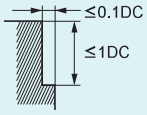
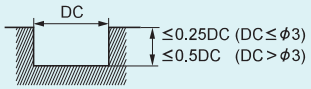
END MILL FOR SLOTTING

SED2KPG
End mill, Short cut length, 2 flute, For key ways

SED2KMG
End mill, Short cut length, 2 flute, For key ways

RECOMMENDED CUTTING CONDITIONS

Work material	Carbon steel, Alloy steel (180—280HB) AISI 1045, AISI P20		Carbon steel, Alloy steel (280—380HB) AISI 1045, AISI P20		Pre-hardened steel (35—45HRC)		Stainless steel (270HB≥) AISI 420		Cast iron (Tensile Strength 350MPa≥) AISI No 35 B	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
2	13000	260 (260)	10300	200 (200)	8800	110 (110)	9800	170 (170)	21500	830 (830)
3	8500	340 (340)	6900	200 (200)	6400	110 (110)	6400	170 (170)	14300	850 (850)
4	6500	380 (380)	5200	250 (200)	4400	140 (110)	4800	200 (160)	10700	860 (860)
5	5100	400 (400)	4100	290 (230)	3500	140 (110)	3800	190 (150)	8600	850 (850)
6	4300	410 (410)	3400	290 (230)	2900	150 (120)	3200	180 (140)	7200	870 (870)
8	3200	410 (410)	2600	250 (200)	2200	140 (110)	2400	150 (120)	5400	880 (880)
10	2600	400 (400)	2070	240 (190)	1800	140 (110)	1900	140 (110)	4300	860 (860)
12	2200	360 (360)	1700	210 (170)	1500	130 (100)	1600	130 (105)	3600	860 (860)
14	1900	340 (340)	1500	200 (160)	1250	130 (100)	1400	130 (100)	3100	860 (860)
16	1600	320 (320)	1300	200 (160)	1100	130 (100)	1200	120 (95)	2700	870 (870)
Depth of cut	  DC:Dia.									

( ) : Indicates standard feed rate for slotting.

1) The cutting conditions above are a guide only to milling within the standard depth of cut.
2) Ductile cast iron milling has the same cutting conditions as carbon steel and alloy steel. (180—280HB)
3) When drilling, please set the feed rate at 1/3 or below of the values above.
4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.