

Unit : mm

Order Number	DC	RE	APMX	LU	DN	LF	DCON	No. of Flutes	Stock	Type	Effective length for inclined angle			
											30°	1°	2°	3°
											CRN2XLREBD0300R050N20	3	0.5	3
CRN2XLRE D0400R020N20	4	0.2	4	20	3.9	65	6	2	●	1	20.8	21.5	23.2	*
CRN2XLRE D0400R030N20	4	0.3	4	20	3.9	65	6	2	●	1	20.8	21.5	23.1	*
CRN2XLRE D0400R050N20	4	0.5	4	20	3.9	65	6	2	●	1	20.8	21.5	23.1	*
CRN2XLRE D0500R020N25	5	0.2	5	25	4.9	65	6	2	●	1	26	26.9	*	*
CRN2XLRE D0500R030N25	5	0.3	5	25	4.9	65	6	2	●	1	26	26.9	*	*
CRN2XLRE D0500R050N25	5	0.5	5	25	4.9	65	6	2	●	1	26	26.9	*	*
CRN2XLRE D0600R020N30	6	0.2	6	30	5.85	70	6	2	●	2	*	*	*	*
CRN2XLRE D0600R030N30	6	0.3	6	30	5.85	70	6	2	●	2	*	*	*	*
CRN2XLRE D0600R050N30	6	0.5	6	30	5.85	70	6	2	●	2	*	*	*	*
CRN2XLRE D0600R100N30	6	1	6	30	5.85	70	6	2	●	2	*	*	*	*

\* No interference

## RECOMMENDED CUTTING CONDITIONS

### Slotting

### Contour Cutting

Work material			Copper, Copper alloys			Copper, Copper alloys			
Dia. DC (mm)	Corner radius RE (mm)	Neck length (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Depth of cut	
								ap (mm)	ae (mm)
0.5	R0.05, R0.1	4	40000	800	0.005	40000	1500	0.01	0.1
		6	40000	700	0.003	40000	1000	0.005	0.1
0.8	R0.05, R0.1	6	40000	1200	0.02	40000	2500	0.02	0.15
		8	40000	1200	0.015	40000	1600	0.01	0.15
1	R0.1, R0.3	8	40000	2000	0.03	40000	3000	0.03	0.2
		10	35000	1600	0.025	35000	2000	0.025	0.2
		12	30000	1200	0.02	30000	1800	0.02	0.2
1.5	R0.1, R0.2, R0.3	12	30000	1500	0.05	40000	4500	0.04	0.3
		20	20000	1000	0.02	20000	2000	0.02	0.3
2	R0.1, R0.2 R0.3, R0.5	12	30000	1500	0.1	40000	4500	0.08	0.4
		16	30000	1000	0.06	30000	3000	0.05	0.4
		20	20000	600	0.04	20000	2000	0.04	0.4
3	R0.2, R0.3 R0.5	20	20000	2000	0.12	35000	6000	0.1	0.6
		20	20000	2200	0.12	35000	8000	0.1	0.6
4	R0.2, R0.3 R0.5	20	15000	2000	0.25	32000	5000	0.15	0.8
		20	15000	2200	0.25	32000	7000	0.15	0.8
5	R0.2, R0.3 R0.5	25	12000	1500	0.3	22000	5000	0.2	1.0
		25	12000	1700	0.3	22000	7000	0.2	1.0
6	R0.2, R0.3, R0.5 R1	30	10000	1200	0.4	20000	5000	0.25	1.2
		30	10000	1500	0.4	20000	7000	0.25	1.2
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) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.