K3S40E

Work Materials

P	M	K	S	H
■	□	■	□	■

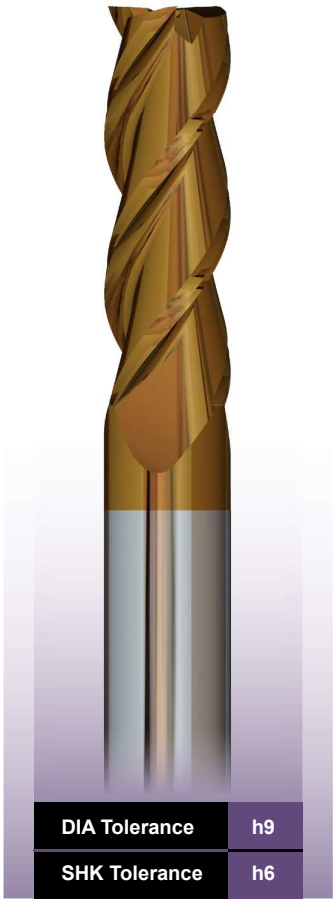
SOLID CARBIDE 3-FLUTE SQUARE END MILL

3刃钨钢平端铣刀

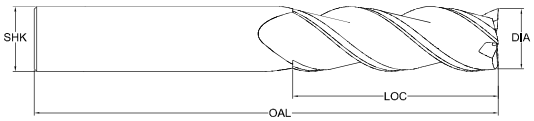
ULTRA FG | HELIX 40° | GASH LAND | S

FEATURES:

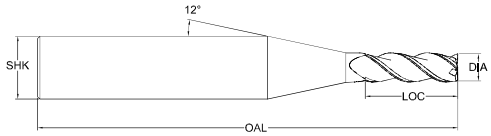
- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.



DIA Tolerance	h9
SHK Tolerance	h6



DIA 3.0 - 10.0mm



DIA 1.0 - 2.5mm

PRODUCT CODE	DIA	LOC	OAL	SHK
K3S40E 010S	**1.0**	3	38	3
K3S40E 015S	**1.5**	4.5	38	3
K3S40E 020S	**2.0**	6.5	38	3
K3S40E 025S	**2.5**	6.5	50	3
K3S40E 030S	**3.0**	7	50	3
K3S40E 035S	**3.5**	8	50	4
K3S40E 040S	**4.0**	8	50	4
K3S40E 045S	**4.5**	10	50	5
K3S40E 050S	**5.0**	10	57	5
K3S40E 055S	**5.5**	10	57	6
K3S40E 060S	**6.0**	13	57	6
K3S40E 070S	**7.0**	16	63	8
K3S40E 080S	**8.0**	16	63	8
K3S40E 090S	**9.0**	19	72	9
K3S40E 100S	**10.0**	22	72	10

K4S40E

Work Materials

P	M	K	S	H
■	□	■	□	■

SOLID CARBIDE 4-FLUTE SQUARE END MILL

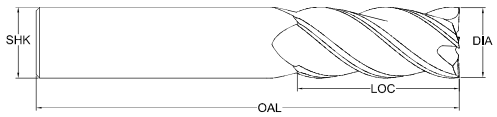
4刃钨钢平端铣刀

ULTRA FG | HELIX 40° | GASH LAND | S

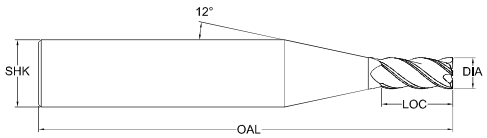
FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.

DIA Tolerance	h9
SHK Tolerance	h6



DIA 3.0 - 10.0mm



DIA 1.0 - 2.5mm

PRODUCT CODE	DIA	LOC	OAL	SHK
K4S40E 010S	**1.0**	3	38	3
K4S40E 015S	**1.5**	4.5	38	3
K4S40E 020S	**2.0**	6.5	38	3
K4S40E 025S	**2.5**	6.5	50	3
K4S40E 030S	**3.0**	9	50	3
K4S40E 035S	**3.5**	12	50	4
K4S40E 040S	**4.0**	12	50	4
K4S40E 045S	**4.5**	15	50	5
K4S40E 050S	**5.0**	15	57	5
K4S40E 055S	**5.5**	15	57	6
K4S40E 060S	**6.0**	16	57	6
K4S40E 070S	**7.0**	20	63	8
K4S40E 080S	**8.0**	20	63	8
K4S40E 090S	**9.0**	22	72	9
K4S40E 100S	**10.0**	22	72	10

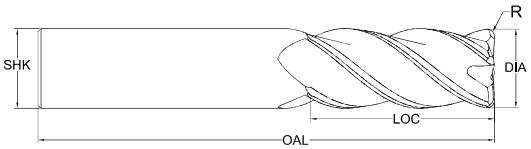
K4S40ER

Work Materials

P	M	K	S	H
■	□	■	□	■

SOLID CARBIDE 4-FLUTE CORNER RADIUS END MILL

4刃钨钢R-角平端铣刀



DIA 3.0 - 12.0mm

FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.

DIA Tolerance	h9
SHK Tolerance	h6

PRODUCT CODE	DIA	R	LOC	OAL	SHK
K4S40ER 02 030S	3.0	0.2	9	38	3
K4S40ER 05 030S	3.0	0.5	9	38	3
K4S40ER 02 040S	4.0	0.2	12	50	4
K4S40ER 05 040S	4.0	0.5	12	50	4
K4S40ER 10 040S	4.0	1.0	12	50	4
K4S40ER 05 050S	5.0	0.5	15	50	5
K4S40ER 10 050S	5.0	1.0	15	50	5
K4S40ER 05 060S	6.0	0.5	16	57	6
K4S40ER 10 060S	6.0	1.0	16	57	6
K4S40ER 15 060S	6.0	1.5	16	57	6
K4S40ER 05 080S	8.0	0.5	20	63	8
K4S40ER 10 080S	8.0	1.0	20	63	8
K4S40ER 15 080S	8.0	1.5	20	63	8
K4S40ER 20 080S	8.0	2.0	20	63	8
K4S40ER 05 100S	10.0	0.5	22	72	10
K4S40ER 10 100S	10.0	1.0	22	72	10
K4S40ER 15 100S	10.0	1.5	22	72	10
K4S40ER 20 100S	10.0	2.0	22	72	10
K4S40ER 05 120S	12.0	0.5	25	73	12
K4S40ER 10 120S	12.0	1.0	25	73	12
K4S40ER 15 120S	12.0	1.5	25	73	12
K4S40ER 20 120S	12.0	2.0	25	73	12
K4S40ER 30 120S	12.0	3.0	25	73	12

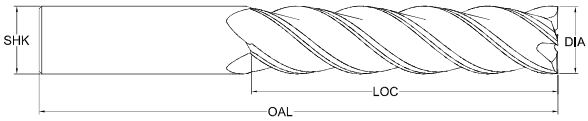
K4S40ELF

Work Materials

P	M	K	S	H
■	□	■	□	■

SOLID CARBIDE 4-FLUTE LONG FLUTE SQUARE END MILL

4刃钨钢长刃平端铣刀



FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.

