K2GNRB (Diameter 0.5 - 3.0 mm)

Work Materials
N

SOLID CARBIDE 2-FLUTE LONG NECK RELIEF BALLNOSE END MILL

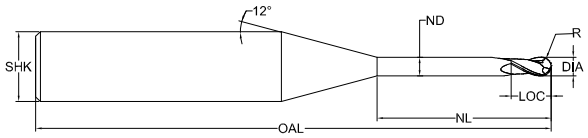
2刃钨钢长颈深沟圆头铣刀

MG | HELIX 30° | D

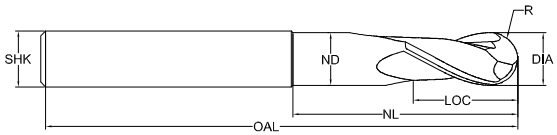
FEATURES:

- Ideal for high-speed machining of graphite, reinforced plastic, CFRP and non-ferrous materials.
- CVD diamond coated delivers the service life of approximately 20x of uncoated tool.
- Long neck relief configuration for extended reach of cuts.

DIA Tolerance
+ 0 / - 0.020 mm
Radius Tolerance
± 0.010 mm
SHK Tolerance
h6



DIA 0.5 - 2.0mm



DIA 3.0MM

PRODUCT CODE	DIA	ND	LOC	NL	OAL	SHK
K2GNRB 02 005D	**0.5**	0.45	2	2	45	3
K2GNRB 05 005D	**0.5**	0.45	2	5	45	3
K2GNRB 03 010D	**1.0**	0.95	3	3	60	3
K2GNRB 05 010D	**1.0**	0.95	3	5	60	3
K2GNRB 10 010D	**1.0**	0.95	3	10	60	3
K2GNRB 15 010D	**1.0**	0.95	3	15	60	3
K2GNRB 20 010D	**1.0**	0.95	3	20	60	3
K2GNRB 10 015D	**1.5**	1.45	5	10	80	3
K2GNRB 15 015D	**1.5**	1.45	5	15	80	3
K2GNRB 20 015D	**1.5**	1.45	5	20	80	3
K2GNRB 25 015D	**1.5**	1.45	5	25	80	3
K2GNRB 10 020D	**2.0**	1.95	6	10	80	3
K2GNRB 15 020D	**2.0**	1.95	6	15	80	3
K2GNRB 20 020D	**2.0**	1.95	6	20	80	3
K2GNRB 30 020D	**2.0**	1.95	6	30	80	3
K2GNRB 15 030D	**3.0**	2.95	8	15	100	3
K2GNRB 20 030D	**3.0**	2.95	8	20	100	3
K2GNRB 30 030D	**3.0**	2.95	8	30	100	3
K2GNRB 40 030D	**3.0**	2.95	8	40	100	3

K2GNRB (Diameter 4.0 - 12.0 mm)

Work Materials
N

SOLID CARBIDE 2-FLUTE LONG NECK RELIEF BALLNOSE END MILL

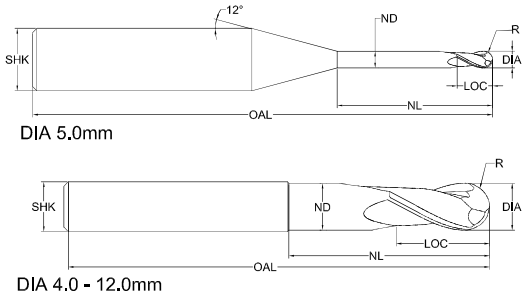
2刃钨钢长颈深沟圆头铣刀

MG | HELIX 30° | D

FEATURES:

- Ideal for high-speed machining of graphite, reinforced plastic, CFRP and non-ferrous materials.
- CVD diamond coated delivers the service life of approximately 20x of uncoated tool.
- Long neck relief configuration for extended reach of cuts.

