

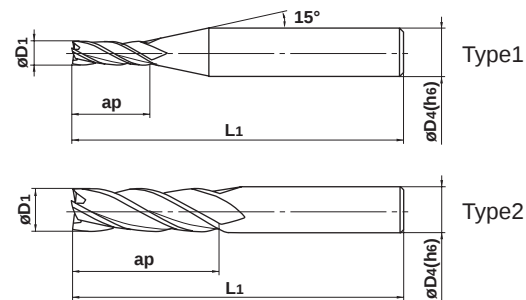
**CRN4JC**

End mill, Semi long cut length, 4 flute, For copper electrodes



CARBIDE

| Carbon Steel, Alloy Steel, Cast Iron<br>(≤30HRC) | Tool Steel, Pre-Hardened Steel, Hardened Steel<br>(≤45HRC) | Hardened Steel<br>(≤55HRC) | Hardened Steel<br>(>55HRC) | Austenitic<br>Stainless Steel | Titanium Alloy,<br>Heat Resistant Alloy | Copper Alloy | Aluminium Alloy |
|--------------------------------------------------|------------------------------------------------------------|----------------------------|----------------------------|-------------------------------|-----------------------------------------|--------------|-----------------|
|                                                  |                                                            |                            |                            |                               |                                         | ○            | ○               |



|  |              |              |              |  |  |
|--|--------------|--------------|--------------|--|--|
|  | 3 ≤ D1 ≤ 12  |              |              |  |  |
|  | 0<br>- 0.02  |              |              |  |  |
|  | D4=6         | 8 ≤ D4 ≤ 10  | D4=12        |  |  |
|  | 0<br>- 0.008 | 0<br>- 0.009 | 0<br>- 0.011 |  |  |

● 4 flute end mill with CRN coating for copper electrode machining.

Unit : mm

| Order Number | D1 | ap | L1 | D4 | Flutes | Stock | Type |
|--------------|----|----|----|----|--------|-------|------|
| CRN4JCD0300  | 3  | 12 | 50 | 6  | 4      | ●     | 1    |
| D0400        | 4  | 15 | 50 | 6  | 4      | ●     | 1    |
| D0500        | 5  | 20 | 60 | 6  | 4      | ●     | 1    |
| D0600        | 6  | 20 | 60 | 6  | 4      | ●     | 2    |
| D0800        | 8  | 25 | 70 | 8  | 4      | ●     | 2    |
| D1000        | 10 | 30 | 90 | 10 | 4      | ●     | 2    |
| D1200        | 12 | 30 | 90 | 12 | 4      | ●     | 2    |

**RECOMMENDED CUTTING CONDITIONS**

| Work material | Copper, Copper alloys              |                       |
|---------------|------------------------------------|-----------------------|
| Dia.<br>(mm)  | Revolution<br>(min <sup>-1</sup> ) | Feed rate<br>(mm/min) |
| 3             | 10600                              | 280                   |
| 4             | 8000                               | 330                   |
| 5             | 6400                               | 380                   |
| 6             | 5300                               | 420                   |
| 8             | 4000                               | 460                   |
| 10            | 3200                               | 460                   |
| 12            | 2700                               | 460                   |
| Depth of cut  |                                    |                       |
|               | D: Dia.                            |                       |

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) Water-soluble cutting fluid is recommended.
- 3) When drilling, please set the feed rate at 1/3 or below of the table value.
- 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.

● : Inventory maintained.

SQUARE

BALL

RADIUS

TAPER

SOLID END MILLS