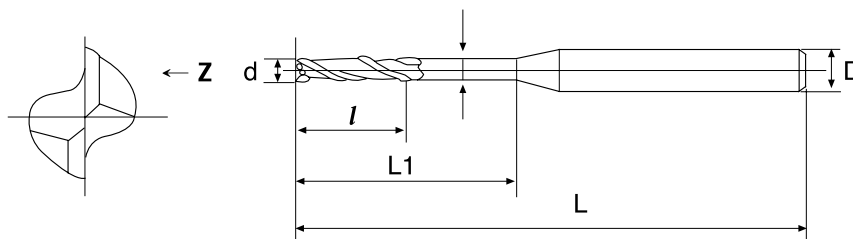


# RS

For Multiple Materials

## SQUARE TYPE LONG NECK - 2 flutes

WC=88 Co=12 HRA = 92.4 Rupture=3950N/mm<sup>2</sup> Grain Size=0.5μm



● SULNT - RS ●



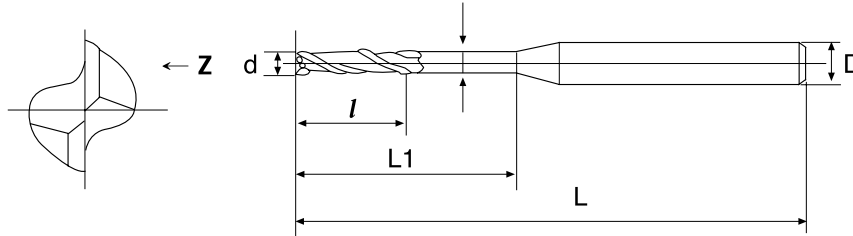
MODE	Diameter d	Flute Length l	Efficient Length L1	Shank Diameter D	Flute Quantity Z	Full Length L
SULNT 05022	0.5	0.75	2	4	2	50
SULNT 05042	0.5	0.75	4	4	2	50
SULNT 05062	0.5	0.75	6	4	2	50
SULNT 06022	0.6	0.9	2	4	2	50
SULNT 06042	0.6	0.9	4	4	2	50
SULNT 06062	0.6	0.9	6	4	2	50
SULNT 07042	0.7	1.1	4	4	2	50
SULNT 07062	0.7	1.1	6	4	2	50
SULNT 08042	0.8	1.2	4	4	2	50
SULNT 08062	0.8	1.2	6	4	2	50
SULNT 08082	0.8	1.2	8	4	2	50
SULNT 09062	0.9	1.4	6	4	2	50
SULNT 09082	0.9	1.4	8	4	2	50
SULNT 09102	0.9	1.4	10	4	2	50
SULNT 10062	1	1.5	6	4	2	50
SULNT 10082	1	1.5	8	4	2	50
SULNT 10102	1	1.5	10	4	2	50
SULNT 10122	1	1.5	12	4	2	50
SULNT 10162	1	1.5	16	4	2	50
SULNT 12062	1.2	1.8	6	4	2	50
SULNT 12082	1.2	1.8	8	4	2	50
SULNT 12102	1.2	1.8	10	4	2	50
SULNT 12122	1.2	1.8	12	4	2	50
SULNT 14062	1.4	2.1	6	4	2	50
SULNT 14102	1.4	2.1	10	4	2	50
SULNT 14162	1.4	2.1	16	4	2	50
SULNT 15062	1.5	2.3	6	4	2	50
SULNT 15082	1.5	2.3	8	4	2	50
SULNT 15102	1.5	2.3	10	4	2	50
SULNT 15122	1.5	2.3	12	4	2	50
SULNT 15142	1.5	2.3	14	4	2	50
SULNT 15162	1.5	2.3	16	4	2	50
SULNT 15182	1.5	2.3	18	4	2	50
SULNT 15202	1.5	2.3	20	4	2	50
SULNT 16062	1.6	2.4	6	4	2	50
SULNT 16082	1.6	2.4	8	4	2	50
SULNT 16102	1.6	2.4	10	4	2	50
SULNT 16122	1.6	2.4	12	4	2	50