DIA Tolerance
+ 0 / - 0.020 mm
Radius Tolerance
± 0.010 mm
SHK Tolerance
h6



DIA 5.0mm

DIA 4.0 - 12.0mm

PRODUCT CODE	DIA	R	ND	LOC	NL	OAL	SHK
K2GNRB 20 040D	**4.0**	2.0	3.95	10	20	100	4
K2GNRB 30 040D	**4.0**	2.0	3.95	10	30	100	4
K2GNRB 40 040D	**4.0**	2.0	3.95	10	40	100	4
K2GNRB 30 050D	**5.0**	2.5	4.95	12	30	110	6
K2GNRB 40 050D	**5.0**	2.5	4.95	12	40	110	6
K2GNRB 30 060D	**6.0**	3.0	5.95	15	30	130	6
K2GNRB 40 060D	**6.0**	3.0	5.95	15	40	130	6
K2GNRB 40 080D	**8.0**	4.0	7.95	18	40	130	8
K2GNRB 50 080D	**8.0**	4.0	7.95	18	50	130	8
K2GNRB 40 100D	**10.0**	5.0	9.95	22	40	150	10
K2GNRB 50 100D	**10.0**	5.0	9.95	22	50	150	10
K2GNRB 50 120D	**12.0**	6.0	11.95	25	50	150	12
K2GNRB 60 120D	**12.0**	6.0	11.95	25	60	150	12

K3GNRB

Work Materials

N

SOLID CARBIDE 3-FLUTE LONG NECK RELIEF BALLNOSE END MILL

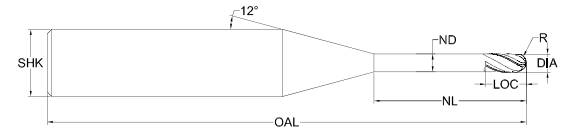
3刃钨钢长颈深沟圆头铣刀

MG | HELIX 30° | D

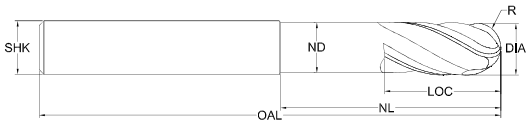
FEATURES:

- Ideal for high-speed machining of graphite, reinforced plastic, CFRP and non-ferrous materials.
- CVD diamond coated delivers the service life of approximately 20x of uncoated tool.
- Long neck relief configuration for extended reach of cuts.

DIA Tolerance	
Dia ≤ 6.0 mm	+ 0 / - 0.010 mm
Dia > 6.0 mm	+ 0 / - 0.015 mm
Radius Tolerance	
Dia ≤ 6.0 mm	± 0.005 mm
Dia > 6.0 mm	± 0.010 mm
SHK Tolerance	
h6	



DIA 1.0-2.0 mm



DIA 3.0 - 12.0mm

PRODUCT CODE	DIA	R	ND	LOC	NL	OAL	SHK
K3GNRB 05 010D	**1.0**	0.5	0.95	3	5	60	3
K3GNRB 10 010D	**1.0**	0.5	0.95	3	10	60	3
K3GNRB 15 010D	**1.0**	0.5	0.95	3	15	60	3
K3GNRB 10 015D	**1.5**	0.75	1.45	5	10	80	3
K3GNRB 15 015D	**1.5**	0.75	1.45	5	15	80	3
K3GNRB 20 015D	**1.5**	0.75	1.45	5	20	80	3
K3GNRB 10 020D	**2.0**	1.0	1.95	6	10	80	3
K3GNRB 15 020D	**2.0**	1.0	1.95	6	15	80	3
K3GNRB 20 020D	**2.0**	1.0	1.95	6	20	80	3
K3GNRB 25 020D	**2.0**	1.0	1.95	6	25	100	3
K3GNRB 15 030D	**3.0**	1.5	2.95	8	15	100	3
K3GNRB 20 030D	**3.0**	1.5	2.95	8	20	100	3
K3GNRB 30 030D	**3.0**	1.5	2.95	8	30	100	3
K3GNRB 40 030D	**3.0**	1.5	2.95	8	40	100	3
K3GNRB 40 040D	**4.0**	2.0	3.95	16	40	130	4
K3GNRB 40 050D	**5.0**	2.5	4.95	16	40	130	5
K3GNRB 50 060D	**6.0**	3.0	5.95	16	50	150	6
K3GNRB 50 080D	**8.0**	4.0	7.95	20	50	150	8
K3GNRB 60 100D	**10.0**	5.0	9.95	22	60	160	10
K3GNRB 60 120D	**12.0**	6.0	11.95	25	60	200	12

