

SOLID END MILLS

END MILLS SELECTION CHART

Group	Type	Feature	Flutes	Code	Shape	Coating	Substrate	Size range	Work material										Page number	
									P	H	M	S	N	Graphite	Dimensions	Cutting conditions				
									Carbon steel, Alloy steel, Cast iron	Tool steel, Pre-Hardened steel, Hardened steel	Hardened steel(—55HRC)	Hardened steel(55HRC—)	Austenitic stainless steel				Titanium alloy, Heat resistant alloy	Copper alloy	Aluminium alloy	
MSTAR / For General material																				
Ball	General	Long neck	Taper neck	2	M525B				R0.1—R6									I073	I076	
					M52MB				R0.25—R6										I075	I076
					M52XLB				R0.1—R3										I077	I082
					M52XB				R0.1—R2										I083	I086
	Square	General	2		M525S				φ0.1—φ12										I036	I039
					M52MS				φ0.2—φ20										I037	I039
					M52JS				φ0.1—φ12										I040	I041
					M52LS				φ0.2—φ12										I042	I043
		General	4		M545C				φ1—φ12										I059	I061
					M54MC				φ1—φ20										I060	I061
					M54JC				φ1—φ12										I062	I063
		Long neck	2		M52XL				φ0.2—φ6										I044	I047
					M52XL6				φ0.3—φ2.5										I048	I050
		High helix		4	M54XL				φ1—φ10										I064	I067
	3			M5MHZD				φ1—φ20										I057	I058	
	High helix		4	M55HD				φ3—φ20										I051	I054	