

# MIRACLE END CRN

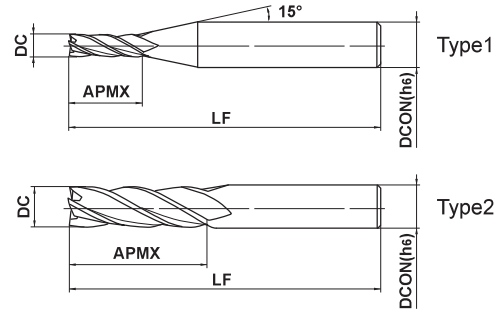
CARBIDE

## CRN4JC

End mill, Semi long cut length, 4 flute, For copper electrodes



Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
						○	○



SQUARE

BALL

	3 ≤ DC ≤ 12				
	<sup>0</sup> / <sub>-0.02</sub>				
	DCON=6	8 ≤ DCON ≤ 10	DCON=12		
	<sup>0</sup> / <sub>-0.008</sub>	<sup>0</sup> / <sub>-0.009</sub>	<sup>0</sup> / <sub>-0.011</sub>		

RADIUS

TAPER

● 4 flute end mill with CRN coating for copper electrode machining.

Unit : mm

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
CRN4JCD0300	3	12	50	6	4	●	1
CRN4JCD0400	4	15	50	6	4	●	1
CRN4JCD0500	5	20	60	6	4	●	1
CRN4JCD0600	6	20	60	6	4	●	2
CRN4JCD0800	8	25	70	8	4	●	2
CRN4JCD1000	10	30	90	10	4	●	2
CRN4JCD1200	12	30	90	12	4	●	2

SOLID END MILLS

### RECOMMENDED CUTTING CONDITIONS

Work material	Copper, Copper alloys	
Dia. DC (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)
3	10600	280
4	8000	330
5	6400	380
6	5300	420
8	4000	460
10	3200	460
12	2700	460
Depth of cut		

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) Water-soluble cutting fluid is recommended.
- 3) When drilling, please set the feed rate at 1/3 or below of the table value.
- 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.

● : Inventory maintained in Japan.