PRODUCT CODE	DIA	LOC	OAL	SHK
K4S40ELF 03 030S	**3.0**	19	60	3
K4S40ELF 06 030S	**3.0**	19	75	6
K4S40ELF 04 040S	**4.0**	19	60	4
K4S40ELF 06 040S	**4.0**	19	75	6
K4S40ELF 05 050S	**5.0**	19	60	5
K4S40ELF 06 050S	**5.0**	19	75	6
K4S40ELF 06 060S	**6.0**	31	75	6
K4S40ELF 08 080S	**8.0**	31	75	8
K4S40ELF 10 100S	**10.0**	31	75	10
K4S40ELF 12 120S	**12.0**	50	125	12
K4S40ELF 14 140S	**14.0**	57	125	14
K4S40ELF 16 160S	**16.0**	57	125	16
K4S40ELF 18 180S	**18.0**	57	125	18
K4S40ELF 20 200S	**20.0**	57	125	20

DIA Tolerance	h9
SHK Tolerance	h6

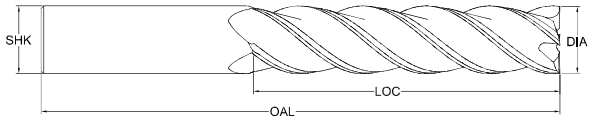
K4S40EXLF

Work Materials

P	M	K	S	H
■	□	■	□	■

SOLID CARBIDE 4-FLUTE EXTRA LONG FLUTE SQUARE END MILL

4刃钨钢特长刃平端铣刀



FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.

PRODUCT CODE	DIA	LOC	OAL	SHK
K4S40EXLF 03 030S	3.0	25	100	3
K4S40EXLF 06 030S	3.0	25	100	6
K4S40EXLF 04 040S	4.0	31	100	4
K4S40EXLF 06 040S	4.0	31	100	6
K4S40EXLF 05 050S	5.0	31	100	5
K4S40EXLF 06 050S	5.0	31	100	6
K4S40EXLF 06 060S	6.0	38	100	6
K4S40EXLF 08 080S	8.0	41	100	8
K4S40EXLF 10 100S	10.0	57	125	10
K4S40EXLF 12 120S	12.0	75	150	12
K4S40EXLF 14 140S	14.0	75	150	14
K4S40EXLF 16 160S	16.0	75	150	16
K4S40EXLF 18 180S	18.0	75	150	18
K4S40EXLF 20 200S	20.0	75	150	20

DIA Tolerance	h9
SHK Tolerance	h6

K4S40ELS

Work Materials

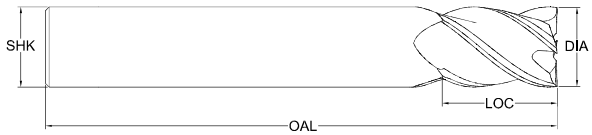
P	M	K	S	H
■	□	■	□	■

SOLID CARBIDE 4-FLUTE LONG SHANK SQUARE END MILL

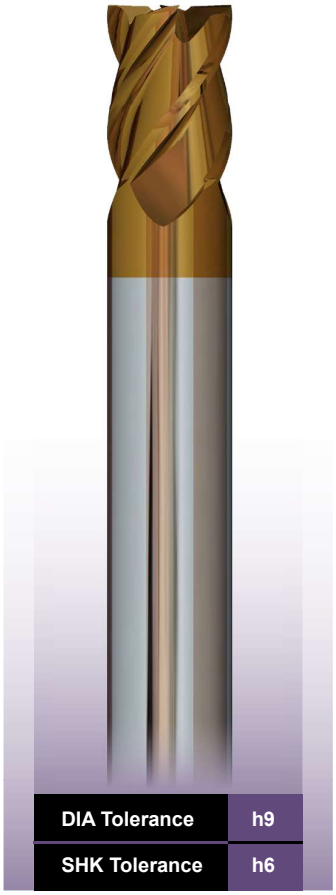
4刃钨钢长柄平端铣刀

FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.
- Long shank for extra reach of cut areas.



PRODUCT CODE	DIA	LOC	OAL	SHK
K4S40ELS 03 030S	3.0	5	100	3
K4S40ELS 06 030S	3.0	5	100	6
K4S40ELS 04 040S	4.0	8	100	4
K4S40ELS 06 040S	4.0	8	100	6
K4S40ELS 05 050S	5.0	9	100	5
K4S40ELS 06 050S	5.0	9	100	6
K4S40ELS 06 060S	6.0	10	100	6
K4S40ELS 08 080S	8.0	12	100	8
K4S40ELS 10 100S	10.0	14	125	10
K4S40ELS 12 120S	12.0	16	150	12
K4S40ELS 14 140S	14.0	22	150	14
K4S40ELS 16 160S	16.0	22	150	16
K4S40ELS 18 180S	18.0	26	150	18
K4S40ELS 20 200S	20.0	26	150	20



DIA Tolerance	h9
SHK Tolerance	h6

K4S40ERXLS (Diameter 2.0 - 8.0 mm)

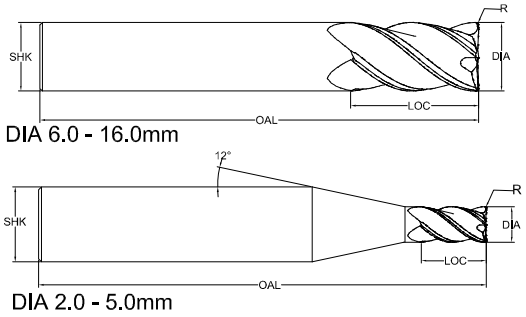
Work Materials

P	M	K	S	H
■	□	■	□	■

SOLID CARBIDE 4-FLUTE EXTRA LONG SHANK CORNER RADIUS END MILL

4刃钨钢特长柄R-角平端铣刀

ULTRA FG | HELIX 40° | R | GASH LAND | S



FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.
- Long shank for extra reach of cut areas.

DIA Tolerance	h9
SHK Tolerance	h6

PRODUCT CODE	DIA	R	LOC	OAL	SHK
K4S40ERXLS 02 020S	2.0	0.2	4	100	6
K4S40ERXLS 03 020S	2.0	0.3	4	100	6
K4S40ERXLS 02 030S	3.0	0.2	5	100	6
K4S40ERXLS 03 030S	3.0	0.3	5	100	6
K4S40ERXLS 05 030S	3.0	0.5	5	100	6
K4S40ERXLS 10 030S	3.0	1.0	5	100	6
K4S40ERXLS 02 040S	4.0	0.2	8	100	6
K4S40ERXLS 03 040S	4.0	0.3	8	100	6
K4S40ERXLS 05 040S	4.0	0.5	8	100	6
K4S40ERXLS 10 040S	4.0	1.0	8	100	6
K4S40ERXLS 02 050S	5.0	0.2	9	100	6
K4S40ERXLS 03 050S	5.0	0.3	9	100	6
K4S40ERXLS 05 050S	5.0	0.5	9	100	6
K4S40ERXLS 10 050S	5.0	1.0	9	100	6
K4S40ERXLS 02 060S	6.0	0.2	10	100	6
K4S40ERXLS 03 060S	6.0	0.3	10	100	6
K4S40ERXLS 05 060S	6.0	0.5	10	100	6
K4S40ERXLS 10 060S	6.0	1.0	10	100	6
K4S40ERXLS 02 080S	8.0	0.2	12	125	8
K4S40ERXLS 03 080S	8.0	0.3	12	125	8
K4S40ERXLS 05 080S	8.0	0.5	12	125	8
K4S40ERXLS 10 080S	8.0	1.0	12	125	8
K4S40ERXLS 20 080S	8.0	2.0	12	125	8

