1	0.6	2.5	45	4		2CREG 012 001 100	1.2 X R0.1	1.4	10	50	4	
2CREG 005 001 030	0.5 X R0.1	0.6	3	45	4		2CREG 012 001 120	1.2 X R0.1	1.4	12	50	4	
2CREG 005 001 040	0.5 X R0.1	0.6	4	45	4		2CREG 012 001 160	1.2 X R0.1	1.4	16	50	4	
2CREG 005 001 050	0.5 X R0.1	0.6	5	45	4		2CREG 012 001 200	1.2 X R0.1	1.4	20	50	4	
2CREG 005 001 060	0.5 X R0.1	0.6	6	45	4		2CREG 012 002 040	1.2 X R0.2	1.4	4	45	4	
2CREG 006 0005 020	0.6 X R0.05	0.7	2	45	4		2CREG 012 002 060	1.2 X R0.2	1.4	6	45	4	
2CREG 006 0005 030	0.6 X R0.05	0.7	3	45	4		2CREG 012 002 080	1.2 X R0.2	1.4	8	45	4	
2CREG 006 0005 040	0.6 X R0.05	0.7	4	45	4		2CREG 012 002 100	1.2 X R0.2	1.4	10	50	4	
2CREG 006 0005 060	0.6 X R0.05	0.7	6	45	4		2CREG 012 002 120	1.2 X R0.2	1.4	12	50	4	
2CREG 006 0005 080	0.6 X R0.05	0.7	8	45	4		2CREG 012 002 160	1.2 X R0.2	1.4	16	50	4	
2CREG 006 001 020	0.6 X R0.1	0.7	2	45	4		2CREG 012 002 200	1.2 X R0.2	1.4	20	50	4	
2CREG 006 001 030	0.6 X R0.1	0.7	3	45	4		2CREG 012 003 040	1.2 X R0.3	1.4	4	45	4	
2CREG 006 001 040	0.6 X R0.1	0.7	4	45	4		2CREG 012 003 060	1.2 X R0.3	1.4	6	45	4	
2CREG 006 001 060	0.6 X R0.1	0.7	6	45	4		2CREG 012 003 080	1.2 X R0.3	1.4	8	45	4	
2CREG 006 001 080	0.6 X R0.1	0.7	8	45	4		2CREG 012 003 100	1.2 X R0.3	1.4	10	50	4	
2CREG 007 001 020	0.7 X R0.1	0.8	2	45	4		2CREG 012 003 120	1.2 X R0.3	1.4	12	50	4	
2CREG 007 001 040	0.7 X R0.1	0.8	4	45	4		2CREG 012 003 160	1.2 X R0.3	1.4	16	50	4	
2CREG 007 001 060	0.7 X R0.1	0.8	6	45	4		2CREG 012 003 200	1.2 X R0.3	1.4	20	50	4	
2CREG 008 001 020	0.8 X R0.1	0.9	2	45	4		2CREG 015 001 040	1.5 X R0.1	1.8	4	45	4	
2CREG 008 001 040	0.8 X R0.1	0.9	4	45	4		2CREG 015 001 060	1.5 X R0.1	1.8	6	45	4	
2CREG 008 001 060	0.8 X R0.1	0.9	6	45	4		2CREG 015 001 080	1.5 X R0.1	1.8	8	45	4	
2CREG 008 001 080	0.8 X R0.1	0.9	8	45	4		2CREG 015 001 100	1.5 X R0.1	1.8	10	50	4	
2CREG 008 002 020	0.8 X R0.2	0.9	2	45	4		2CREG 015 001 120	1.5 X R0.1	1.8	12	50	4	

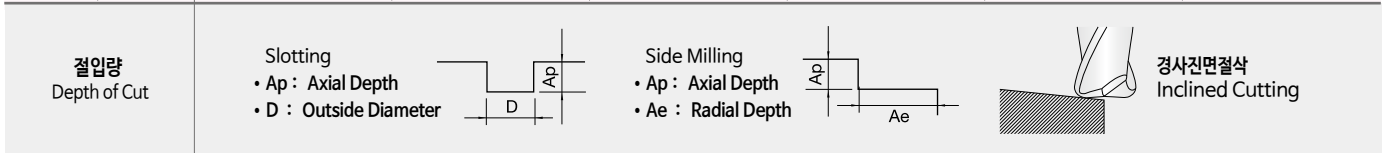
G series

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
2CREG 015 001 160	1.5 X R0.1	1.8	16	50	4		2CREG 025 001 160	2.5 X R0.1	3	16	50	4	
2CREG 015 001 200	1.5 X R0.1	1.8	20	50	4		2CREG 025 001 200	2.5 X R0.1	3	20	50	4	