K4GNRB

Work Materials
N

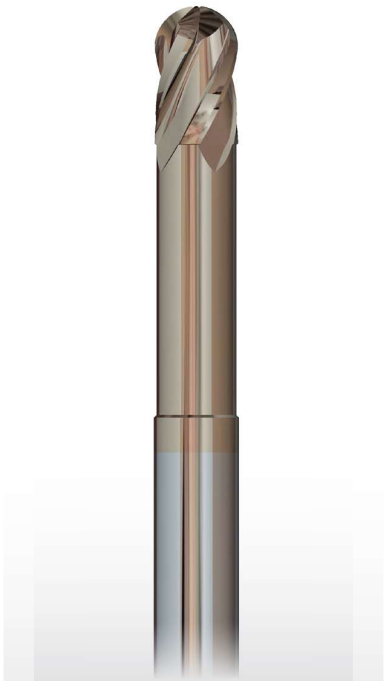
SOLID CARBIDE 4-FLUTE LONG NECK RELIEF BALLNOSE END MILL

4刃钨钢长颈深沟圆头铣刀

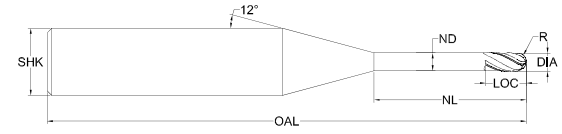
MG | HELIX 30° | D

FEATURES:

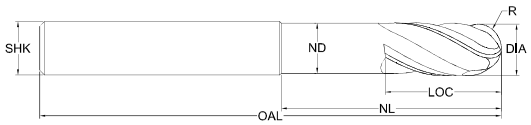
- Ideal for high-speed machining of graphite, reinforced plastic, CFRP and non-ferrous materials.
- CVD diamond coated delivers the service life of approximately 20x of uncoated tool.
- Long neck relief configuration for extended reach of cuts.



DIA Tolerance	
Dia ≤ 6.0 mm	+ 0 / - 0.010 mm
Dia > 6.0 mm	+ 0 / - 0.015 mm
Radius Tolerance	
Dia ≤ 6.0 mm	± 0.005 mm
Dia > 6.0 mm	± 0.010 mm
SHK Tolerance	
h6	



DIA 1.0-2.0 mm



DIA 3.0 - 12.0mm

PRODUCT CODE	DIA	R	ND	LOC	NL	OAL	SHK
K4GNRB 05 010D	**1.0**	0.5	0.95	3	5	60	3
K4GNRB 10 010D	**1.0**	0.5	0.95	3	10	60	3
K4GNRB 15 010D	**1.0**	0.5	0.95	3	15	60	3
K4GNRB 10 015D	**1.5**	0.75	1.45	5	10	80	3
K4GNRB 15 015D	**1.5**	0.75	1.45	5	15	80	3
K4GNRB 20 015D	**1.5**	0.75	1.45	5	20	80	3
K4GNRB 10 020D	**2.0**	1.0	1.95	6	10	80	3
K4GNRB 15 020D	**2.0**	1.0	1.95	6	15	80	3
K4GNRB 20 020D	**2.0**	1.0	1.95	6	20	80	3
K4GNRB 25 020D	**2.0**	1.0	1.95	6	25	100	3
K4GNRB 15 030D	**3.0**	1.5	2.95	8	15	100	3
K4GNRB 20 030D	**3.0**	1.5	2.95	8	20	100	3
K4GNRB 30 030D	**3.0**	1.5	2.95	8	30	100	3
K4GNRB 40 030D	**3.0**	1.5	2.95	8	40	100	3
K4GNRB 40 040D	**4.0**	2.0	3.95	16	40	130	4
K4GNRB 40 050D	**5.0**	2.5	4.95	16	40	130	5
K4GNRB 50 060D	**6.0**	3.0	5.95	16	50	150	6
K4GNRB 50 080D	**8.0**	4.0	7.95	20	50	150	8
K4GNRB 60 100D	**10.0**	5.0	9.95	22	60	160	10
K4GNRB 60 120D	**12.0**	6.0	11.95	25	60	200	12

K2GLSE

Work Materials

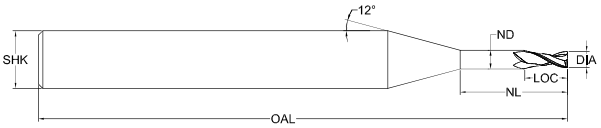
N

SOLID CARBIDE 2-FLUTE LONG SHANK SQUARE END MILL

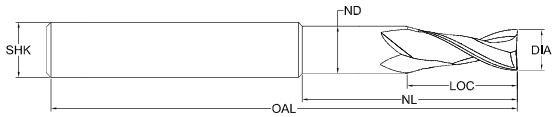
2刃钨钢长柄平端铣刀

FEATURES:

- Ideal for high-speed machining of graphite, reinforced plastic, CFRP and non-ferrous materials.
- CVD diamond coated delivers the service life of approximately 20x of uncoated tool.
- Long neck relief configuration for extended reach of cuts.



