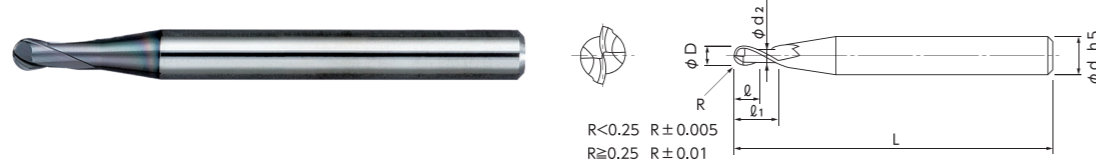


Sharp cutting edge reduces cutting load for tough materials



- It is designed for high speed cutting of hardened steels.
- Perform efficiently under high feed condition and able to take large depth of cut.

Unit : mm

Code No.	Radius (R)	Under Neck Length (ℓ_1)	Length of Cut (ℓ)	Dia. (D)	Neck Dia. (d2)	Shank Dia. (d)	Overall Length (L)	Actual effective length depending on inclined angle of workpiece				
								30°	1°	1°30'	2°	3°
08-00555-01011	R0.1	0.5	0.2	0.2	0.175	4	50	0.57	0.60	0.62	0.64	0.71
08-00555-01012		0.5	0.2	0.2	0.175	6	50	0.57	0.60	0.62	0.64	0.71
08-00555-02011	R0.2	1	0.4	0.4	0.365	4	50	1.12	1.16	1.20	1.25	1.37
08-00555-02012		1	0.4	0.4	0.365	6	50	1.12	1.16	1.20	1.25	1.37
08-00555-02511	R0.25	1.25	0.5	0.5	0.46	4	50	1.39	1.44	1.49	1.56	1.70
08-00555-02512		1.25	0.5	0.5	0.46	6	50	1.39	1.44	1.49	1.56	1.70
08-00555-03011	R0.3	1.5	0.6	0.6	0.56	4	50	1.65	1.71	1.77	1.85	2.02
08-00555-03012		1.5	0.6	0.6	0.56	6	50	1.65	1.71	1.77	1.85	2.02
08-00555-04011	R0.4	2	0.8	0.8	0.76	4	50	2.16	2.24	2.33	2.42	2.65
08-00555-04012		2	0.8	0.8	0.76	6	50	2.16	2.24	2.33	2.42	2.65
08-00555-05011	R0.5	2.5	1	1	0.95	4	50	3.51	3.78	4.02	4.26	4.70
08-00555-05012		2.5	1	1	0.95	6	50	3.51	3.78	4.02	4.26	4.70
08-00555-05021		4	1	1	0.95	6	50	5.14	5.49	5.80	6.08	6.60
08-00555-05022		6	1	1	0.95	6	50	7.29	7.73	8.10	8.44	9.04
08-00555-07511	R0.75	3.8	1.5	1.5	1.45	4	50	4.90	5.23	5.52	5.79	6.29
08-00555-07512		3.8	1.5	1.5	1.45	6	50	4.90	5.23	5.52	5.79	6.29
08-00555-10011	R1	5	2	2	1.94	4	50	6.22	6.59	6.91	7.21	7.74
08-00555-10012		5	2	2	1.94	6	50	6.22	6.59	6.91	7.21	7.74
08-00555-10022		6	2	2	1.94	6	50	7.30	7.71	8.06	8.38	8.96
08-00555-10032		8	2	2	1.94	6	50	9.43	9.91	10.32	10.69	11.33
08-00555-15012	R1.5	8	3	3	2.85	6	60	8.88	9.33	9.85	10.45	11.94
08-00555-15022		10	3	3	2.85	6	60	10.99	11.58	12.25	13.01	14.93
08-00555-15032		15	3	3	2.85	6	60	16.28	17.20	18.24	19.43	22.40
08-00555-20012	R2	10	4	4	3.8	6	60	11.13	11.70	12.34	13.08	14.92
08-00555-25012	R2.5	12	5	5	4.8	6	60	13.22	13.88	14.64	15.50	Free
08-00555-30012	R3	15	6	6	5.7	6	60	Free	Free	Free	Free	Free

How to Order When you order, indicate MACH225 (R) \times (ℓ_1) \times (d). ※(γ) is reference value.

