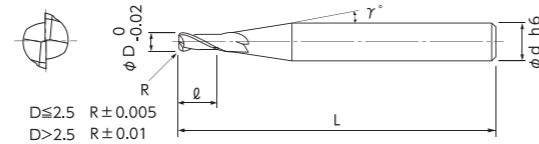
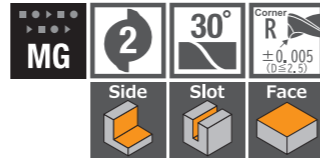


## MUGEN COATING 2-Flute Radius End Mill

Total 38 sizes

## Recommended Milling Conditions

2-flute standard type corner radius end mill with helix angle 30°  
For multi-purpose from roughing to finishing



- New  $\phi 6$  size of 2-Flute MUGEN COATING corner radius end mill.
- Total 38 sizes for suitable selection.

Code No.	Dia. (D)	Corner Radius (R)	Length of Cut (L)	Neck Taper Angle ( $\gamma$ )	Shank Dia. (d)	Overall Length (L)
08-00700-01001	1	R0.1	2	9°	4	60
08-00700-01002		R0.2				
08-00700-01003		R0.3				
08-00700-01501	1.5	R0.1	3	9°	4	60
08-00700-01502		R0.2				
08-00700-01503		R0.3				
08-00700-01505	R0.5					
08-00700-02001	2	R0.1	4	9°	4	60
08-00700-02002		R0.2				
08-00700-02003		R0.3				
08-00700-02005	R0.5					
08-00700-02501	2.5	R0.1	5	9°	4	60
08-00700-02502		R0.2				
08-00700-02503		R0.3				
08-00700-02505	R0.5					
08-00700-03001	3	R0.1	6	9°	6	60
08-00700-03002		R0.2				
08-00700-03003		R0.3				
08-00700-03005	R0.5					
08-00700-03010	R1					
08-00700-04001	4	R0.1	8	9°	6	65
08-00700-04002		R0.2				
08-00700-04003		R0.3				
08-00700-04005	R0.5					
08-00700-04010	R1					

Unit : mm

Code No.	Dia. (D)	Corner Radius (R)	Length of Cut (L)	Neck Taper Angle ( $\gamma$ )	Shank Dia. (d)	Overall Length (L)
08-00700-05001	5	R0.1	10	9°	6	70
08-00700-05002		R0.2				
08-00700-05003		R0.3				
08-00700-05005		R0.5				
08-00700-05010		R1				
08-00700-05015	R1.5					
08-00700-06001	6	R0.1	12	-	6	80
08-00700-06002		R0.2				
08-00700-06003		R0.3				
08-00700-06005		R0.5				
08-00700-06010		R1				
08-00700-06015		R1.5				
08-00700-06020		R2				

Work Material	Carbon Steels S50C		Alloy Steels SCM·SKD·SUS		Prehardened Steels HPM·NAK		Hardened Steels SKD61 (~52HRC)					
	Cutting Speed		60~80m/min		50~70m/min		30~50m/min		20~30m/min			
	Dia.	Spindle Speed	Feed		Spindle Speed	Feed		Spindle Speed	Feed			
min <sup>-1</sup>		mm/min		min <sup>-1</sup>	mm/min		min <sup>-1</sup>	mm/min				
		Side Milling	Slotting		Side Milling	Slotting		Side Milling	Slotting			
1	25,500	200	100	19,200	130	50	12,800	80	40	6,400	60	30
1.5	17,100	340	120	12,800	180	60	8,500	90	45	4,200	70	35
2	12,800	400	150	9,600	210	70	6,400	110	55	3,200	80	40
2.5	10,200	400	150	7,700	210	70	5,100	110	55	2,500	80	40
3	8,500	450	160	6,400	250	80	4,300	120	60	2,100	100	50
4	6,400	450	160	4,800	250	80	3,200	120	60	1,600	100	50
5	5,100	600	200	3,800	300	90	2,600	150	75	1,300	120	60
6	4,300	600	220	3,200	300	100	2,200	150	90	1,100	130	70
Depth of Cut (D: Dia.)	Side Milling: $1.5D$ Slotting: $0.3D$ 以下				Side Milling: $1D$ Slotting: $0.02D$				Side Milling: $1D$ Slotting: $0.02D$			
Notes	※1 Adjust feed according to inclined angle. ※2 When corner machining, reduce the feed by approximately 50%~30%. ※3 Adjust spindle speed and feed at the same rate also reduce Depth of Cut, if the machine spindle speed insufficient.											

**How to Order** When you order, indicate MSRS230 (D)x(R). ※( $\gamma$ ) is reference value.

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

Stainless Steel M

Aluminium Alloy N

Copper N

Resin O

Stainless Steel M

Aluminium Alloy N

Copper N

Resin O

Corner Radius Coating

Corner Radius Coating