2CREG 015 001 220	1.5 X R0.1	1.8	22	60	4		2CREG 025 001 250	2.5 X R0.1	3	25	60	4	
2CREG 015 001 250	1.5 X R0.1	1.8	25	60	4		2CREG 025 001 300	2.5 X R0.1	3	30	70	4	
2CREG 015 002 040	1.5 X R0.2	1.8	4	45	4		2CREG 025 002 100	2.5 X R0.2	3	10	50	4	
2CREG 015 002 060	1.5 X R0.2	1.8	6	45	4		2CREG 025 002 160	2.5 X R0.2	3	16	50	4	
2CREG 015 002 080	1.5 X R0.2	1.8	8	45	4		2CREG 025 002 200	2.5 X R0.2	3	20	50	4	
2CREG 015 002 100	1.5 X R0.2	1.8	10	50	4		2CREG 025 002 250	2.5 X R0.2	3	25	60	4	
2CREG 015 002 120	1.5 X R0.2	1.8	12	50	4		2CREG 025 002 300	2.5 X R0.2	3	30	70	4	
2CREG 015 002 160	1.5 X R0.2	1.8	16	50	4		2CREG 025 003 100	2.5 X R0.3	3	10	50	4	
2CREG 015 002 200	1.5 X R0.2	1.8	20	50	4		2CREG 025 003 160	2.5 X R0.3	3	16	50	4	
2CREG 015 002 220	1.5 X R0.2	1.8	22	60	4		2CREG 025 003 200	2.5 X R0.3	3	20	50	4	
2CREG 015 002 250	1.5 X R0.2	1.8	25	60	4		2CREG 025 003 250	2.5 X R0.3	3	25	60	4	
2CREG 015 003 040	1.5 X R0.3	1.8	4	45	4		2CREG 025 003 300	2.5 X R0.3	3	30	70	4	
2CREG 015 003 060	1.5 X R0.3	1.8	6	45	4		2CREG 025 005 100	2.5 X R0.5	3	10	50	4	
2CREG 015 003 080	1.5 X R0.3	1.8	8	45	4		2CREG 025 005 160	2.5 X R0.5	3	16	50	4	
2CREG 015 003 100	1.5 X R0.3	1.8	10	50	4		2CREG 025 005 200	2.5 X R0.5	3	20	50	4	
2CREG 015 003 120	1.5 X R0.3	1.8	12	50	4		2CREG 025 005 250	2.5 X R0.5	3	25	60	4	
2CREG 015 003 160	1.5 X R0.3	1.8	16	50	4		2CREG 025 005 300	2.5 X R0.5	3	30	70	4	
2CREG 015 003 200	1.5 X R0.3	1.8	20	50	4		2CREG 030 001 100	3 X R0.1	3.6	10	50	6	
2CREG 015 003 220	1.5 X R0.3	1.8	22	60	4		2CREG 030 001 120	3 X R0.1	3.6	12	50	6	
2CREG 015 003 250	1.5 X R0.3	1.8	25	60	4		2CREG 030 001 160	3 X R0.1	3.6	16	55	6	
2CREG 015 005 040	1.5 X R0.5	1.8	4	45	4		2CREG 030 001 200	3 X R0.1	3.6	20	60	6	
2CREG 015 005 060	1.5 X R0.5	1.8	6	45	4		2CREG 030 001 250	3 X R0.1	3.6	25	65	6	
2CREG 015 005 080	1.5 X R0.5	1.8	8	45	4		2CREG 030 001 300	3 X R0.1	3.6	30	70	6	
2CREG 015 005 100	1.5 X R0.5	1.8	10	50	4		2CREG 030 001 350	3 X R0.1	3.6	35	75	6	
2CREG 015 005 120	1.5 X R0.5	1.8	12	50	4		2CREG 030 001 400	3 X R0.1	3.6	40	80	6	
2CREG 015 005 160	1.5 X R0.5	1.8	16	50	4		2CREG 030 002 100	3 X R0.2	3.6	10	50	6	
2CREG 015 005 200	1.5 X R0.5	1.8	20	50	4		2CREG 030 002 120	3 X R0.2	3.6	12	50	6	
