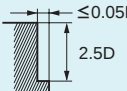
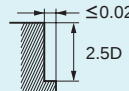


MSTAR END MILLS**MSJHD**

High power, Semi long cut length, 4 flute

CARBIDE

RECOMMENDED CUTTING CONDITIONS**Shoulder milling**

Dia. (mm)	Carbon steel, Cast iron, Alloy steel (—30HRC)		Alloy steel, Tool steel, Pre-hardened steel		Austenitic stainless steel, Titanium alloy		Hardened steel (45—55HRC)		Heat resistant alloys	
	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
2	11000	370	7000	230	7000	210	5000	100	3800	55
3	8000	550	5100	320	5100	300	3800	190	2500	80
4	6200	620	4000	350	4000	340	3000	210	1900	110
5	5000	670	3200	370	3200	360	2400	220	1500	110
6	4200	750	2600	400	2600	390	2000	220	1300	110
8	3200	780	2000	420	2000	400	1500	230	960	100
10	2500	690	1600	410	1600	380	1200	210	760	100
12	2100	670	1300	380	1300	340	1000	190	640	80
16	1600	570	1000	320	1000	280	750	170	480	65
20	1200	470	800	290	800	260	600	150	380	50
Depth of cut	 $\leq 0.05D$ 2.5D				 $\leq 0.02D$ 2.5D					

D: Dia.

- 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
- 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.