

End mill, Short cut length, 2 flute **C2SS**
 End mill, Semi long cut length, 2 flute **C2JS**¹⁾

End mill, Medium cut length, 2 flute **C2MS**
 End mill, Long cut length, 2 flute **C2LS**²⁾

CARBIDE

RECOMMENDED CUTTING CONDITIONS

Work material	Structural steel, Cast iron, Carbon steel		Carbon steel, Alloy steel (20—30HRC)		Alloy steel, Tool steel, Pre-hardened steel (30—45HRC)		Austenitic stainless steel, Titanium alloy	
	AISI 1045, AISI No 35 B, AISI 1050		AISI 1050, AISI P20		AISI H13, AISI P21		AISI 304	
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)
0.5	17000	50 (50)	14000	45 (45)	11000	30 (30)	9000	30 (30)
1	10000	65 (65)	8500	55 (55)	6400	40 (40)	5200	35 (35)
2	5500	90 (90)	4800	80 (80)	3800	55 (55)	3100	50 (50)
3	4100	100 (100)	3500	85 (85)	2800	65 (65)	2300	60 (60)
4	3400	170 (135)	2900	140 (110)	2200	90 (70)	1900	80 (60)
5	2900	190 (150)	2400	150 (120)	1800	100 (80)	1500	90 (60)
6	2500	200 (160)	2100	170 (135)	1600	110 (90)	1300	95 (65)
8	1900	200 (160)	1600	170 (135)	1200	105 (85)	1000	100 (70)
10	1500	180 (145)	1250	150 (120)	950	95 (75)	800	90 (65)
12	1250	150 (120)	1050	130 (100)	800	80 (65)	660	75 (50)
16	940	110 (90)	800	95 (75)	600	60 (50)	500	55 (40)
20	750	90 (70)	640	80 (65)	480	50 (40)	400	45 (30)

Depth of cut	(C2SS, C2MS)	

() : Indicates standard feed rate for slotting.

- 1) Decrease the feed rate by 20—30% for C2JS.
- 2) Decrease the revolution by 20—30% and the feed rate by 40—50% for C2LS.
- 3) 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.

SOLID END MILLS