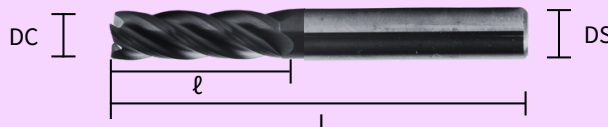




4 CARBIDE END MILL FLUTES

VARIABLE LEADS UNEQUAL SPACING OF TEETH

- ✓ USER FRIENDLY 3D TYPE
- ✓ AOI ORIGINAL COATING FOR GREATER WEAR AND FRACTURE RESISTANCE
- ✓ SUPPRESS CHATTERING WITH UNEQUAL SPACING OF TEETH AND VARIABLE LEADS
- ✓ INCREASE COST PERFORMANCE



CODE	DC	L (ℓ)	DS	PRICE
AS4030-3D	3.0	50 (9)	6.0	¥2,480
AS4040-3D	4.0	50 (12)	6.0	¥2,480
AS4050-3D	5.0	50 (15)	6.0	¥2,480
AS4060-3D	6.0	50 (18)	6.0	¥2,480
AS4080-3D	8.0	65 (24)	8.0	¥4,000
AS4100-3D	10.0	75 (30)	10.0	¥6,560
AS4120-3D	12.0	80 (36)	12.0	¥8,920

Unit : mm / ¥ JPY

· STANDARD MILLING CONDITIONS ·

SIDE MILLING

Feed Speed: (mm/min) Rotation

WORK MATERIAL	STRUCTURAL STEEL, CARBON STEELS		ALLOY STEELS		PRE-HARDEND STEELS		STAINLESS STEEL	
	ROTATION	FEED	ROTATION	FEED SPEED	ROTATION	FEED SPEED	ROTATION	FEED SPEED
DC								
3	12900	1300	10200	800	9000	980	7300	580
4	9600	1260	7800	920	6800	890	5400	520
5	7600	1260	6100	960	5500	720	4300	420
6	6400	1150	5100	1120	4500	800	3600	480
8	4800	1150	3800	1200	3400	880	2700	520
10	3900	1120	3000	1080	2700	790	2100	470
12	3200	1000	2600	960	2300	690	1800	420
DEPTH OF CUT	ap = 1.0D		ap = 1.0D		ap = 1.0D		ap = 1.0D	
	ae = 0.2D		ae = 0.2D		ae = 0.2D		ae = 0.2D	

GROOVING

WORK MATERIAL	STRUCTURAL STEEL, CARBON STEELS		ALLOY STEELS		PRE-HARDEND STEELS		STAINLESS STEEL	
	ROTATION	FEED	ROTATION	FEED	ROTATION	FEED	ROTATION	FEED
DC								
3	9600	720	7600	5100	5100	330	5900	380
4	7200	660	5700	3900	3900	290	4400	340
5	5800	520	4600	3100	3100	250	3600	280
6	4800	600	3800	2600	2600	270	3000	320
8	3600	650	2800	1900	1900	290	2200	320
10	2900	590	2200	1500	1500	260	1800	280
12	2400	520	1900	1300	1300	240	1500	270
DEPTH OF CUT	ap = 1.0D		ap = 1.0D		ap = 0.5D		ap = 0.5D	