DIA 5.0mm



DIA 4.0 - 12.0mm

PRODUCT CODE	DIA	LOC	ND	NL	OAL	SHK
K2GLSE 01 005D	**0.5**	1	0.45	1	45	3
K2GLSE 05 010D	**1.0**	3	0.95	5	60	3
K2GLSE 10 010D	**1.0**	3	0.95	10	60	3
K2GLSE 15 015D	**1.5**	6	1.45	15	60	3
K2GLSE 20 015D	**1.5**	6	1.45	20	60	3
K2GLSE 25 015D	**1.5**	6	1.45	25	60	3
K2GLSE 20 020D	**2.0**	8	1.95	20	80	3
K2GLSE 25 020D	**2.0**	8	1.95	25	80	3
K2GLSE 30 020D	**2.0**	8	1.95	30	80	3
K2GLSE 40 020D	**2.0**	8	1.95	40	80	3
K2GLSE 20 030D	**3.0**	12	2.95	20	80	3
K2GLSE 25 030D	**3.0**	12	2.95	25	80	3
K2GLSE 30 030D	**3.0**	12	2.95	30	80	3
K2GLSE 40 030D	**3.0**	12	2.95	40	80	3
K2GLSE 40 040D	**4.0**	16	3.95	40	100	4
K2GLSE 40 050D	**5.0**	16	4.95	40	100	5
K2GLSE 50 060D	**6.0**	16	5.95	50	120	6
K2GLSE 50 080D	**8.0**	20	7.95	50	120	8
K2GLSE 60 100D	**10.0**	22	9.95	60	150	10
K2GLSE 60 120D	**12.0**	25	11.95	60	150	12

DIA Tolerance	
Dia ≤ 6.0 mm	+ 0 / - 0.010 mm
Dia > 6.0 mm	+ 0 / - 0.015 mm
SHK Tolerance	
h6	

K3GLFE

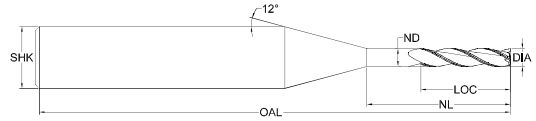
Work Materials
N

SOLID CARBIDE 3-FLUTE LONG FLUTE SQUARE END MILL

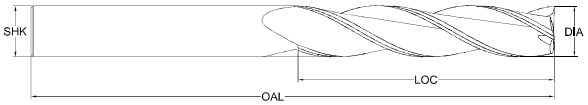
3刃钨钢长刃平端铣刀

FEATURES:

- Ideal for high-speed machining of graphite, reinforced plastic, CFRP and non-ferrous materials.
- CVD diamond coated delivers the service life of approximately 20x of uncoated tool.
- Long neck relief configuration for extended reach of cuts.



DIA 1.0 - 2.0mm



DIA 3.0 - 12.0mm

PRODUCT CODE	DIA	LOC	OAL	SHK
K3GLFE 03 010D	**1.0**	3	45	3
K3GLFE 06 020D	**2.0**	6	60	3
K3GLFE 10 020D	**2.0**	10	45	3
K3GLFE 09 030D	**3.0**	9	50	3
K3GLFE 15 030D	**3.0**	15	60	3
K3GLFE 20 030D	**3.0**	20	60	3
K3GLFE 12 040D	**4.0**	12	50	4
K3GLFE 20 040D	**4.0**	20	80	4
K3GLFE 18 060D	**6.0**	18	60	6
K3GLFE 25 060D	**6.0**	25	110	6
K3GLFE 30 060D	**6.0**	30	150	6
K3GLFE 24 080D	**8.0**	24	70	8
K3GLFE 35 080D	**8.0**	35	110	8
K3GLFE 40 080D	**8.0**	40	150	8
K3GLFE 25 100D	**10.0**	25	80	10
K3GLFE 40 100D	**10.0**	40	110	10
K3GLFE 50 100D	**10.0**	50	160	10
K3GLFE 25 120D	**12.0**	25	80	12
K3GLFE 45 120D	**12.0**	45	110	12
K3GLFE 55 120D	**12.0**	55	160	12

DIA Tolerance	
Dia ≤ 6.0 mm	+ 0 / - 0.020 mm
Dia > 6.0 mm	+ 0 / - 0.030 mm
SHK Tolerance	
h6	

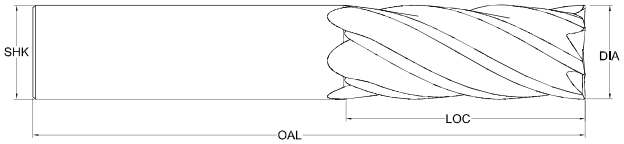
K6GE

Work Materials

N

SOLID CARBIDE 6-FLUTE SQUARE END MILL

6刃钨钢平端铣刀



FEATURES:

- Ideal for high-speed machining of graphite, reinforced plastic, CFRP and non-ferrous materials.
- CVD diamond coated delivers the service life of approximately 20x of uncoated tool.
- Long neck relief configuration for extended reach of cuts.