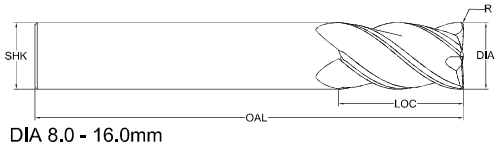
K4S40ERXLS (Diameter 10.0 - 16.0 mm)

Work Materials

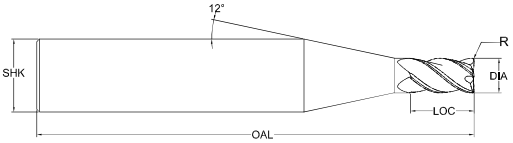
P	M	K	S	H
■	□	■	□	■

SOLID CARBIDE 4-FLUTE EXTRA LONG SHANK CORNER RADIUS END MILL

4刃钨钢特长柄R-角平端铣刀



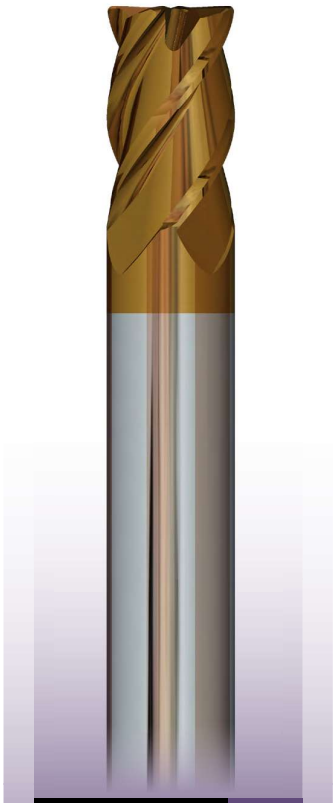
DIA 8.0 - 16.0mm



DIA 2.0 - 5.0mm

FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.
- Long shank for extra reach of cut areas.



DIA Tolerance	h9
SHK Tolerance	h6

PRODUCT CODE	DIA	R	LOC	OAL	SHK
K4S40ERXLS 02 100S	10.0	0.2	14	125	10
K4S40ERXLS 03 100S	10.0	0.3	14	125	10
K4S40ERXLS 05 100S	10.0	0.5	14	125	10
K4S40ERXLS 10 100S	10.0	1.0	14	125	10
K4S40ERXLS 15 100S	10.0	1.5	14	125	10
K4S40ERXLS 20 100S	10.0	2.0	14	125	10
K4S40ERXLS 02 120S	12.0	0.2	16	150	12
K4S40ERXLS 03 120S	12.0	0.3	16	150	12
K4S40ERXLS 05 120S	12.0	0.5	16	150	12
K4S40ERXLS 10 120S	12.0	1.0	16	150	12
K4S40ERXLS 20 120S	12.0	2.0	16	150	12
K4S40ERXLS 03 160S	16.0	0.3	9	150	16
K4S40ERXLS 05 160S	16.0	0.5	9	150	16
K4S40ERXLS 10 160S	16.0	1.0	9	150	16
K4S40ERXLS 20 160S	16.0	2.0	10	150	16
K4S40ERXLS 30 160S	16.0	3.0	10	150	16

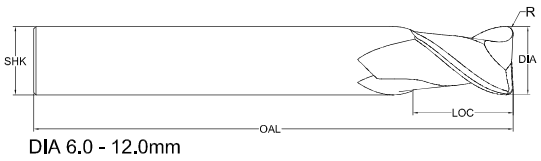
K2S40ERL

Work Materials

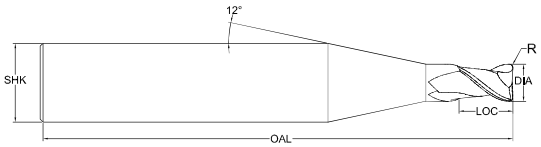
P	M	K	S	H
■	□	■	□	■

SOLID CARBIDE 2-FLUTE LONG SHANK CORNER RADIUS END MILL

2刃钨钢长柄R-角平端铣刀



DIA 6.0 - 12.0mm



DIA 2.0 - 5.0mm

FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.

DIA Tolerance	h9
SHK Tolerance	h6

PRODUCT CODE	DIA	R	LOC	OAL	SHK
K2S40ERL 03 020S	**2.0**	0.3	4	100	6
K2S40ERL 03 030S	**3.0**	0.3	5	100	6
K2S40ERL 05 030S	**3.0**	0.5	5	100	6
K2S40ERL 03 040S	**4.0**	0.3	8	100	6
K2S40ERL 05 040S	**4.0**	0.5	8	100	6
K2S40ERL 03 050S	**5.0**	0.3	9	100	6
K2S40ERL 05 050S	**5.0**	0.5	9	100	6
K2S40ERL 03 060S	**6.0**	0.3	10	100	6
K2S40ERL 05 060S	**6.0**	0.5	10	100	6
K2S40ERL 10 060S	**6.0**	1.0	10	100	6
K2S40ERL 03 080S	**8.0**	0.3	12	100	8
K2S40ERL 05 080S	**8.0**	0.5	12	100	8
K2S40ERL 10 080S	**8.0**	1.0	12	100	8
K2S40ERL 05 100S	**10.0**	0.5	14	125	10
K2S40ERL 10 100S	**10.0**	1.0	14	125	10
K2S40ERL 20 100S	**10.0**	2.0	14	125	10
K2S40ERL 05 120S	**12.0**	0.5	16	150	12
K2S40ERL 10 120S	**12.0**	1.0	16	150	12
K2S40ERL 20 120S	**12.0**	2.0	16	150	12

K4S40EL

Work Materials

P	M	K	S	H
■	□	■	□	■

SOLID CARBIDE 4-FLUTE LONG NECK RELIEF SQUARE END MILL

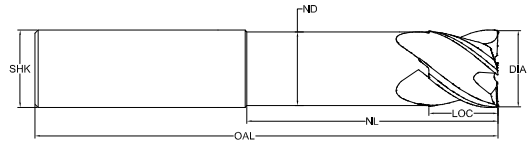
4刃钨钢长颈深沟平端铣刀

ULTRA FG | HELIX 40° | GASH LAND | S

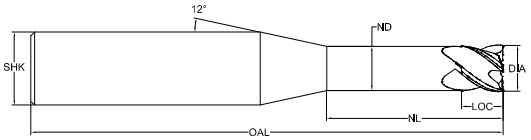
FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.