2CREG 015 005 220	1.5 X R0.5	1.8	22	60	4		2CREG 030 002 160	3 X R0.2	3.6	16	55	6	
2CREG 015 005 250	1.5 X R0.5	1.8	25	60	4		2CREG 030 002 200	3 X R0.2	3.6	20	60	6	
2CREG 020 001 060	2 X R0.1	2.4	6	45	4		2CREG 030 002 250	3 X R0.2	3.6	25	65	6	
2CREG 020 001 080	2 X R0.1	2.4	8	45	4		2CREG 030 002 300	3 X R0.2	3.6	30	70	6	
2CREG 020 001 100	2 X R0.1	2.4	10	50	4		2CREG 030 002 350	3 X R0.2	3.6	35	75	6	
2CREG 020 001 120	2 X R0.1	2.4	12	50	4		2CREG 030 002 400	3 X R0.2	3.6	40	80	6	
2CREG 020 001 160	2 X R0.1	2.4	16	50	4		2CREG 030 003 100	3 X R0.3	3.6	10	50	6	
2CREG 020 001 200	2 X R0.1	2.4	20	50	4		2CREG 030 003 120	3 X R0.3	3.6	12	50	6	
2CREG 020 001 250	2 X R0.1	2.4	25	60	4		2CREG 030 003 160	3 X R0.3	3.6	16	55	6	
2CREG 020 001 300	2 X R0.1	2.4	30	70	4		2CREG 030 003 200	3 X R0.3	3.6	20	60	6	
2CREG 020 002 060	2 X R0.2	2.4	6	45	4		2CREG 030 003 250	3 X R0.3	3.6	25	65	6	
2CREG 020 002 080	2 X R0.2	2.4	8	45	4		2CREG 030 003 300	3 X R0.3	3.6	30	70	6	
2CREG 020 002 100	2 X R0.2	2.4	10	50	4		2CREG 030 003 350	3 X R0.3	3.6	35	75	6	
2CREG 020 002 120	2 X R0.2	2.4	12	50	4		2CREG 030 003 400	3 X R0.3	3.6	40	80	6	
2CREG 020 002 160	2 X R0.2	2.4	16	50	4		2CREG 030 005 100	3 X R0.5	3.6	10	50	6	
2CREG 020 002 200	2 X R0.2	2.4	20	50	4		2CREG 030 005 120	3 X R0.5	3.6	12	50	6	
2CREG 020 002 250	2 X R0.2	2.4	25	60	4		2CREG 030 005 160	3 X R0.5	3.6	16	55	6	
2CREG 020 002 300	2 X R0.2	2.4	30	70	4		2CREG 030 005 200	3 X R0.5	3.6	20	60	6	
2CREG 020 003 060	2 X R0.3	2.4	6	45	4		2CREG 030 005 250	3 X R0.5	3.6	25	65	6	
2CREG 020 003 080	2 X R0.3	2.4	8	45	4		2CREG 030 005 300	3 X R0.5	3.6	30	70	6	
2CREG 020 003 100	2 X R0.3	2.4	10	50	4		2CREG 030 005 350	3 X R0.5	3.6	35	75	6	
2CREG 020 003 120	2 X R0.3	2.4	12	50	4		2CREG 030 005 400	3 X R0.5	3.6	40	80	6	
2CREG 020 003 160	2 X R0.3	2.4	16	50	4		2CREG 030 010 100	3 X R1	3.6	10	50	6	
2CREG 020 003 200	2 X R0.3	2.4	20	50	4		2CREG 030 010 120	3 X R1	3.6	12	50	6	
2CREG 020 003 250	2 X R0.3	2.4	25	60	4		2CREG 030 010 160	3 X R1	3.6	16	55	6	
2CREG 020 003 300	2 X R0.3	2.4	30	70	4		2CREG 030 010 200	3 X R1	3.6	20	60	6	
2CREG 020 005 060	2 X R0.5	2.4	6	45	4		2CREG 030 010 250	3 X R1	3.6	25	65	6	
