

Unit : mm

Order Number	R	B ₇	ap	D ₂	L ₁	D ₄	Flutes	Stock	Type
MS2MTBR0125T0400	1.25	4°	10	3.73	50	6	2	★	1
R0125T0500	1.25	5°	10	4.04	50	6	2	★	1
R0125T0700	1.25	7°	14.5	5.77	60	6	2	★	2
R0150T0700	1.5	7°	12.5	5.72	60	6	2	★	2

SQUARE

BALL

RADIUS

TAPER

SOLID END MILLS

RECOMMENDED CUTTING CONDITIONS

Work material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel Cf53, GG25					Hardened steel (45—55HRC) X40CrMoV51				
	$\alpha \leq 15^\circ$		$\alpha > 15^\circ$		Depth of cut (mm)	$\alpha \leq 15^\circ$		$\alpha > 15^\circ$		Depth of cut (mm)
R (mm)	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)	
R 0.1	40000	300	40000	250	0.003	40000	300	40000	250	0.003
R 0.15	40000	500	40000	350	0.007	40000	500	40000	350	0.007
R 0.2	40000	1600	40000	1200	0.02	40000	1300	40000	950	0.015
R 0.25	40000	2400	40000	1400	0.025	40000	1900	40000	1100	0.020
R 0.3	40000	3200	40000	1600	0.03	40000	2500	40000	1300	0.025
R 0.4	40000	4800	40000	2400	0.05	40000	4000	40000	1900	0.04
R 0.5	40000	5600	40000	3200	0.06	40000	5600	40000	3000	0.05
R 0.75	40000	6500	40000	4000	0.09	40000	6500	32000	3200	0.08
R 1	40000	6500	39000	4700	0.11	40000	6500	31000	3500	0.11
R 1.25	40000	7000	33000	4500	0.12	36000	6500	26000	3500	0.12
R 1.5	40000	7500	27000	4300	0.13	32000	6000	22000	3400	0.13
R 2	32000	7500	20000	3600	0.15	25000	6000	16000	2700	0.15
R 2.5	25000	6000	16000	2900	0.20	20000	5400	13000	2300	0.20
R 3	21000	5800	13000	2600	0.25	17000	4700	10000	2000	0.25
R 4	16000	4500	10000	2000	0.30	13000	3600	8000	1500	0.30
R 5	13000	3600	8000	1700	0.50	10000	2900	6400	1200	0.50
R 6	9000	2500	6000	1300	0.50	7200	2000	4800	1000	0.50
Depth of cut	≤ 0.2R ≤ Please refer to the list above for depth of cut. R: Radius									

- 1) α is the inclination angle of the machined surface.
- 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.

