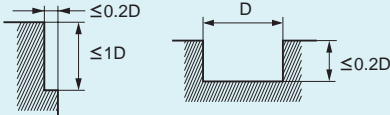
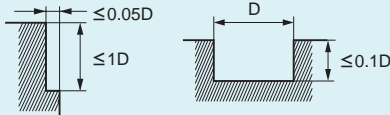


MSTAR END MILLS**MS4EC**

End mill, 4 flute, For small automatic lathe

CARBIDE

RECOMMENDED CUTTING CONDITIONS

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)	
	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)
3	10000	900	7000	600	6000	450	5000	180
4	7500	900	5200	600	4500	450	4000	180
5	6000	900	4200	600	3600	450	3200	180
6	5000	900	3500	600	3000	450	2700	180
7	4500	840	3000	540	2700	420	2300	160
8	4000	780	2800	520	2400	390	2000	160
10	3200	680	2200	450	1900	340	1600	140
12	2700	620	1900	410	1600	310	1300	120
14	2300	550	1600	350	1400	280	1200	120
Depth of cut								

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) When drilling, please set the feed rate at 1/3 or below the values above.
- 4) 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.