

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
ALIMASTER / For Aluminium alloy																			
Roughing	General	Radius	3	AM5R		—		φ10 —φ25								○	◎	I300	I301
				AMMR		—		φ3 —φ25							○	◎	I302	I303	
				AM5RRB		—		φ10 —φ25							○	◎	I304	I305	
VIOLET / For General material																			
Square	General	High helix	2	VA25S				φ3 —φ20	◎	○				○	○			I306	I308
				VA2MS				φ3 —φ40	◎	○			○	○			I307	I308	
				VA4MC				φ3 —φ30	◎	○			○	○			I309	I310	
	Roughing	General	4	3	VAMH				φ5 —φ30	◎	○			◎	○			I321	I322
				4	VAFPR				φ5 —φ50	◎	○			◎	○			I311	I312
				5	VAMFPR				φ5 —φ50	◎	○			◎	○			I313	I314
				6	VAMR				φ5 —φ50	◎	○			◎	○			I315	I316
				VAJR				φ10 —φ50	◎	○			◎	○			I317	I318	
				VALR				φ10 —φ50	◎	○			◎	○			I319	I320	

◎ : 1st recommendation / ○ : 2nd recommendation