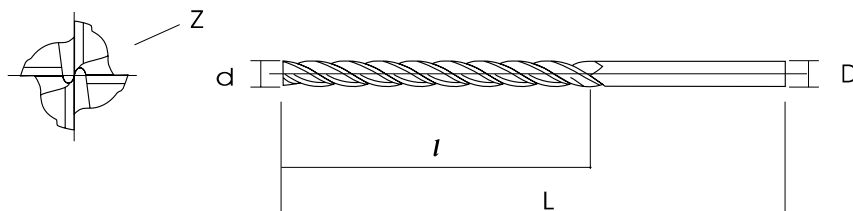


# RS

For Multiple Materials

## SQUARE TYPE LONG FLUTE - 4 flutes

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



● SULET 4 Flutes - RS ●



MODE	Diameter d	Flute Length l	Shank Diameter D	Flute Quantity Z	Full Length L
SULET 0104	1	6	4	4	50
SULET 0154	1.5	9	4	4	50
SULET 0204	2	12	4	4	50
SULET 0254	2.5	12	4	4	50
SULET 0304	3	15	6	4	60
SULET 0354	3.5	15	6	4	60
SULET 0404	4	20	6	4	75
SULET 0454	4.5	20	6	4	75
SULET 0504	5	25	6	4	75
SULET 0554	5.5	25	6	4	75
SULET 0604	6	30	6	4	75
SULET 0704	7	30	8	4	100
SULET 0804	8	40	8	4	100
SULET 0904	9	40	10	4	100
SULET 1004	10	40	10	4	100
SULET 1104	11	40	12	4	100
SULET 1204	12	50	12	4	100
SULET 1404	14	50	16	4	150
SULET 1604	16	60	16	4	150
SULET 2004	20	90	20	4	200

### SULET 4 Flutes ■ Standard Cutting Conditions

Work Material	Carbon Steels, Alloy Steels (~30HRC) S50C, SCM, FC250 etc AISI 1049, Cast iron			Alloy Steels, Tool Steels (30~45HRC) Prehardened Steels, SKD61, NAK etc AISI H13			Austenitic stainless Steels SUS304, SUS316 etc AISI 304, AISI 316			Hardened Steels (45~50HRC) SKD61, SKD11, NAK, STAVAX etc AISI H13		
Cutting Speed	35~50m/min			30~40m/min			20~30m/min			15~25m/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		Side Milling	Slotting		Side Milling	Slotting		Side Milling	Slotting
1	11,000	85	40	9,500	65	30	8,000	50	6,400	35	17	
												20
1.5	7,400	85	40	6,400	90	45	5,300	50	4,200	35	17	
												20
2	5,600	85	40	4,800	90	45	4,000	50	3,200	35	17	
												20
2.5	4,500	85	40	3,800	90	45	3,200	55	2,500	35	17	
												22
3	4,200	100	50	3,400	90	45	2,600	60	2,100	35	17	
												24
4	3,400	125	60	2,700	90	45	2,100	70	1,700	50	25	
												28
5	2,900	155	75	2,300	110	55	1,800	85	1,500	55	27	
												34
6	2,500	180	90	2,000	140	70	1,500	110	1,300	70	35	
												44
8	1,900	200	100	1,500	140	70	1,200	110	1,000	70	35	
												44
10	1,600	205	100	1,300	140	70	950	110	800	70	35	
												44
12	1,300	180	90	1,100	140	70	800	110	670	70	35	
												44
16	1,000	120	60	820	100	50	600	80	500	50	25	
												32
20	800	95	45	650	75	35	480	70	400	40	20	
												28
25	650	75	35	520	60	30	380	50	320	35	17	
												20

Depth of cut (D: Dia)				
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1. In cutting Austenitic stainless steels, the use of non-water-soluble cutting fluid is especially effective.
2. If the rigidity of the machine or the work material installation is very low, or chattering is generated, please reduce the revolution and the feed rate proportionately.
3. When drilling, please set the feed rate at 1/3 or below of the above value.