DIA Tolerance	
Dia ≤ 3.0 mm	+ 0 / - 0.020 mm
Dia > 3.0 mm	+ 0 / - 0.030 mm
SHK Tolerance	
h6	

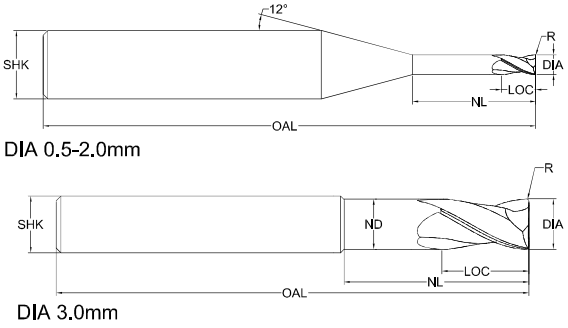
PRODUCT CODE	DIA	LOC	OAL	SHK
K6GE03 06 020D	**2.0**	6	50	3
K6GE03 12 030D	**3.0**	12	60	3
K6GE04 15 030D	**3.0**	15	60	4
K6GE04 16 040D	**4.0**	16	60	4
K6GE05 19 040D	**4.0**	19	60	5
K6GE05 20 050D	**5.0**	20	60	5
K6GE05 23 050D	**5.0**	23	60	6
K6GE06 25 060D	**6.0**	25	75	6
K6GE06 28 060D	**6.0**	28	75	8
K6GE08 35 080D	**8.0**	35	100	8
K6GE10 38 080D	**8.0**	38	100	10
K6GE10 40 100D	**10.0**	40	100	10
K6GE12 43 100D	**10.0**	43	100	12
K6GE12 45 120D	**12.0**	45	100	12

K2GLSR (Diameter 0.5 - 3.0 mm)

Work Materials
N

SOLID CARBIDE 2-FLUTE LONG SHANK CORNER RADIUS END MILL

2刃钨钢长柄R-角平端铣刀



FEATURES:

- Ideal for high-speed machining of graphite, reinforced plastic, CFRP and non-ferrous materials.
- CVD diamond coated delivers the service life of approximately 20x of uncoated tool.
- Long neck relief configuration for extended reach of cuts.

DIA Tolerance	
+ 0 / - 0.015mm	
Radius Tolerance	
Dia ≤ 2.0 mm	+ 0 / - 0.005mm
Dia > 2.0 mm	+ 0 / - 0.010 mm
SHK Tolerance	

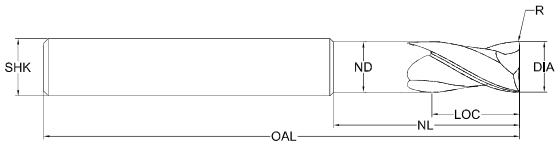
PRODUCT CODE	DIA	R	LOC	NL	OAL	SHK
K2GLSR005025005D	**0.5**	0.05	1	2.5	60	3
K2GLSR005035005D	**0.5**	0.05	1	3.5	60	3
K2GLSR005050005D	**0.5**	0.05	1	5.0	60	3
K2GLSR005075005D	**0.5**	0.05	1	7.5	60	3
K2GLSR005100005D	**0.5**	0.05	1	10	60	3
K2GLSR020050010D	**1.0**	0.20	2	5	60	3
K2GLSR020100010D	**1.0**	0.20	2	10	60	3
K2GLSR020150010D	**1.0**	0.20	2	15	60	3
K2GLSR020200010D	**1.0**	0.20	2	20	60	3
K2GLSR020050015D	**1.5**	0.20	3	5	60	3
K2GLSR020100015D	**1.5**	0.20	3	10	60	3
K2GLSR020150015D	**1.5**	0.20	3	15	60	3
K2GLSR020200015D	**1.5**	0.20	3	20	60	3
K2GLSR050100020D	**2.0**	0.50	3.5	10	60	3
K2GLSR050200020D	**2.0**	0.50	3.5	20	60	3
K2GLSR050300020D	**2.0**	0.50	3.5	30	60	3
K2GLSR050400020D	**2.0**	0.50	3.5	40	60	3
K2GLSR050100030D	**3.0**	0.50	4	10	80	3
K2GLSR050200030D	**3.0**	0.50	4	20	80	3
K2GLSR050300030D	**3.0**	0.50	4	30	80	3
K2GLSR050400030D	**3.0**	0.50	4	40	80	3

