

ST[®] 200NaNo Series



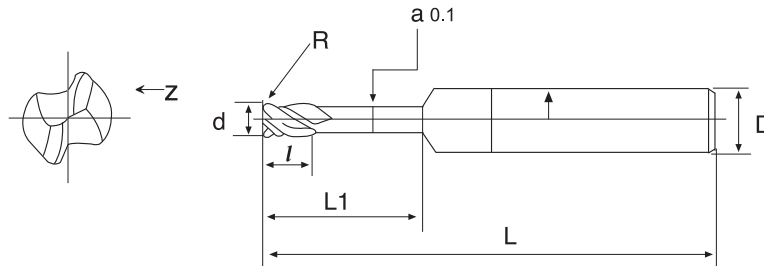
Corner Radius Medium Flute & Long Neck End Mill - 2 flutes

Super Ultra Fine Micro Grain Carbide

WC = 91 Co = 9 HRA = 93.2 Rupture = 4000N/mm² Grain Size = 0.2µm

Application Iron, Carbon steel, Cast Iron, Alloy Steel, Tool Steel, Heat treatment Steel, Welding Steel

Main Character Super Ultra Fine Micro Grain Carbide that has high toughness, coating ALTIN (TiAlN) and wear-resisting, non-general titanium aluminium is specialized in milling on M/C high hardness at a high speed and can carry on rough machining get to detailed process directly for heat treatment mould to reduce change times, improve machine flexible rate and shorten producing time.



MODE	Diameter d	Flute Length l	Full Length L	Shank Diameter D	Efficient Length L1	Corner Radius R	Packing Quantity	Price
SFUCRM060022-HSC	6	9	75	6	18	0.2R	2	
SFUCRM060032-HSC	6	9	75	6	18	0.3R	2	
SFUCRM060052-HSC	6	9	75	6	18	0.5R	2	
SFUCRM060102-HSC	6	9	75	6	18	1.0R	2	
SFUCRM060202-HSC	6	9	75	6	18	2.0R	2	
SFUCRM080032-HSC	8	12	100	8	20	0.3R	2	
SFUCRM080052-HSC	8	12	100	8	20	0.5R	2	
SFUCRM080102-HSC	8	12	100	8	20	1.0R	2	
SFUCRM080202-HSC	8	12	100	8	20	2.0R	2	
SFUCRM100052-HSC	10	15	100	10	25	0.5R	2	
SFUCRM100102-HSC	10	15	100	10	25	1.0R	2	
SFUCRM100152-HSC	10	15	100	10	25	1.5R	2	
SFUCRM100202-HSC	10	15	100	10	25	2.0R	2	
SFUCRM100302-HSC	10	15	100	10	25	3.0R	2	
SFUCRM120052-HSC	12	18	100	12	30	0.5R	2	
SFUCRM120102-HSC	12	18	100	12	30	1.0R	2	
SFUCRM120152-HSC	12	18	100	12	30	1.5R	2	
SFUCRM120202-HSC	12	18	100	12	30	2.0R	2	
SFUCRM120302-HSC	12	18	100	12	30	3.0R	2	



Attention : In order to get better cutting surface and lengthen the life-time of the end mill, please use high accuracy, high rigidity and dynamic equilibrium of holder.

1. Before using the end mill, please examine the end mill to lean towards and put, when the precision of the leaning towards of end mill exceeds 0.01mm, please cut after correcting.
2. It is better that end mill stretches out shorter from chuck, when the end mill stretches out longer, please adjust the rotational speed, feeding speed or cutting amount.
3. Unusual vibrations or sound happen when cutting, please adjust and lower the rotational speed of the main shaft one by one, feeding speed and cutting amount until improving the situation, or change the high-quality end mill.
4. It is the best way to cool steel material by spraying or air in order to make TiAlN efficiently; we commend to adopt non-water cutting liquid to cool the stainless steel, titanium alloy or heat-resisting alloy liquid.
5. Cutting will be influenced by work piece, machine and software; the above-mentioned data are only for reference, please improve feeding speed by 30%~50% up after cutting situation steadily.

SFUCRM 2 Flutes Recommended Milling conditions

Working material hardness	HRC30°		HRC40°		HRC50°		HRC55°		HRC60°	
	Rotational speed	Feeding speed	Rotational speed	Feeding speed	Rotational speed	Feeding speed	Rotational speed	Feeding speed	Rotational speed	Feeding speed
	RPM	mm/min.	RPM	mm/min.	RPM	mm/min.	RPM	mm/min.	RPM	mm/min.
D3.0 x 0.1R	5460	756	4620	630	4116	504	3444	441	3150	210
D3.0 x 0.2R	5460	756	4620	630	4116	504	3444	441	3150	210
D3.0 x 0.3R	5460	756	4620	630	4116	504	3444	441	315	210
D4.0 x 0.3R	5250	840	4410	756	3906	441	3297	357	2856	210
D4.0 x 0.3R	5250	840	4410	756	3906	441	3297	357	2856	210
D2.0 x 0.5R	6720	504	6090	462	5460	378	4620	315	3864	252
D3.0 x 0.5R	5460	840	4620	756	4116	630	3444	462	3150	210
D4.0 x 0.5R	5250	840	4410	756	3906	441	3297	357	2856	210
D6.0 x 0.5R	4830	1260	4200	1092	3696	840	3024	630	1932	315
D8.0 x 0.5R	3633	1428	3339	1134	2247	714	1953	504	1617	344
D10.0 x 0.5R	2310	1176	1764	798	1344	462	1134	399	693	244
D12.0 x 0.5R	1953	1218	1449	714	924	399	756	336	546	223
D3.0 x 1R	6279	966	5313	869	4733	725	3961	531	3623	242
D4.0 x 1R	66038	966	5072	870	4492	507	3792	411	3284	242
D6.0 x 1R	5555	1449	4830	1256	4250	966	3478	725	2222	362
D8.0 x 1R	4178	1642	3840	1304	2584	821	2246	580	1860	396
D10.0 x 1R	2657	1344	2029	918	1546	531	1304	459	797	280
D12.0 x 1R	2246	1401	1667	821	1063	599	869	386	628	256
D6.0 x 1.5R	5796	1512	5040	1310	4435	1008	3629	756	2318	378
D8.0 x 1.5R	4360	1714	4007	1361	2696	857	2344	605	1940	413
D10.0 x 1.5R	2772	1411	2117	958	1613	554	1361	479	832	292
D12.0 x 1.5R	2344	1462	1739	857	1109	479	907	403	6555	267
D6.0 x 2R	6279	1638	5460	1420	4805	1092	3931	819	2512	410
D8.0 x 2R	4723	1856	4341	1474	2921	928	2539	2102	2102	448
D10.0 x 2R	3003	1529	2293	1037	1747	601	1474	901	901	317
D12.0 x 2R	2539	1583	1884	928	1201	519	983	710	710	289
D8.0 x 3R	4905	1928	4508	1531	3034	964	2637	680	2184	465
D10.0 x 3R	3119	1588	2381	1077	1814	624	1531	539	936	329
D12.0 x 3R	2637	1644	1956	964	1247	539	1021	454	737	301