DIA Tolerance	h9
SHK Tolerance	h6



DIA 6.0 - 20.0mm



DIA 3.0 - 5.0mm

PRODUCT CODE	DIA	ND	LOC	NL	OAL	SHK
K4S40EL 30 030S	**3.0**	2.88	4	30	75	6
K4S40EL 32 040S	**4.0**	3.84	5	32	75	6
K4S40EL 32 050S	**5.0**	4.98	5	32	75	6
K4S40EL 40 060S	**6.0**	5.98	8	40	75	6
K4S40EL 40 080S	**8.0**	7.98	8	40	75	8
K4S40EL 60 100S	**10.0**	9.97	9	60	100	10
K4S40EL 60 120S	**12.0**	11.97	9	60	100	12
K4S40EL 85 140S	**14.0**	13.96	10	85	125	14
K4S40EL 85 160S	**16.0**	15.96	10	85	125	16
K4S40EL 85 180S	**18.0**	17.95	10	85	125	18
K4S40EL 85 200S	**20.0**	19.95	12	85	125	20

K2S40ELN-M

Work Materials

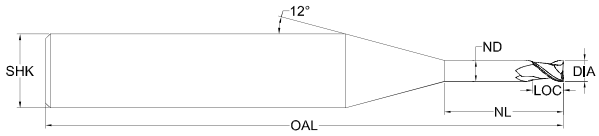
P	M	K	S	H
■	□	■	□	■

SOLID CARBIDE 2-FLUTE MINIATURE LONG NECK SQUARE END MILL

2刃钨钢微型长颈平端铣刀

FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.



PRODUCT CODE	DIA	ND	LOC	NL	OAL	SHK
K2S40ELN 005 002S	**0.2**	0.17	0.3	0.5	50	4
K2S40ELN 010 002S	**0.2**	0.17	0.3	1	50	4
K2S40ELN 015 002S	**0.2**	0.17	0.3	1.5	50	4
K2S40ELN 010 003S	**0.3**	0.27	0.4	1	50	4
K2S40ELN 020 003S	**0.3**	0.27	0.4	2	50	4
K2S40ELN 030 003S	**0.3**	0.27	0.4	3	50	4
K2S40ELN 020 004S	**0.4**	0.37	0.6	2	50	4
K2S40ELN 030 004S	**0.4**	0.37	0.6	3	50	4
K2S40ELN 040 004S	**0.4**	0.37	0.6	4	50	4
K2S40ELN 050 004S	**0.4**	0.37	0.6	5	50	4
K2S40ELN 020 005S	**0.5**	0.45	0.7	2	50	4
K2S40ELN 040 005S	**0.5**	0.45	0.7	4	50	4
K2S40ELN 060 005S	**0.5**	0.45	0.7	6	50	4
K2S40ELN 080 005S	**0.5**	0.45	0.7	8	50	4
K2S40ELN 020 006S	**0.6**	0.55	0.9	2	50	4
K2S40ELN 040 006S	**0.6**	0.55	0.9	4	50	4
K2S40ELN 060 006S	**0.6**	0.55	0.9	6	50	4
K2S40ELN 080 006S	**0.6**	0.55	0.9	8	50	4
K2S40ELN 100 006S	**0.6**	0.55	0.9	10	50	4
K2S40ELN 040 008S	**0.8**	0.75	1.2	4	50	4
K2S40ELN 060 008S	**0.8**	0.75	1.2	6	50	4
K2S40ELN 080 008S	**0.8**	0.75	1.2	8	50	4
K2S40ELN 100 008S	**0.8**	0.75	1.2	10	50	4
K2S40ELN 120 008S	**0.8**	0.75	1.2	12	50	4

DIA Tolerance	h9
SHK Tolerance	h6

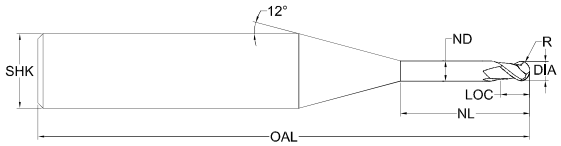
K2S40BLN-M

Work Materials

P	M	K	S	H
■	□	■	□	■

SOLID CARBIDE 2-FLUTE MINIATURE LONG NECK BALLNOSE END MILL

2刃钨钢微型长颈圆头铣刀



FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.

DIA Tolerance	h9
SHK Tolerance	h6

PRODUCT CODE	DIA	ND	LOC	NL	OAL	SHK
K2S40BLN 005 002S	**0.2**	0.15	0.2	0.5	50	4
K2S40BLN 010 002S	**0.2**	0.15	0.2	1	50	4
K2S40BLN 015 002S	**0.2**	0.15	0.2	1.5	50	4
K2S40BLN 010 003S	**0.3**	0.25	0.3	1	50	4
K2S40BLN 020 003S	**0.3**	0.25	0.3	2	50	4
K2S40BLN 030 003S	**0.3**	0.25	0.3	3	50	4
K2S40BLN 010 004S	**0.4**	0.35	0.4	1	50	4
K2S40BLN 020 004S	**0.4**	0.35	0.4	2	50	4
K2S40BLN 030 004S	**0.4**	0.35	0.4	3	50	4
K2S40BLN 040 004S	**0.4**	0.35	0.4	4	50	4
K2S40BLN 050 004S	**0.4**	0.35	0.4	5	50	4
K2S40BLN 020 005S	**0.5**	0.45	0.4	2	50	4
K2S40BLN 030 005S	**0.5**	0.45	0.4	3	50	4
K2S40BLN 040 005S	**0.5**	0.45	0.4	4	50	4
K2S40BLN 050 005S	**0.5**	0.55	0.4	5	50	4
K2S40BLN 060 005S	**0.5**	0.55	0.4	6	50	4
K2S40BLN 080 005S	**0.5**	0.55	0.4	8	50	4
K2S40BLN 020 006S	**0.6**	0.55	0.5	2	50	4
K2S40BLN 030 006S	**0.6**	0.55	0.5	3	50	4
K2S40BLN 040 006S	**0.6**	0.55	0.5	4	50	4
K2S40BLN 050 006S	**0.6**	0.75	0.5	5	50	4
K2S40BLN 060 006S	**0.6**	0.75	0.5	6	50	4
K2S40BLN 080 006S	**0.6**	0.75	0.5	8	50	4
K2S40BLN 020 008S	**0.8**	0.75	1.2	2	50	4
K2S40BLN 040 008S	**0.8**	0.75	1.2	4	50	4
K2S40BLN 050 008S	**0.8**	0.75	1.2	5	50	4
K2S40BLN 060 008S	**0.8**	0.75	1.2	6	50	4
K2S40BLN 080 008S	**0.8**	0.75	1.2	8	50	4
K2S40BLN 100 008S	**0.8**	0.75	1.2	10	50	4

K2S40BL

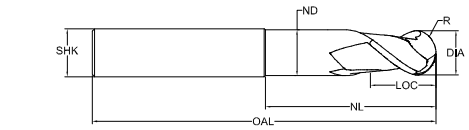
Work Materials

P	M	K	S	H
■	□	■	□	■

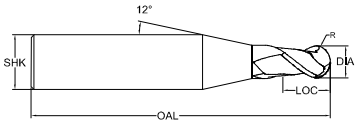
SOLID CARBIDE 2-FLUTE NECK RELIEF BALLNOSE END MILL

2刃钨钢深沟圆头铣刀

ULTRA FG | HELIX 40° | S



DIA 3.0 - 20.0mm



DIA 1.0 - 2.5mm

FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.