K2GLSR (Diameter 4.0 – 6.0 mm)

Work Materials
N

SOLID CARBIDE 2-FLUTE LONG SHANK CORNER RADIUS END MILL

2刃钨钢长柄R-角平端铣刀



DIA 4.0 - 6.0mm

FEATURES:

- Ideal for high-speed machining of graphite, reinforced plastic, CFRP and non-ferrous materials.
- CVD diamond coated delivers the service life of approximately 20x of uncoated tool.
- Long neck relief configuration for extended reach of cuts.

PRODUCT CODE	DIA	R	LOC	NL	OAL	SHK
K2GLSR005150040D	**4.0**	0.5	5	15	80	4
K2GLSR005250040D	**4.0**	0.5	5	25	80	4
K2GLSR005400040D	**4.0**	0.5	5	40	80	4
K2GLSR005150050D	**5.0**	0.5	6	15	80	6
K2GLSR005300050D	**5.0**	0.5	6	30	80	6
K2GLSR005500050D	**5.0**	0.5	6	50	80	6
K2GLSR005200060D	**6.0**	0.5	7	20	110	6
K2GLSR005300060D	**6.0**	0.5	7	30	110	6
K2GLSR005500060D	**6.0**	0.5	7	50	110	6
K2GLSR010200060D	**6.0**	1.0	8	20	110	6
K2GLSR010300060D	**6.0**	1.0	8	30	110	6
K2GLSR010500060D	**6.0**	1.0	8	50	110	6

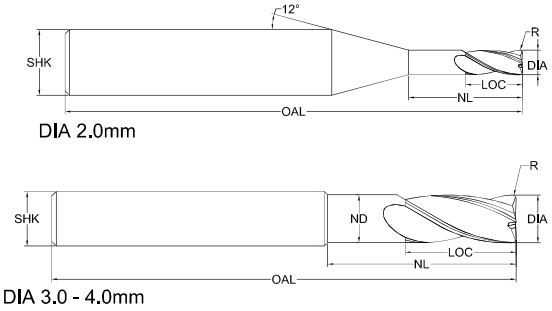
DIA Tolerance
+ 0 / - 0.015mm
Radius Tolerance
+ 0 / - 0.010 mm
SHK Tolerance
h6

K4GLSR (Diameter 2.0 - 3.0 mm)

Work Materials
N

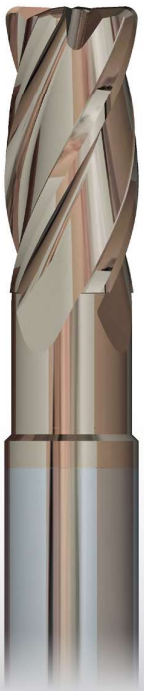
SOLID CARBIDE 4-FLUTE LONG SHANK CORNER RADIUS END MILL

4刃钨钢长柄R-角平端铣刀



FEATURES:

- Ideal for high-speed machining of graphite, reinforced plastic, CFRP and non-ferrous materials.
- CVD diamond coated delivers the service life of approximately 20x of uncoated tool.
- Long neck relief configuration for extended reach of cuts.



