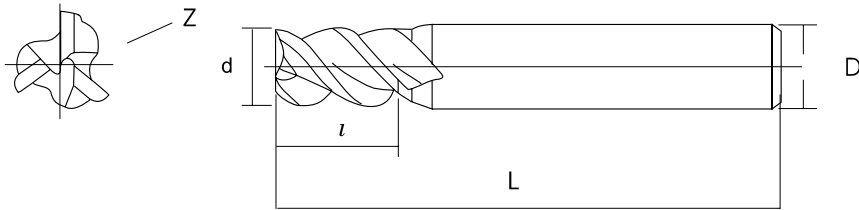


Super high lubrication & Super low friction coefficient



## SQUARE TYPE - 3 flutes

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



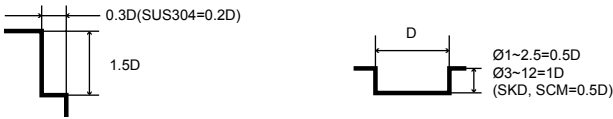
● SUPE 3 Flutes - RS ●



MODE	Diameter d	Flute Length l	Shank Diameter D	Flute Quantity Z	Full Length L
SUPE4 103	1	3	4	3	50
SUPE4 153	1.5	4	4	3	50
SUPE4 203	2	6	4	3	50
SUPE4 253	2.5	8	4	3	50
SUPE3 303	3	8	3	3	50
SUPE4 303	3	8	4	3	50
SUPE4 353	3.5	10	4	3	50
SUPE4 403	4	11	4	3	50
SUPE 0103	1	3	6	3	50
SUPE 0153	1.5	4	6	3	50
SUPE 0203	2	6	6	3	50
SUPE 0253	2.5	8	6	3	50
SUPE 0303	3	8	6	3	50
SUPE 0353	3.5	10	6	3	50
SUPE 0403	4	11	6	3	50
SUPE 0453	4.5	13	6	3	50
SUPE 0503	5	13	6	3	50
SUPE 0553	5.5	13	6	3	50
SUPE 0603	6	16	6	3	50
SUPE 0653	6.5	16	8	3	60
SUPE 0703	7	16	8	3	60
SUPE 0753	7.5	19	8	3	60
SUPE 0803	8	20	8	3	60
SUPE 0853	8.5	20	10	3	75
SUPE 0903	9	20	10	3	75
SUPE 0953	9.5	25	10	3	75
SUPE 1003	10	30	10	3	75
SUPE 1053	10.5	30	12	3	75
SUPE 1103	11	30	12	3	75
SUPE 1153	11.5	30	12	3	75
SUPE 1203	12	32	12	3	75
SUPE 1403	14	40	16	3	100
SUPE 1603	16	40	16	3	100
SUPE 1803	18	45	20	3	100
SUPE 2003	20	45	20	3	100

# RS *For Multiple Materials*

## SUPE 3 Flutes ■ Standard Cutting Conditions

Work Material	Carbon Steels S50C				Alloy Tool Steels, SCM, SKD				Stainless Steels, Titanium Alloys SUS304, SUS316 etc				Prehardened Steels, (~40HRC) HPM, NAK			
Cutting Speed	~100m/min				~50m/min				~35m/min				~56m/min			
Diameter (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)		
		Side Milling	Slotting	Drilling		Side Milling	Slotting	Drilling		Side Milling	Slotting	Drilling		Side Milling	Slotting	Drilling
1	15,000	400	200	70	15,000	210	100	40	10,000	200	70	-	15,000	200	100	50
1.5	13,000	500	250	70	13,000	270	120	40	7,000	250	70	-	13,000	250	130	50
2	11,000	600	300	100	8,000	350	140	50	5,000	250	70	-	10,000	300	150	70
2.5	10,000	700	400	100	7,000	450	160	60	4,000	250	70	-	8,000	350	170	90
3	9,600	800	550	200	4,200	550	200	100	3,600	250	100	-	5,800	400	250	100
4	7,200	900	650	210	3,200	500	250	120	2,800	250	100	-	4,400	400	250	110
5	5,700	1,000	700	260	2,500	450	250	120	2,200	300	120	-	3,500	500	300	120
6	4,800	1,200	720	300	2,000	400	300	150	1,800	300	120	-	3,000	600	330	130
8	3,600	1,000	760	300	1,600	400	300	120	1,400	300	120	-	2,200	600	330	100
10	3,000	900	800	300	1,300	350	200	100	1,100	300	100	-	1,700	400	200	80
12	2,600	850	740	280	1,100	340	180	80	900	270	100	-	1,500	340	180	70
Depth of cut (D:Dia)																

1. Use a rigid and precise machine and holder.
2. Please adjust the speed and feed when the cutting depth is large or when machines with low rigidity are used.
3. Air blow is recommended.
4. Non-water cutting fluid is recommended for cutting stainless steels.