DIA Tolerance	h9
SHK Tolerance	h6

PRODUCT CODE	DIA	R	ND	LOC	NL	OAL	SHK
K2S40BL 07 010S	**1.0**	0.5	0.99	3	7	60	3
K2S40BL 10 015S	**1.5**	0.75	1.49	3	10	60	3
K2S40BL 14 020S	**2.0**	1	1.99	4	14	60	3
K2S40BL 18 025S	**2.5**	1.25	2.49	4	18	60	3
K2S40BL 21 030S	**3.0**	1.5	2.88	5	21	60	3
K2S40BL 28 040S	**4.0**	2	3.84	8	28	75	4
K2S40BL 32 050S	**5.0**	2.5	4.98	9	32	75	5
K2S40BL 40 060S	**6.0**	3	5.98	10	40	75	6
K2S40BL 40 080S	**8.0**	4	7.98	10	40	75	8
K2S40BL 60 100S	**10.0**	5	9.97	12	60	100	10
K2S40BL 60 120S	**12.0**	6	11.97	16	60	100	12
K2S40BL 80 140S	**14.0**	7	13.96	32	80	100	14
K2S40BL 80 160S	**16.0**	8	15.96	32	80	100	16
K2S40BL 80 180S	**18.0**	9	17.95	38	80	100	18
K2S40BL 80 200S	**20.0**	10	19.95	38	80	100	20

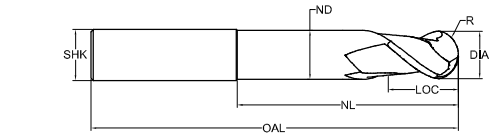
K2S40BXL

Work Materials

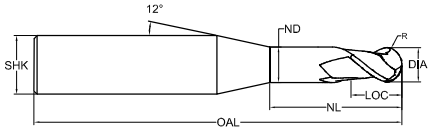
P	M	K	S	H
■	□	■	□	■

SOLID CARBIDE 2-FLUTE LONG NECK RELIEF BALLNOSE END MILL

2刃钨钢长颈深沟圆头铣刀



DIA 3.0 - 20.0mm



DIA 1.0 - 2.5mm

FEATURES:

- Ideal for High Speed Cutting applications of ferrous materials up to 55 HRc hardness.
- Designed in high helix and S-Coating provides excellent wear resistant for extended tool life.

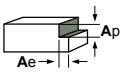
DIA Tolerance	h9
SHK Tolerance	h6

PRODUCT CODE	DIA	R	ND	LOC	NL	OAL	SHK
K2S40BXL 010 010S	**1.0**	0.5	0.99	3	10	100	3
K2S40BXL 015 015S	**1.5**	0.75	1.49	3	15	100	3
K2S40BXL 020 020S	**2.0**	1	1.99	4	20	100	3
K2S40BXL 025 025S	**2.5**	1.25	2.49	4	25	100	3
K2S40BXL 030 030S	**3.0**	1.5	2.88	5	30	100	3
K2S40BXL 040 040S	**4.0**	2	3.84	8	40	100	4
K2S40BXL 050 050S	**5.0**	2.5	4.98	9	50	100	5
K2S40BXL 060 060S	**6.0**	3	5.98	10	60	150	6
K2S40BXL 080 080S	**8.0**	4	7.98	10	80	150	8
K2S40BXL 100 100S	**10.0**	5	9.97	12	100	150	10
K2S40BXL 110 120S	**12.0**	6	11.97	16	110	150	12
K2S40BXL 150 140S	**14.0**	7	13.96	32	150	200	14
K2S40BXL 150 160S	**16.0**	8	15.96	32	150	200	16
K2S40BXL 150 180S	**18.0**	9	17.95	38	150	200	18
K2S40BXL 150 200S	**20.0**	10	19.95	38	150	200	20

Operating Parameters For Spiral 40 Series

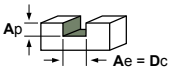
K3S40E

SIDE MILLING 侧面切削



ISO WORK MATERIAL CODE	P K Carbon Steel & Cast Iron (~25HRC)		P Alloy Steel (~30HRC)		P Prehardened Steel (35~45HRC)		M Stainless Steel (<35HRC)		S Titanium & High Temperature Alloy		H Hardened Steel (45~55HRC)	
Dc (mm)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
1.0	38190	680	35010	1470	31830	660	19090	515	15270	410	15910	430
1.5	37500	690	34700	1500	32500	660	18200	530	14000	440	14300	450
2.0	19090	745	17500	1520	15915	660	9540	570	7630	455	7950	470
2.5	17500	790	16900	1520	14700	700	7900	590	6400	470	6550	490
3.0	12730	840	11670	1540	10610	795	6360	610	5090	480	5300	500
4.0	9540	830	8750	1730	7958	780	4775	670	3820	530	3970	560
5.0	7630	960	7000	1825	6366	895	3820	710	3050	560	3180	580
6.0	6366	1010	5836	1900	5305	930	3180	705	2540	560	2650	585
8.0	5450	1110	5000	1900	4547	1030	2725	720	2180	580	2270	600
10.0	4775	1160	4375	1970	3979	1070	2380	750	1910	600	1980	630
Depth of Cut (DOC)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)
	1.2 x **D**c	0.7 x **D**c	1.2 x **D**c	0.7 x **D**c	1.2 x **D**c	0.6 x **D**c	0.5 x **D**c	0.1 x **D**c	0.5 x **D**c	0.1 x **D**c	0.5 x **D**c	0.1 x **D**c

SLOT MILLING 槽切削



1.0	41380	745	38190	1140	35010	735	22282	535	18140	435	19090	450
1.5	42500	780	37600	1400	34300	750	21800	535	17820	435	18100	450
2.0	20690	800	19080	1200	17500	785	11150	535	9070	435	9540	450
2.5	19500	810	18200	1220	16800	785	10700	535	8250	450	8600	470
3.0	13790	830	12730	1260	11670	770	7420	570	6048	470	6360	490
4.0	10340	1020	9540	1460	8750	945	5570	630	4530	515	4770	540
5.0	8270	1140	7630	1535	7003	1070	4450	730	3620	590	3820	630
6.0	6890	1138	6360	1585	5830	1060	3710	730	3020	590	3180	630
8.0	5900	1200	5450	1620	5000	1125	3180	800	2590	650	2720	680
10.0	5173	1220	4770	1660	4370	1150	2780	800	2260	650	2380	680
Depth of Cut (DOC)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)
	1.0 x **D**c	1.0 x **D**c	1.0 x **D**c	1.0 x **D**c	1.0 x **D**c	1.0 x **D**c	0.2 x **D**c	1.0 x **D**c	0.2 x **D**c	1.0 x **D**c	0.2 x **D**c	1.0 x **D**c

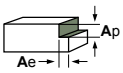
Dc = Cutter Diameter (mm) 切削直径
Ap = Depth of cut (mm) 切削深度

n = Spindle Speed (mm^{-1}) 转速

Vf = Feed Rate (mm/min) 进给速
Ae = Width of Cut (mm) 切削宽度

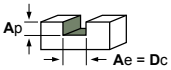
K4S40E

SIDE MILLING 侧面切削



ISO WORK MATERIAL CODE	P K Carbon Steel & Cast Iron (~25HRC)		P Alloy Steel (~30HRC)		P Prehardened Steel (35~45HRC)		M Stainless Steel (<35HRC)		S Titanium & High Temperature Alloy		H Hardened Steel (45~55HRC)	
Dc (mm)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
1.0	41380	497	38197	573	35014	420	22282	334	18144	272	19099	286
2.0	20690	559	19099	573	17507	473	11141	368	9072	299	9549	315
3.0	13793	579	12732	611	11671	490	7427	379	6048	308	6366	325
4.0	10345	590	9549	630	8754	499	5570	401	4536	327	4775	358
5.0	8276	646	7639	642	7003	546	4456	428	3629	348	3820	367
6.0	6897	662	6366	649	5836	560	3714	435	3024	354	3183	382
8.0	5173	667	4775	659	4377	565	2785	468	2268	381	2387	408
10.0	4138	757	3820	676	3501	641	2228	501	1814	408	1910	430
Depth of Cut (DOC)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)
	1.2 x **D**c	0.7 x **D**c	1.2 x **D**c	0.7 x **D**c	1.2 x **D**c	0.6 x **D**c	1.2 x **D**c	0.4 x **D**c	1.2 x **D**c	0.4 x **D**c	1.2 x **D**c	0.4 x **D**c