2CREG 020 005 080	2 X R0.5	2.4	8	45	4		2CREG 030 010 300	3 X R1	3.6	30	70	6	
2CREG 020 005 100	2 X R0.5	2.4	10	50	4		2CREG 030 010 350	3 X R1	3.6	35	75	6	
2CREG 020 005 120	2 X R0.5	2.4	12	50	4		2CREG 030 010 400	3 X R1	3.6	40	80	6	
2CREG 020 005 160	2 X R0.5	2.4	16	50	4		2CREG 040 001 050	4 X R0.1	4.8	12	50	4	
2CREG 020 005 200	2 X R0.5	2.4	20	50	4		2CREG 040 001 070	4 X R0.1	4.8	20	70	4	
2CREG 020 005 250	2 X R0.5	2.4	25	60	4		2CREG 040 001 120	4 X R0.1	4.8	12	50	6	
2CREG 020 005 300	2 X R0.5	2.4	30	70	4		2CREG 040 001 160	4 X R0.1	4.8	16	55	6	
2CREG 025 001 100	2.5 X R0.1	3	10	50	4		2CREG 040 001 200	4 X R0.1	4.8	20	60	6	

G series

피삭재 Material		동 합금 Copper alloys C1100				합금강 / 프리하드강 Alloy Steels / Prehardened Steels NAK80/KP4M				고경도강 Hardened Steels STAVAX/SKD11			
경도 Hardness		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
∅ 0.2	1	50,000	352	0.016	0.020	50,000	264	0.006	0.020	34,500	211	0.004	0.020
"	1.5	50,000	311	0.017	0.010	50,000	233	0.005	0.010	26,450	186	0.003	0.010
∅ 0.3	1	50,000	890	0.029	0.020	50,000	668	0.007	0.020	34,500	534	0.005	0.015
"	3	50,000	393	0.029	0.015	50,000	295	0.006	0.015	24,150	236	0.003	0.010
∅ 0.4	1	47,150	890	0.047	0.062	50,000	668	0.013	0.070	39,675	534	0.011	0.070
"	3	33,350	683	0.026	0.053	26,450	512	0.008	0.026	26,450	410	0.007	0.026
∅ 0.5	1	48,300	2,008	0.079	0.114	48,300	668	0.033	0.119	39,100	534	0.029	0.119
"	3	31,050	1,118	0.056	0.088	31,050	525	0.022	0.110	25,415	420	0.020	0.110
"	5	25,760	827	0.026	0.044	25,760	510	0.011	0.010	20,700	408	0.010	0.010
∅ 0.6	2	27,945	890	0.111	0.158	27,945	668	0.010	0.214	23,000	534	0.010	0.214
"	6	16,445	435	0.035	0.044	16,445	326	0.003	0.010	13,570	261	0.003	0.010
∅ 0.8	4	17,250	787	0.129	0.194	17,020	590	0.014	0.114	14,720	472	0.015	0.114
"	8	12,650	475	0.029	0.098	12,650	264	0.005	0.088	10,695	184	0.004	0.088
∅ 1	4	13,800	1,449	0.196	0.396	13,800	805	0.034	0.264	11,730	655	0.029	0.264
"	10	8,625	559	0.047	0.308	8,625	311	0.013	0.123	7,475	264	0.011	0.123
"	16	6,900	331	0.018	0.220	6,900	184	0.005	0.026	5,980	161	0.004	0.026
∅ 1.2	6	9,200	1,035	0.182	0.457	9,200	575	0.021	0.088	8,165	483	0.018	0.088
"	12	6,670	662	0.053	0.396	6,670	368	0.010	0.070	5,980	299	0.007	0.070
