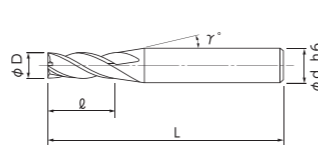
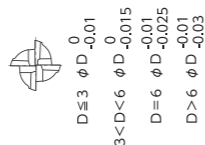


MUGEN COATING 4-Flute LEAD35 End Mill

Total 14 sizes

Recommended Milling Conditions

For various work materials. L/D=3.
Suitable for side milling with 4-flute



● L/D=3 and helix 35° for appropriate length of cut to avoid the inconveniences in size selection.

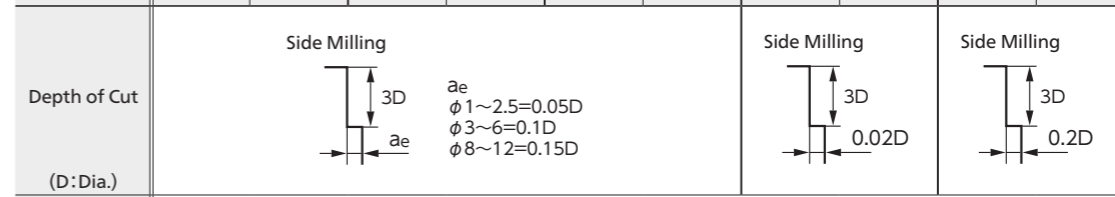
Unit : mm

Code No.	Dia. (D)	Length of Cut (ℓ)	Neck Taper Angle (γ)	Shank Dia. (d)	Overall Length (L)
08-00085-00100	1	3	12°	4	45
08-00085-00150	1.5	4.5	12°	4	45
08-00085-00200	2	6	12°	4	45
08-00085-00250	2.5	7.5	12°	4	45
08-00085-00300	3	9	12°	6	45
08-00085-00350	3.5	10.5	12°	6	45
08-00085-00400	4	12	12°	6	50
08-00085-00450	4.5	13.5	12°	6	50
08-00085-00500	5	15	12°	6	55
08-00085-00550	5.5	16.5	12°	6	60
08-00085-00600	6	18	-	6	60
08-00085-00800	8	24	-	8	65
08-00085-01000	10	30	-	10	75
08-00085-01200	12	36	-	12	80

How to Order

When you order, indicate MX435 (D). ※(γ) is reference value.

Work Material	Carbon Steels S50C		Alloy Steels SCM·SKD·SUS		Prehardened Steels HPM·NAK		Hardened Steels SKD61 (~52HRC)		Copper	
Cutting Speed	45~75m/min		45~65m/min		35~55m/min		15~35m/min		55~75m/min	
Dia.	Side Milling		Side Milling		Side Milling		Side Milling		Side Milling	
	Spindle Speed min ⁻¹	Feed mm/min	Spindle Speed min ⁻¹	Feed mm/min	Spindle Speed min ⁻¹	Feed mm/min	Spindle Speed min ⁻¹	Feed mm/min	Spindle Speed min ⁻¹	Feed mm/min
1	19,100	290	17,500	210	14,300	170	8,000	100	20,700	380
1.5	12,700	290	11,700	210	9,500	170	5,300	100	13,800	420
2	9,500	290	8,800	240	7,200	210	4,000	100	10,300	470
2.5	7,600	350	7,000	260	5,700	210	3,200	110	8,300	500
3	6,400	390	5,800	260	4,800	230	2,700	110	6,900	530
3.5	5,500	410	5,000	270	4,100	230	2,300	120	5,900	530
4	4,800	480	4,400	310	3,600	260	2,000	140	5,200	610
4.5	4,200	490	3,900	340	3,200	290	1,800	140	4,600	610
5	3,800	510	3,500	360	2,900	320	1,600	140	4,100	630
5.5	3,500	530	3,200	370	2,600	340	1,400	140	3,800	630
6	3,200	540	2,900	390	2,400	360	1,300	140	3,400	630
8	2,400	480	2,200	370	1,800	340	1,000	140	2,600	580
10	1,900	440	1,800	360	1,400	310	800	140	2,100	540
12	1,600	440	1,500	360	1,200	290	700	140	1,700	490



Notes

- ※1 Use cutting fluid with smoke retardant.
- ※2 Recommend to use oil mist coolant for machining hardened steels.
- ※3 Adjust both spindle speed and feed at the same rate.
- ※4 Adjust milling conditions according to the volume of Depth of Cut and rigidity of the machine.

Stainless Steel M

Aluminium Alloy N

Copper N

Resin O

Square Coating

Carbon Steel P

Alloy Steel P

Prehardened Steel P

Hardened Steel H

Stainless Steel M

Aluminium Alloy N

Copper N

Resin O

Square Coating