SLOT MILLING 槽切削



1.0	38197	344	35014	525	31831	382	20690	310	15915	239	15915	239
2.0	19099	401	17507	525	15915	382	10345	341	7958	263	7958	263
3.0	12732	420	11671	525	10610	382	6897	331	5305	255	5305	255
4.0	9549	430	8754	525	7958	406	5173	372	3979	286	3979	286
5.0	7639	458	7003	546	6366	420	4138	385	3183	296	3183	296
6.0	6366	477	5836	560	5305	430	3448	403	2653	310	2653	310
8.0	4775	473	4377	578	3979	430	2586	473	1989	364	1989	364
10.0	3820	481	3501	620	3183	449	2069	490	1592	377	1592	387
Depth of Cut (DOC)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)
	1.2 x **D**c	1.0 x **D**c	1.2 x **D**c	1.0 x **D**c	1.0 x **D**c	1.0 x **D**c	0.5 x **D**c	1.0 x **D**c	0.5 x **D**c	1.0 x **D**c	0.5 x **D**c	1.0 x **D**c

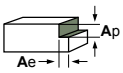
Dc = Cutter Diameter (mm) 切削直径
Ap = Depth of cut (mm) 切削深度

n = Spindle Speed (mm^{-1}) 转速

Vf = Feed Rate (mm/min) 进给速
Ae = Width of Cut (mm) 切削宽度

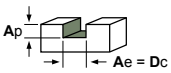
K4S40ER

SIDE MILLING 侧面切削



ISO WORK MATERIAL CODE	H	Hardened Steel		
	45 ~ 55HRc		55 ~ 60HRc	
Dc (mm)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
3.0	6360	745	5305	668
4.0	4775	870	3979	716
5.0	3820	835	3183	764
6.0	3180	870	2653	796
8.0	2385	795	1989	722
10.0	1910	750	1592	673
12.0	1590	790	1326	720
Depth of Cut (DOC)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)
	0.12 x **D**c	1.0 x **D**c	0.09 x **D**c	1.0 x **D**c

SLOT MILLING 槽切削

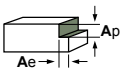


3.0	5830	455	4775	186
4.0	4375	450	3581	183
5.0	3501	460	2865	232
6.0	2915	499	2387	258
8.0	2185	420	1790	242
10.0	1750	373	1432	193
12.0	1450	411	1194	226
Depth of Cut (DOC)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)
	0.4 x **D**c	0.3 x **D**c	0.3 x **D**c	0.3 x **D**c

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

K4S40ELF

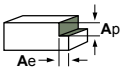
SIDE MILLING 侧面切削



ISO WORK MATERIAL CODE	H	Hardened Steel		
	45 ~ 55HRc		55 ~ 60HRc	
Dc (mm)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
3.0	6360	590	5305	540
4.0	4770	700	3975	573
5.0	3820	675	3180	610
6.0	3180	695	2650	635
8.0	2385	635	1980	570
10.0	1910	600	1590	540
12.0	1590	640	1325	570
14.0	1360	610	1135	550
16.0	1190	580	995	525
18.0	1060	600	880	520
20.0	955	590	795	520
Depth of Cut (DOC)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)
	0.4 x **D**c	0.3 x **D**c	0.3 x **D**c	0.3 x **D**c

K4S40EXLF

SIDE MILLING 侧面切削

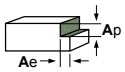


3.0	6360	515	5300	475
4.0	4775	600	3975	500
5.0	3820	580	3180	535
6.0	3180	610	2650	555
8.0	2385	550	1985	500
10.0	1910	525	1590	470
12.0	1590	550	1325	500
14.0	1360	530	1130	480
16.0	1190	510	995	465
18.0	1060	510	880	470
20.0	955	510	795	470
Depth of Cut (DOC)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)
	0.4 x **D**c	0.3 x **D**c	0.3 x **D**c	0.3 x **D**c

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

K4S40ELS

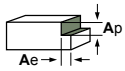
SIDE MILLING 侧面切削



ISO WORK MATERIAL CODE	P K Carbon Steel & Cast Iron (~25HRC)		P Alloy Steel (~30HRC)		P Prehardened Steel (35~45HRC)		M Stainless Steel (<35HRC)		S Titanium & High Temperature Alloy		H Hardened Steel (45~55HRC)	
Dc (mm)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
3.0	13793	497	12732	535	11671	420	7427	334	6048	272	6366	286
4.0	10345	497	9549	544	8754	420	5570	351	4536	286	4775	301
5.0	8276	546	7639	550	7003	462	4456	361	3629	294	3820	309
6.0	6897	559	6366	554	5836	473	3714	368	3024	299	3183	325
8.0	5173	559	4775	559	4377	473	2785	401	2268	327	2387	344
10.0	4138	646	3820	573	3501	546	2228	428	1814	348	1910	367
12.0	3448	683	3183	573	2918	578	1857	440	1512	358	1592	368
14.0	2956	692	2728	614	2501	585	1592	468	1296	381	1364	389
16.0	2586	667	2387	602	2188	565	1393	472	1134	384	1194	405
18.0	2299	724	2122	611	1945	613	1238	494	1008	402	1061	433
20.0	2069	770	1910	636	1751	651	1114	511	907	416	955	441
Depth of Cut (DOC)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)
	1.2 x **Dc**	0.3 x **Dc**	1.2 x **Dc**	0.3 x **Dc**	1.2 x **Dc**	0.3 x **Dc**	0.5 x **Dc**	0.1 x **Dc**	0.5 x **Dc**	0.1 x **Dc**	0.5 x **Dc**	0.1 x **Dc**

K4S40ERXLS

SIDE MILLING 侧面切削

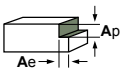


2.0	20690	620	19099	630	17507	525	11141	334	9072	327	9549	344
3.0	13793	455	12732	458	11671	385	7427	312	6048	254	6366	267
4.0	10345	460	9549	485	8754	394	5570	317	4536	259	4775	272
5.0	8276	490	7639	480	7003	420	4456	334	3629	272	3820	287
6.0	6897	490	6366	495	5836	420	3714	345	3024	281	3183	296
8.0	5173	510	4775	500	4377	433	2785	359	2268	293	2387	308
Depth of Cut (DOC)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)
	1.5 x **Dc**	0.3 x **Dc**	1.5 x **Dc**	0.3 x **Dc**	1.5 x **Dc**	0.3 x **Dc**	0.5 x **Dc**	0.1 x **Dc**	0.5 x **Dc**	0.1 x **Dc**	0.5 x **Dc**	0.1 x **Dc**

