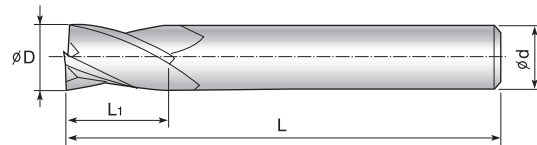


# SKE 4000

## 4날 스퀘어 엔드밀

### SQUARE END MILLS (4 FLUTES)

- ◆ TiSiN코팅 적용으로 내마모성이 우수하고, 날부칩핑을 최소화함.
- ◆ HRC55 이상 고경도 피삭재 및 프리하든강 등 다양한 피삭재 적용 가능
- ◆ 고정밀 공차적용으로 초정밀가공 및 안정적인 치수관리가 가능
- ◆ 4Flute은 작업효율을 높여준다.
- ◆ Excellent wear-resistance due to TiSiN coating, and minimized cutting edge chipping
- ◆ Suitable for various workpieces such as hardened and prehardened steels over HRC55
- ◆ Designed for stable dimensional control and hyper precision machining with application of high precision tolerance
- ◆ 4 Flutes improve work efficiency



모델번호	직 경	날 장	전 장	생크 경
Model No.	Diameter of Mill	Length of cut	Overall Length	Shank Diameter
	∅D	L <sub>1</sub>	L	∅d(h6)
SKE 4010	1.0	3	45	4
SKE 4010-S6	1.0	3	45	6
SKE 4015	1.5	4	45	4
SKE 4015-S6	1.5	4	45	6
SKE 4020	2.0	6	45	6
SKE 4025	2.5	8	50	6
SKE 4030	3.0	10	50	6
SKE 4035	3.5	10	50	6
SKE 4040-S4	4.0	10	55	4
SKE 4040	4.0	12	55	6
SKE 4045	4.5	15	55	6
SKE 4050	5.0	15	55	6
SKE 4060	6.0	15	55	6
SKE 4080	8.0	20	65	8
SKE 4100	10.0	25	70	10
SKE 4120	12.0	30	80	12
SKE 4140	14.0	45	100	16
SKE 4160	16.0	45	100	16

SK-007

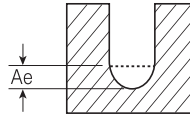
SQUARE SERIES



# SKRE Series

## 2날 롱넥 스퀘어

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS			HARDENED STEELS						COPPER		
	HRc 30 ~HRc 45			HRc 45 ~HRc 55			HRc 55 ~HRc 65					
	HARDNESS	RPM	FEED	Ae(mm)	RPM	FEED	Ae(mm)	RPM	FEED	Ae(mm)	RPM	FEED
0.2	50000	300-350	0.006-0.016	50000	265-310	0.005-0.013	50000	225-265	0.005-0.012	50000	455-530	0.010-0.022
0.3	43000-50000	330-420	0.006-0.015	39900-46200	265-310	0.004-0.011	23900-32300	105-185	0.003-0.007	48000-50000	550-640	0.010-0.025
0.4	31400-50000	350-590	0.005-0.028	30500-35200	295-340	0.003-0.020	18300-24600	120-200	0.002-0.012	48000-50000	790-920	0.008-0.048
0.5	25650-33000	370-470	0.006-0.035	23750-26000	285-315	0.004-0.025	14200-18000	115-130	0.003-0.015	44000-50000	800-1150	0.010-0.060
0.6	20900-35200	330-560	0.007-0.030	19900-22000	260-290	0.005-0.021	11900-15500	100-120	0.003-0.013	37500-50000	770-1250	0.011-0.051
0.8	16150-26400	360-590	0.009-0.040	15200-16700	280-310	0.006-0.028	9000-11700	110-125	0.004-0.017	28500-47000	770-1300	0.015-0.060
1.0	12300-18700	350-540	0.011-0.028	10500-11500	250-280	0.008-0.020	6300-8060	100-115	0.005-0.012	22500-34000	810-1300	0.018-0.048
1.2	10450-17600	350-590	0.025-0.070	9100-10000	250-280	0.015-0.042	5400-7000	100-115	0.009-0.026	22500-31500	950-1350	0.038-0.101
1.5	9100-17600	430-830	0.017-0.077	7000-8000	250-280	0.012-0.055	4300-5500	100-115	0.007-0.033	14500-25000	770-1320	0.028-0.132
2.0	6350-10550	340-570	0.021-0.140	6100-6700	270-300	0.015-0.100	3600-4700	100-120	0.009-0.060	11500-18500	770-1250	0.036-0.240
3.0	4300-7050	550-900	0.056-0.210	3990-4600	445-515	0.040-0.150	2400-3200	105-310	0.024-0.090	9000-13000	1400-2110	0.096-0.360
4.0	3200-5300	400-675	0.074-0.280	3000-3400	335-380	0.053-0.200	1800-2400	75-230	0.032-0.120	6750-9750	1050-1575	0.128-0.480



RPM = rev/min  
Feed = mm/min

SK-007

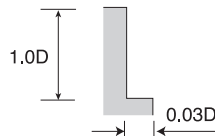
Technical Data



# 4SKRE, SKE 4000 Series

## 4날 롱넥스퀘어, 4날 스퀘어-Side Cutting

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS		HARDENED STEELS							
	HRc 30 ~HRc 40		HRc 40 ~HRc 50		HRc 50 ~HRc 55		HRc 55 ~HRc 60		HRc 60 ~HRc 65	
	HARDNESS	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM
1.0	48000	1480	38000	1050	25500	710	20500	430	16000	270
2.0	33300	1750	26000	1250	17500	840	14500	520	11000	320
3.0	21800	1750	17300	1250	11500	840	9500	520	7500	320
4.0	16700	1800	13200	1300	8800	880	7200	540	5600	335
5.0	15700	2000	12500	1500	8300	1000	6400	580	5100	370
6.0	13100	1950	10350	1400	6900	950	5300	560	4200	350
8.0	9880	1880	7800	1350	5200	900	4000	520	3200	330
10.0	7800	1750	6150	1260	4100	840	3200	480	2550	310
12.0	6650	1750	5250	1260	3500	840	2650	480	2100	300



RPM = rev/min  
Feed = mm/min



CAUTION

- 불꽃 발생으로 인한 화재의 위험이나 공구 파손에 의한 열발생이 가공중 발생될 수 있습니다.
- 사용전에 반드시 화재예방 대책이 마련되어 있는지 확인하시기 바랍니다.
- Danger of fire by spark incidence or heat caused by tool breakage can happen during processing.
- Confirm fire prevention countermeasure beforehand necessarily before use.