DIA Tolerance
+ 0 / - 0.020mm
Radius Tolerance
+ 0 / - 0.010 mm
SHK Tolerance
h6

PRODUCT CODE	DIA	R	LOC	NL	OAL	SHK
K4GLSR005060020D	**2.0**	0.05	3.5	6	60	3
K4GLSR005120020D	**2.0**	0.05	3.5	12	60	3
K4GLSR005180020D	**2.0**	0.05	3.5	18	60	3
K4GLSR005250020D	**2.0**	0.05	3.5	25	60	3
K4GLSR005300020D	**2.0**	0.05	3.5	30	60	3
K4GLSR020060020D	**2.0**	0.20	3.5	6	60	3
K4GLSR020120020D	**2.0**	0.20	3.5	12	60	3
K4GLSR020180020D	**2.0**	0.20	3.5	18	60	3
K4GLSR020250020D	**2.0**	0.20	3.5	25	60	3
K4GLSR020300020D	**2.0**	0.20	3.5	30	60	3
K4GLSR050060020D	**2.0**	0.50	3.5	6	60	3
K4GLSR050120020D	**2.0**	0.50	3.5	12	60	3
K4GLSR050180020D	**2.0**	0.50	3.5	18	60	3
K4GLSR050250020D	**2.0**	0.50	3.5	25	60	3
K4GLSR050300020D	**2.0**	0.50	3.5	30	60	3
K4GLSR020100030D	**3.0**	0.20	4	10	80	3
K4GLSR020200030D	**3.0**	0.20	4	20	80	3
K4GLSR020300030D	**3.0**	0.20	4	30	80	3
K4GLSR020400030D	**3.0**	0.20	4	40	80	3
K4GLSR050100030D	**3.0**	0.50	4	10	80	3
K4GLSR050200030D	**3.0**	0.50	4	20	80	3
K4GLSR050300030D	**3.0**	0.50	4	30	80	3
K4GLSR050400030D	**3.0**	0.50	6	40	80	3
K4GLSR030200040D	**3.0**	0.30	6	20	100	4
K4GLSR050300040D	**3.0**	0.50	6	30	100	4
K4GLSR100400040D	**3.0**	1.0	6	40	100	4

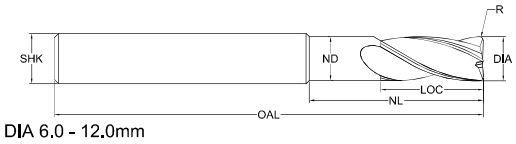
K4GLSR (Diameter 6.0 - 12.0 mm)

Work Materials

N

SOLID CARBIDE 4-FLUTE LONG SHANK CORNER RADIUS END MILL

4刃钨钢长柄R-角平端铣刀

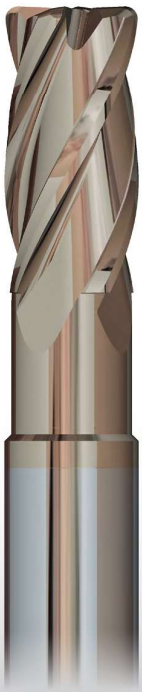


DIA 6.0 - 12.0mm

FEATURES:

- Ideal for high-speed machining of graphite, reinforced plastic, CFRP and non-ferrous materials.
- CVD diamond coated delivers the service life of approximately 20x of uncoated tool.
- Long neck relief configuration for extended reach of cuts.

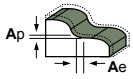
PRODUCT CODE	DIA	R	LOC	NL	OAL	SHK
K4GLR030250060D	**6.0**	0.3	9	25	110	6
K4GLR050300060D	**6.0**	0.5	9	30	110	6
K4GLR100400060D	**6.0**	1.0	9	40	110	6
K4GLR030300080D	**8.0**	0.3	12	30	130	8
K4GLR050400080D	**8.0**	0.5	12	40	130	8
K4GLR100500080D	**8.0**	1.0	12	50	130	8
K4GLR050400100D	**10.0**	0.5	15	40	130	10
K4GLR100500100D	**10.0**	1.0	15	50	130	10
K4GLR050400120D	**12.0**	0.5	15	40	150	12
K4GLR100500120D	**12.0**	1.0	3.5	50	150	12



DIA Tolerance
+ 0 / - 0.020mm
Radius Tolerance
+ 0 / - 0.010 mm
SHK Tolerance
h6

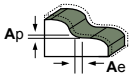
Operating Parameters For Graphite Series

CONTOUR MILLING 等高切削

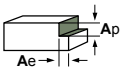


SERIES	K2GNRB Solid Carbide 2 Flute Long Neck Relief Ballnose End Mill		K3GNRB Solid Carbide 3 Flute Long Neck Relief Ballnose End Mill	
ISO WORK MATERIAL CODE	N	Graphite		
Dc (mm)	n (min⁻¹)	Vf (mm/min)	n (min⁻¹)	Vf (mm/min)
0.5	40000	1500	40000	2200
1.0	40000	1800	40000	2700
1.5	40000	2100	40000	3100
2.0	40000	2200	40000	3300
3.0	30000	2400	30000	3200
4.0	24000	2500	24000	3600
5.0	19000	2500	19000	3600
6.0	16000	2600	16000	3900
8.0	12000	2800	12000	4200
10.0	10000	3000	10000	4500
12.0	8000	3000	8000	4500
Depth of Cut (DOC)	Axial DOC, Ap (mm)	Radial DOC, Ae (mm)	Axial DOC, Ap (mm)	Radial DOC, Ae (mm)
	≤ 0.10 x Dc	≤ 0.25 x Dc	≤ 0.10 x Dc	≤ 0.25 x Dc