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

K2S40ERL

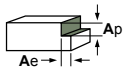
SIDE MILLING 侧面切削



ISO WORK MATERIAL CODE	P K Carbon Steel & Cast Iron (~25HRC)		P Alloy Steel (~30HRC)		P Prehardened Steel (35~45HRC)		M Stainless Steel (<35HRC)		S Titanium & High Temperature Alloy		H Hardened Steel (45~55HRC)	
Dc (mm)	**n** (min^{-1})	**Vf** (mm/min)	**n** (min^{-1})	**Vf** (mm/min)	**n** (min^{-1})	**Vf** (mm/min)	**n** (min^{-1})	**Vf** (mm/min)	**n** (min^{-1})	**Vf** (mm/min)	**n** (min^{-1})	**Vf** (mm/min)
2.0	19090	455	17500	525	15915	430	9550	370	7480	290	7960	285
3.0	12730	495	11670	525	10610	445	6365	360	4985	285	5300	300
4.0	9550	485	8750	550	7960	455	4775	385	3740	300	3980	310
5.0	7640	505	7000	545	6365	460	3820	400	2990	315	3180	325
6.0	6360	515	5835	560	5300	475	3180	430	2490	335	2650	340
8.0	4770	585	4370	565	3980	550	2385	455	1870	360	1990	370
10.0	3820	615	3501	575	3180	570	1910	465	1495	365	1590	365
12.0	3180	640	2910	600	2650	580	1590	480	1245	375	1325	385
Depth of Cut (DOC)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)
	1.2 x **Dc**	0.7 x **Dc**	1.2 x **Dc**	0.3 x **Dc**	1.2 x **Dc**	0.3 x **Dc**	1.0 x **Dc**	0.1 x **Dc**	1.0 x **Dc**	0.1 x **Dc**	1.2 x **Dc**	0.1 x **Dc**

K4S40EL

SIDE MILLING 侧面切削



3.0	6360	380	5305	540
4.0	4775	440	3975	570
5.0	3820	560	3180	610
6.0	3180	695	2650	635
8.0	2385	635	1989	580
10.0	1910	600	1590	540
12.0	1590	640	1326	575
14.0	1360	615	1135	555
16.0	1190	585	990	525
18.0	1060	600	885	540
20.0	955	590	796	540
Depth of Cut (DOC)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)
	1.0 x **Dc**	0.25 x **Dc**	1.0 x **Dc**	0.2 x **Dc**

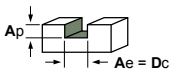
Dc = Cutter Diameter (mm) 切削直径
Ap = Depth of cut (mm) 切削深度

n = Spindle Speed (mm^{-1}) 转速

Vf = Feed Rate (mm/min) 进给速
Ae = Width of Cut (mm) 切削宽度

K2S40ELN-M

SLOT MILLING 槽切削

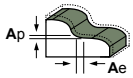


ISO WORK MATERIAL CODE	Neck Length	H	Hardened Steel				
		45 ~ 55HRc			55 ~ 60HRc		
Dc (mm)	NL (mm)	Ap (mm)	n (min^{-1})	Vf (mm/min)	Ap (mm)	n (min^{-1})	Vf (mm/min)
0.2	0.5	0.010	33420	400	0.009	31830	380
	1	0.007	33420	400	0.006	31830	380
	1.5	0.004	30230	360	0.004	28640	340
0.3	1	0.011	29700	445	0.009	27580	740
	2	0.006	26520	315	0.005	25460	380
	3	0.004	26520	315	0.004	25460	300
0.4	2	0.014	23870	500	0.013	22280	865
	3	0.008	21480	450	0.007	19890	415
	4	0.005	21480	450	0.005	19890	295
	5	0.005	19090	345	0.005	17500	260
0.5	2	0.016	24190	760	0.014	17825	695
	4	0.010	21645	645	0.009	15915	430
	6	0.007	19090	400	0.006	15915	285
	8	0.004	19090	225	0.004	14000	165
0.6	2	0.021	23870	715	0.019	22280	535
	4	0.012	21751	650	0.011	20160	540
	6	0.008	21751	650	0.007	20160	540
	8	0.008	19099	515	0.007	18030	375
	10	0.005	19099	510	0.004	18038	375
0.8	4	0.028	23873	710	0.025	22282	535
	6	0.016	21486	645	0.014	20292	545
	8	0.010	21486	645	0.009	20292	545
	10	0.010	19099	515	0.009	17905	370
	12	0.006	19099	515	0.005	17905	370

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

K2S40BLN-M

CONTOUR MILLING 等高切削

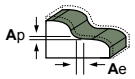


ISO WORK MATERIAL CODE	Neck Length	P K Carbon Steel & Cast Iron (~25HRC)			M Stainless Steel (<35HRC)				
						High Machinability		Low Machinability	
Dc (mm)	NL (mm)	Ap (mm)	n (min^{-1})	Vf (mm/min)	Ap (mm)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
0.2	0.5	0.019	39780	595	0.018	39780	477	23873	143
	1	0.013	39780	595	0.013	39780	477	23873	143
	1.5	0.007	39780	475	0.007	39789	477	23873	143
0.3	1	0.020	40310	845	0.019	40319	726	24192	290
	2	0.011	40310	725	0.011	40319	726	24192	290
	3	0.007	40310	725	0.007	40319	726	24192	290
0.4	1	0.037	39780	835	0.036	39789	836	23873	286
	2	0.026	39780	835	0.025	39789	836	23873	286
	3	0.015	39780	716	0.014	38993	585	23396	211
	4	0.009	39780	715	0.009	38993	585	23396	211
	5	0.007	38190	570	0.007	34218	513	20531	185
0.5	2	0.033	40100	1200	0.032	36287	1089	21772	392
	3	0.028	36280	980	0.027	32468	877	19481	292
	4	0.019	36280	980	0.018	32468	877	19481	292
	5	0.017	36280	980	0.016	32468	877	19481	292
	6	0.012	31830	760	0.012	28648	773	17189	258
	8	0.007	31830	760	0.007	28648	773	17189	258
0.6	2	0.039	39780	1790	0.038	36075	1623	21221	573
	3	0.032	39780	1790	0.031	36075	1623	21221	573
	4	0.022	36075	1515	0.022	32362	1359	19417	466
	5	0.019	36075	1400	0.018	32362	1359	19417	466
	6	0.014	36075	1400	0.014	32362	1359	19417	466
	8	0.014	31830	1240	0.014	28648	1117	17189	413
0.8	2	0.075	40180	2170	0.072	35810	1934	21486	709
	4	0.052	40180	2170	0.050	35810	1934	21486	709
	5	0.042	35810	1715	0.041	32229	1547	19337	580
	6	0.030	35810	1715	0.029	32229	1547	19337	580
	8	0.019	31830	1525	0.018	28648	1375	17189	516
	10	0.019	31830	1430	0.018	28648	1289	17189	464