∅ 1.5	4	12,880	1,925	0.293	0.660	12,880	1,070	0.059	0.440	11,730	920	0.044	0.440
"	10	8,280	1,325	0.147	0.554	8,280	736	0.041	0.282	7,590	633	0.031	0.282
"	20	5,865	725	0.041	0.352	6,350	403	0.006	0.106	4,160	345	0.005	0.106
∅ 2	6	12,535	1,801	0.314	0.836	12,535	1,001	0.059	0.792	11,730	909	0.042	0.792
"	12	9,200	1,449	0.182	0.704	9,200	805	0.043	0.440	8,280	725	0.030	0.440
"	20	6,900	1,139	0.091	0.651	6,200	633	0.023	0.194	3,520	564	0.017	0.194
"	30	5,865	973	0.049	0.440	3,300	541	0.005	0.132	2,860	495	0.005	0.132
∅ 2.5	10	10,350	1,801	0.331	0.836	10,350	1,001	0.073	0.528	9,775	943	0.051	0.528
"	30	6,210	787	0.067	0.616	6,210	437	0.016	0.176	5,865	414	0.011	0.176
∅ 3	12	10,350	2,029	0.381	0.831	10,350	1,127	0.103	0.655	9,775	874	0.103	0.616
"	20	8,165	1,553	0.254	0.762	6,050	863	0.071	0.567	3,420	667	0.071	0.567
"	30	6,900	1,263	0.137	0.674	3,300	702	0.049	0.371	2,890	541	0.049	0.371
∅ 4	12	8,740	1,904	0.401	1.525	8,740	1,058	0.117	1.124	7,360	920	0.081	1.124
"	20	6,785	1,458	0.375	1.325	5,880	810	0.078	0.880	5,750	840	0.053	0.880
"	30	5,750	752	0.196	1.210	2,950	418	0.041	0.671	2,540	656	0.028	0.671
"	45	4,715	500	0.096	1.118	2,300	278	0.010	0.326	2,015	322	0.007	0.326
∅ 5	15	7,705	3,064	0.697	2.277	7,705	1,702	0.150	1.346	5,520	1,139	0.106	1.346
"	30	5,290	1,470	0.342	1.760	2,780	817	0.075	1.035	3,795	541	0.053	1.035
∅ 6	20	5,980	2,194	0.600	2.194	5,460	1,219	0.476	1.356	3,565	1,035	0.186	1.356
"	40	4,600	1,635	0.565	2.049	2,380	909	0.410	1.304	2,160	759	0.164	1.304
∅ 8	22	5,520	1,946	0.528	2.542	5,520	1,081	0.419	1.518	3,220	909	0.164	1.518
"	40	4,140	1,449	0.497	2.277	2,120	805	0.361	1.323	2,080	667	0.144	1.323
∅ 10	24	4,600	1,656	0.449	2.887	4,485	920	0.356	1.645	2,760	771	0.139	1.645
"	45	3,450	1,221	0.423	2.438	3,450	679	0.307	1.334	1,955	564	0.122	1.334
∅ 12	26	3,795	1,387	0.377	3.013	3,795	771	0.299	2.024	2,300	644	0.117	2.024
"	50	2,875	1,035	0.355	2.415	2,875	575	0.258	1.403	1,725	483	0.103	1.403
∅ 16	35	2,990	1,097	0.302	2.921	2,990	610	0.239	2.162	1,725	518	0.094	2.162



- HRC52 이상인 경우 같은 직경의 같은 비율로 20% DOWN 시켜 주십시오.
- 유효장이 긴 경우에는 회전수와 이송속도를 최대 30% 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.