Super high lubrication & Super low friction coefficient



## SQUARE TYPE LONG NECK - 2 flutes

WC=88 Co=12 HRA = 92.4 Rupture=3950N/mm<sup>2</sup> Grain Size=0.5μm



● SULNT - RS ●



MODE	Diameter d	Flute Length l	Efficient Length L1	Shank Diameter D	Flute Quantity Z	Full Length L
SULNT 16142	1.6	2.4	14	4	2	50
SULNT 16162	1.6	2.4	16	4	2	50
SULNT 16182	1.6	2.4	18	4	2	50
SULNT 18082	1.8	2.7	8	4	2	50
SULNT 18142	1.8	2.7	14	4	2	50
SULNT 18202	1.8	2.7	20	4	2	50
SULNT 20062	2	3	6	4	2	50
SULNT 20082	2	3	8	4	2	50
SULNT 20102	2	3	10	4	2	50
SULNT 20122	2	3	12	4	2	50
SULNT 20142	2	3	14	4	2	50
SULNT 20162	2	3	16	4	2	50
SULNT 20182	2	3	18	4	2	50
SULNT 20202	2	3	20	4	2	50
SULNT 25082	2.5	4	8	4	2	50
SULNT 25102	2.5	4	10	4	2	50
SULNT 25122	2.5	4	12	4	2	50
SULNT 25142	2.5	4	14	4	2	50
SULNT 25162	2.5	4	16	4	2	50
SULNT 25202	2.5	4	20	4	2	50
SULNT 30082	3	4.5	8	6	2	50
SULNT 30102	3	4.5	10	6	2	50
SULNT 30122	3	4.5	12	6	2	50
SULNT 30162	3	4.5	16	6	2	60
SULNT 30202	3	4.5	20	6	2	60
SULNT 30252	3	4.5	25	6	2	75
SULNT 35122	3.5	6	12	6	2	50
SULNT 35162	3.5	6	16	6	2	60
SULNT 35202	3.5	6	20	6	2	75
SULNT 35252	3.5	6	25	6	2	75
SULNT 35302	3.5	6	30	6	2	75
SULNT 40122	4	6	12	6	2	50
SULNT 40162	4	6	16	6	2	60
SULNT 40202	4	6	20	6	2	75
SULNT 40252	4	6	25	6	2	75
SULNT 40302	4	6	30	6	2	75
SULNT 40352	4	6	35	6	2	75

# RS

For Multiple Materials

## SULNT ■ Standard Cutting Conditions

Work Material		Carbon Steels, Alloy Steels Prehardened Steels S50C, SCM, SKD, SUS, HPM, NAK		Aluminum		Copper		Plastics	
Cutting Speed		30~80m/min		100~200m/min		50~150m/min		50~80m/min	
Diameter (mm)	Ad Depth of cut (mm)	Speed (min <sup>-1</sup> )	Feed Rate (mm/min)	Speed (min <sup>-1</sup> )	Feed Rate (mm/min)	Speed (min <sup>-1</sup> )	Feed Rate (mm/min)	Speed (min <sup>-1</sup> )	Feed Rate (mm/min)
0.2	0.002~0.01	47,800~	200~400	50,000~	200~400	50,000~	200~400	50,000~	200~400
0.3	0.002~0.02	31,800~	200~600	50,000~	200~600	50,000~	300~600	50,000~	200~600
0.4	0.002~0.02	23,900~	200~800	50,000~	200~800	39,800~	300~800	39,800~	200~800
0.5	0.001~0.04	19,100~	200~1,000	50,000~	200~1,000	31,800~	300~1,000	31,800~	200~1,000
1	0.002~0.05	9,600~25,500	300~1,300	31,800~	300~2,600	15,900~47,800	450~1,950	15,900~25,500	300~1,300
1.5	0.002~0.1	6,400~17,000	250~900	21,200~42,500	250~1,800	10,600~31,800	375~1,350	10,600~17,000	250~900
2	0.003~0.2	4,800~12,700	250~700	15,900~31,800	250~1,400	8,000~23,900	375~1,050	8,000~12,700	250~700
2.5	0.01~0.4	3,800~10,200	200~500	12,700~25,500	200~1,000	6,400~19,100	300~750	6,400~10,200	200~500
3	0.012~0.6	3,200~8,500	200~500	10,600~21,200	200~1,000	5,300~15,900	300~750	5,300~8,500	200~500

1. Adjust depth of cut according to effective length.
2. When under 20 (effective length / diameter), refer to the conditions listed above.
3. Use cutting fluid with retardant.
4. Recommend reciprocating cutting.