■ Semi-standard products, please inquire for price and delivery.

Work Material	Carbon Steels·Prehardened Steels S50C·HPM·NAK (~43HRC)					Hardened Steels SKD61·STAVAX·HPM38 (~55HRC)					Hardened Steels SKD11 (~62HRC)				
	Normal Speed		High Speed		Depth of Cut	Normal Speed		High Speed		Depth of Cut	Normal Speed		High Speed		Depth of Cut
	Spindle Speed	Feed	Spindle Speed	Feed		Spindle Speed	Feed	Spindle Speed	Feed		Spindle Speed	Feed	Spindle Speed	Feed	
Radius	min ⁻¹	mm/min	min ⁻¹	mm/min	mm	min ⁻¹	mm/min	min ⁻¹	mm/min	mm	min ⁻¹	mm/min	min ⁻¹	mm/min	mm
0.1	20,000	400	50,000	800	0.01×0.02	20,000	250	50,000	500	0.01×0.02	20,000	250	50,000	500	0.01×0.02
0.2	20,000	600	50,000	1,000	0.02×0.05	20,000	320	50,000	680	0.02×0.05	20,000	320	50,000	680	0.02×0.05
0.25	20,000	800	50,000	1,200	0.03×0.05	20,000	400	50,000	800	0.02×0.05	20,000	400	50,000	800	0.02×0.05
0.3	20,000	1,200	50,000	2,000	0.05×0.1	20,000	460	50,000	1,000	0.03×0.05	20,000	460	50,000	1,000	0.03×0.05
0.4	20,000	1,600	50,000	2,500	0.1×0.2	20,000	580	50,000	1,200	0.05×0.1	20,000	580	50,000	1,200	0.05×0.1
0.5	20,000	2,000	50,000	5,000	0.2×0.3	20,000	1,200	50,000	3,000	0.1×0.2	20,000	800	50,000	2,000	0.1×0.2
0.75	20,000	2,000	50,000	5,000	0.2×0.3	20,000	1,600	42,000	3,000	0.1×0.2	20,000	1,200	32,000	2,000	0.1×0.2
1	20,000	3,200	50,000	8,000	0.3×0.5	20,000	2,500	32,000	3,500	0.2×0.5	20,000	2,000	24,000	2,400	0.2×0.5
1.5	16,000	2,800	32,000	6,000	0.3×0.5	16,000	2,500	21,000	3,500	0.2×0.5	13,000	2,000	16,000	2,400	0.2×0.5
2	12,000	2,400	24,000	5,000	0.5×1	12,000	2,000	16,000	3,000	0.2×0.7	9,600	1,600	12,000	2,000	0.2×0.7
2.5	9,600	2,000	20,000	5,000	0.5×1	9,600	2,000	13,000	3,000	0.2×0.7	7,600	1,300	9,600	1,600	0.2×0.7
3	8,000	2,000	16,000	4,000	0.5×1.5	8,000	1,600	10,000	2,500	0.2×1	6,400	1,000	8,000	1,300	0.2×1
Notes	※1 Depth of Cut : ap = Axial Depth of Cut / ae = Radial Depth of Cut. ※2 We recommend using oil mist coolant. ※3 Adjust milling conditions according to the volume of depth of cut and rigidity of machine. ※4 Adjust both spindle speed and feed at the same rate. ※5 Length of tool overhang must be as short as possible.														

○ Stainless Steel M

○ Titanium Alloy Heat Resistant Alloy S

○ Prehardened Steel P

○ ~55 HRC Hardened Steel H

○ ~65 HRC Hardened Steel H

○ Stainless Steel M

○ Titanium Alloy Heat Resistant Alloy S

Long Neck Ball Coating

Long Neck Ball Coating