CONTOUR MILLING 等高切削



SIDE MILLING 侧面切削

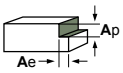


SERIES	K4GNRB Solid Carbide 4 Flute Long Shank Ballnose End Mill		K2GLSE Solid Carbide 2 Flute Long Shank Square End Mill	
ISO WORK MATERIAL CODE	N	Graphite		
Dc (mm)	n (min⁻¹)	Vf (mm/min)	n (min⁻¹)	Vf (mm/min)
0.5	40000	2300	40000	200
1.0	40000	2900	40000	400
1.5	40000	3300	35000	450
2.0	40000	3500	30000	480
3.0	30000	3600	21000	650
4.0	24000	3800	16000	540
5.0	19000	3800	12500	560
6.0	16000	4200	10500	590
8.0	12000	4500	8000	610
10.0	10000	4800	6400	600
12.0	8000	4800	5300	580
Depth of Cut (DOC)	Axial DOC, Ap (mm)	Radial DOC, Ae (mm)	Axial DOC, Ap (mm)	Radial DOC, Ae (mm)
	≤ 0.10 x Dc	≤ 0.25 x Dc	≤ 1.5 x Dc	≤ 0.1 x Dc

Note: When parameter exceeded the machine's maximum spindle speed, decrease both spindle speed and the feedrate by the same proportion.

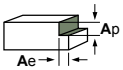
Dc = Cutter Diameter (mm) 切削直径
Ap = Depth of cut (mm) 切削深度
n = Spindle Speed (mm^{-1}) 转速
Vf = Feed Rate (mm/min) 进给速
Ae = Width of Cut (mm) 切削宽度

SIDE MILLING 侧面切削



SERIES	K3GLFE Solid Carbide 3 Flute Long Flute Square End Mill		K6GE Solid Carbide 6-Flute Square End Mill	
ISO WORK MATERIAL CODE	N	Graphite		
Dc (mm)	n (min⁻¹)	Vf (mm/min)	n (min⁻¹)	Vf (mm/min)
0.5	40000	280	-	-
1.0	40000	570	-	-
1.5	35000	640	-	-
2.0	30000	680	40000	3000
3.0	21000	920	30000	3200
4.0	16000	760	24000	3600
5.0	12500	790	19000	3600
6.0	10500	840	16000	3900
8.0	8000	860	12000	6000
10.0	6400	850	10000	5600
12.0	5300	850	8000	4000
Depth of Cut (DOC)	Axial DOC, Ap (mm)	Radial DOC, Ae (mm)	Axial DOC, Ap (mm)	Radial DOC, Ae (mm)
	≤ 0.15 x Dc	≤ 0.1 x Dc	≤ 1.5 x Dc	≤ 0.08 x Dc

SIDE MILLING 侧面切削



SERIES	K2GLSR Solid Carbide 2 Flute Long Shank Corner Radius End Mill		K4GLSR Solid Carbide 4 Flute Long Shank Corner Radius End Mill	
ISO WORK MATERIAL CODE	N	Graphite		
Dc (mm)	n (min⁻¹)	Vf (mm/min)	n (min⁻¹)	Vf (mm/min)
0.5	40000	200	-	-
1.0	40000	900	-	-
1.5	38000	900	-	-
2.0	36000	900	40000	3200
3.0	32000	1300	40000	3500
4.0	26000	1500	40000	5400
5.0	24000	1100	40000	5600
6.0	21000	1100	40000	5600
8.0	-	-	32000	5700
10.0	-	-	26000	5500
12.0	-	-	21000	5500
Depth of Cut (DOC)	Axial DOC, Ap (mm)	Radial DOC, Ae (mm)	Axial DOC, Ap (mm)	Radial DOC, Ae (mm)
	≤ 1.5 x Dc	≤ 0.2 x Dc	≤ 1.5 x Dc	≤ 0.2 x Dc

Note: When parameter exceeded the machine's maximum spindle speed, decrease both spindle speed and the feedrate by the same proportion.

Dc = Cutter Diameter (mm) 切削直径
Ap = Depth of cut (mm) 切削深度
n = Spindle Speed (mm^{-1}) 转速
Vf = Feed Rate (mm/min) 进给速
Ae = Width of Cut (mm) 切削宽度