

## Standard Endmills 2 Flutes

| Side Milling              |                   | N       |                 |         |                 | O       |                 |         |
|---------------------------|-------------------|---------|-----------------|---------|-----------------|---------|-----------------|---------|
| Working Material          | Wrought Aluminium |         | Cast Aluminium  |         | Copper Alloy    |         | Thermoplastics  |         |
| Properties                | Si < 9%           |         | Si ≥ 9%         |         | -               |         | -               |         |
| Cutting Depth, $A_p$ (mm) | $1.00 \times D$   |         | $1.00 \times D$ |         | $1.00 \times D$ |         | $1.00 \times D$ |         |
| Cutting Width, $A_e$ (mm) | $0.40 \times D$   |         | $0.40 \times D$ |         | $0.40 \times D$ |         | $0.40 \times D$ |         |
| D (mm)                    | Vc (m/min)        | Fz (mm) | Vc (m/min)      | Fz (mm) | Vc (m/min)      | Fz (mm) | Vc (m/min)      | Fz (mm) |
| 1                         | 400               | 0.004   | 300             | 0.004   | 350             | 0.002   | 350             | 0.004   |
| 2                         |                   | 0.008   |                 | 0.009   |                 | 0.006   |                 | 0.009   |
| 3                         |                   | 0.015   |                 | 0.016   |                 | 0.013   |                 | 0.015   |
| 4                         |                   | 0.023   |                 | 0.024   |                 | 0.020   |                 | 0.023   |
| 5                         |                   | 0.032   |                 | 0.034   |                 | 0.028   |                 | 0.033   |
| 6                         |                   | 0.044   |                 | 0.047   |                 | 0.040   |                 | 0.044   |
| 8                         |                   | 0.064   |                 | 0.071   |                 | 0.060   |                 | 0.066   |
| 10                        |                   | 0.088   |                 | 0.097   |                 | 0.084   |                 | 0.092   |
| 12                        |                   | 0.115   |                 | 0.129   |                 | 0.110   |                 | 0.124   |
| 14                        |                   | 0.135   |                 | 0.150   |                 | 0.130   |                 | 0.145   |
| 16                        | 400               | 0.160   | 300             | 0.180   | 350             | 0.152   | 350             | 0.172   |
| 20                        |                   | 0.200   |                 | 0.225   |                 | 0.192   |                 | 0.215   |



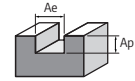
N

O

Recommended Cutting Data

Note: These recommended cutting conditions indicate just references. It should be adjusted due to different cutting conditions.

## Standard Endmills 2 Flutes



| Slotting               | N                 |         |                |         |              |         | O              |         |
|------------------------|-------------------|---------|----------------|---------|--------------|---------|----------------|---------|
| Working Material       | Wrought Aluminium |         | Cast Aluminium |         | Copper Alloy |         | Thermoplastics |         |
| Properties             | Si < 9%           |         | Si > 9%        |         | -            |         | -              |         |
| Cutting Depth, Ap (mm) | 0.50 × D          |         | 0.50 × D       |         | 0.50 × D     |         | 0.50 × D       |         |
| Cutting Width, Ae (mm) | 1.00 × D          |         | 1.00 × D       |         | 1.00 × D     |         | 1.00 × D       |         |
| D (mm)                 | Vc (m/min)        | Fz (mm) | Vc (m/min)     | Fz (mm) | Vc (m/min)   | Fz (mm) | Vc (m/min)     | Fz (mm) |
| 1                      | 250               | 0.004   | 200            | 0.004   | 220          | 0.003   | 230            | 0.004   |
| 2                      |                   | 0.009   |                | 0.009   |              | 0.008   |                | 0.008   |
| 3                      |                   | 0.014   |                | 0.014   |              | 0.012   |                | 0.013   |
| 4                      |                   | 0.020   |                | 0.019   |              | 0.017   |                | 0.019   |
| 5                      |                   | 0.029   |                | 0.026   |              | 0.024   |                | 0.026   |
| 6                      |                   | 0.040   |                | 0.035   |              | 0.032   |                | 0.035   |
| 8                      |                   | 0.059   |                | 0.054   |              | 0.050   |                | 0.052   |
| 10                     |                   | 0.080   |                | 0.072   |              | 0.068   |                | 0.072   |
| 12                     |                   | 0.102   |                | 0.092   |              | 0.088   |                | 0.094   |
| 14                     |                   | 0.131   |                | 0.115   |              | 0.110   |                | 0.118   |
| 16                     | 250               | 0.161   | 200            | 0.146   | 220          | 0.140   | 230            | 0.148   |
| 20                     |                   | 0.201   |                | 0.182   |              | 0.175   |                | 0.191   |



Recommended Cutting Data

Note: These recommended cutting conditions indicate just references. It should be adjusted due to different cutting conditions.