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

K2S40BLN-M

CONTOUR MILLING 等高切削

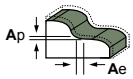


ISO WORK MATERIAL CODE	Neck Length	P Alloy Steel (~30HRC)			P Prehardened Steel (35~45HRC)			H Hardened Steel (45~55HRC)		
Dc (mm)	NL (mm)	Ap (mm)	n (min^{-1})	Vf (mm/min)	Ap (mm)	n (min^{-1})	Vf (mm/min)	Ap (mm)	n (min^{-1})	Vf (mm/min)
0.2	0.5	0.020	39780	475	0.016	39780	470	0.013	39780	350
	1	0.014	39780	475	0.011	39780	470	0.009	39780	350
	1.5	0.008	39780	475	0.006	39780	350	0.005	39780	350
0.3	1	0.021	40310	725	0.017	40310	720	0.014	40310	600
	2	0.012	40310	725	0.010	40310	605	0.008	40310	480
	3	0.008	40310	725	0.006	40310	605	0.005	40310	480
0.4	1	0.040	39780	835	0.032	39780	715	0.026	35810	530
	2	0.028	39780	835	0.022	39780	710	0.018	35810	530
	3	0.016	39780	715	0.013	36600	540	0.010	32620	390
	4	0.010	39780	715	0.008	36600	540	0.007	32620	390
	5	0.008	38190	570	0.006	32620	480	0.005	28640	340
0.5	2	0.035	40100	1200	0.028	33740	910	0.023	29920	800
	3	0.030	36280	980	0.024	30550	730	0.020	26730	640
	4	0.020	36280	980	0.016	30550	730	0.013	26730	640
	5	0.018	36280	980	0.014	30550	730	0.012	26730	640
	6	0.013	31830	760	0.010	27370	650	0.008	24190	580
	8	0.008	31830	760	0.006	27370	650	0.005	24190	580
0.6	2	0.042	39780	1790	0.034	33950	1320	0.027	30230	1080
	3	0.034	39780	1790	0.027	33950	1320	0.022	30230	1080
	4	0.024	36075	1515	0.019	30770	1100	0.016	27050	890
	5	0.020	36075	1405	0.016	30770	1100	0.013	27050	890
	6	0.015	36075	1405	0.012	30770	1100	0.010	27050	890
	8	0.015	31830	1240	0.012	27050	890	0.010	23870	710
0.8	2	0.080	40180	2170	0.064	33820	1620	0.052	29840	1340
	4	0.056	40180	2170	0.045	33820	1620	0.036	29840	1340
	5	0.045	35810	1710	0.036	30630	1280	0.029	27050	1130
	6	0.032	35810	1710	0.026	30630	1280	0.021	27050	1130
	8	0.020	31830	1520	0.016	27050	1130	0.013	23870	1000
	10	0.020	31830	1430	0.016	27050	1130	0.013	23870	930

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

K2S40BL

CONTOUR MILLING 等高切削



ISO WORK MATERIAL CODE	P K Carbon Steel & Cast Iron (~25HRC)		P Alloy Steel (~30HRC)		M Stainless Steel				P Prehardened Steel (35~45HRC)		H Hardened Steel			
					High Machinability		Low Machinability				45 ~ 55HRc		55 ~ 60HRc	
Dc (mm)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
1.0	63660	5150	47740	3580	47740	3860	22280	1800	31830	2290	23870	1280	15910	570
1.5	47750	4340	35800	3040	35800	3250	16710	1520	23870	1950	17900	1090	11930	490
2.0	31830	3530	23870	2500	23870	2650	11140	1230	15910	1620	11930	890	7950	400
2.5	26520	3290	19890	2320	19890	2470	9280	1150	13260	1490	9940	830	6630	370
3.0	21220	3050	15910	2190	15910	2290	7420	1060	10610	1360	7950	760	5300	350
4.0	15910	2530	11930	1820	11930	1890	5570	880	7950	1140	5960	640	3970	280
5.0	12730	2860	9540	2030	9540	2140	4450	1000	6360	1280	4770	710	3180	320
6.0	10610	2730	7950	1930	7950	2020	3710	940	5300	1220	3970	690	2650	300
8.0	7950	2140	5960	1540	5960	1710	2780	800	3970	960	2980	580	1980	250
10.0	6360	1830	4770	1440	4770	1510	2220	700	3180	910	2380	510	1590	220
12.0	5300	1680	3970	1320	3970	1390	1850	650	2650	840	1980	470	1320	210
14.0	4540	1650	3410	1180	3410	1240	1590	580	2270	750	1700	410	1130	185
16.0	3970	1510	2980	1090	2980	1140	1390	530	1980	680	1490	380	990	170
18.0	3530	1400	2650	1000	2650	1050	1230	490	1760	630	1320	350	880	150
20.0	3180	1320	2380	930	2380	980	1110	460	1590	590	1190	330	790	140
Depth of Cut (DOC)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)	**Ap** (mm)	**Ae** (mm)
	0.13x**Dc**	0.39x**Dc**	0.12x**Dc**	0.36x**Dc**	0.125x**Dc**	0.375x**Dc**	0.115x**Dc**	0.345x**Dc**	0.115x**Dc**	0.345x**Dc**	0.115x**Dc**	0.345x**Dc**	0.115x**Dc**	0.345x**Dc**

Dc = Cutter Diameter (mm) 切削直径
Ap = Depth of cut (mm) 切削深度
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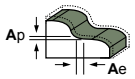
Ae = Width of Cut (mm) 切削宽度

K2S40BXL

CONTOUR MILLING 等高切削



ISO WORK MATERIAL CODE	P K Carbon Steel & Cast Iron (~25HRC)		P Alloy Steel (~30HRC)		M Stainless Steel				P Prehardened Steels (35~45HRC)		H Hardened Steel			
					High Machinability		Low Machinability				45 ~ 55HRc		55 ~ 60HRc	
Dc (mm)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
1.0	63660	4390	47740	3150	47740	3290	22280	1530	31830	2000	23870	1140	15900	525
1.5	47700	3750	35800	2670	35800	2820	16700	1300	23850	1680	17800	960	11920	440
2.0	31830	3150	23870	2200	23870	2360	11100	1100	15910	1380	11930	785	7950	358
2.5	26500	2900	19890	2050	19890	2180	9280	1010	13250	1290	9900	720	6620	330
3.0	21220	2670	15910	1910	15910	2000	7420	930	10610	1210	7950	660	5300	300
4.0	15910	2240	11930	1570	11930	1680	5570	780	7950	1000	5960	570	3970	250
5.0	12730	2480	9540	1770	9540	1860	4450	860	6360	1120	4770	630	3180	286
6.0	10610	2380	7950	1690	7950	1790	3710	830	5300	1060	3970	590	2650	270
8.0	7950	2000	5960	1430	5960	1500	2780	700	3970	890	2980	500	1980	225
10.0	6360	1770	4770	1270	4770	1330	2220	620	3180	800	2380	450	1590	200
12.0	5300	1620	3970	1170	3970	1230	1850	570	2650	730	1980	410	1320	180
14.0	4540	1440	3410	980	3410	1090	1590	510	2270	650	1700	365	1130	165
16.0	3970	1330	2980	940	2980	1000	1390	460	1980	600	1490	335	995	150
18.0	3530	1230	2650	870	2650	920	1230	430	1760	550	1320	310	880	140
20.0	3180	1160	2380	820	2380	850	1110	400	1590	520	1190	290	795	130
Depth of Cut (DOC)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)	**A**p (mm)	**A**e (mm)
	0.13x**D**c	0.39x**D**c	0.12x**D**c	0.36x**D**c	0.125x**D**c	0.375x**D**c	0.115x**D**c	0.345x**D**c	0.115x**D**c	0.345x**D**c	0.115x**D**c	0.345x**D**c	0.115x**D**c	0.345x**D**c

Dc = Cutter Diameter (mm) 切削直径
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