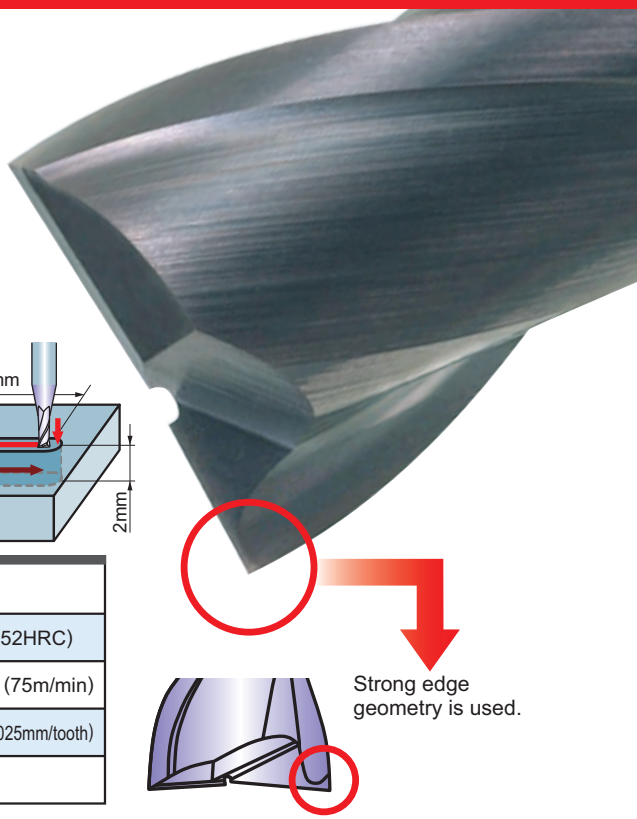
2 Flute MSTAR Strong Geometry Type End Mill (M)

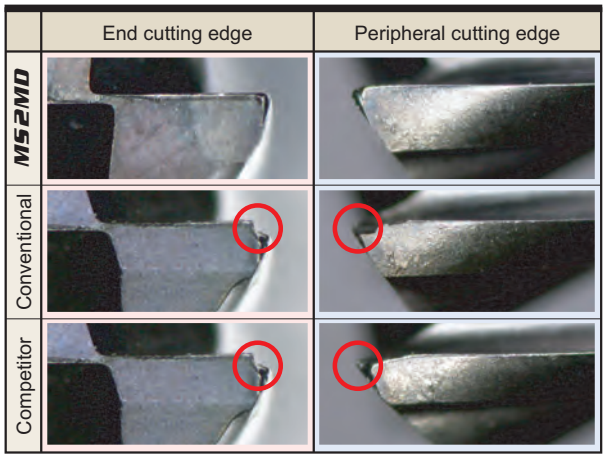
MS2MD

MSTAR
2 flute square strong geometry type now available!

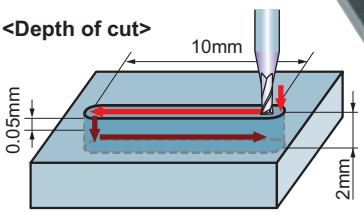


Machining of JIS SKD61 (52HRC)

After machining 40 grooves



<Depth of cut>



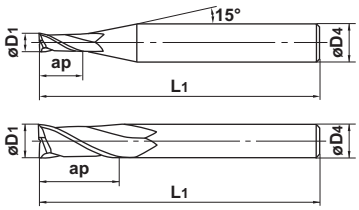
End mill	MS2MD ϕ2
Work material	JIS SKD61 (52HRC)
Revolution	12,000min^{-1} (75m/min)
Feed rate	600mm/min (0.025mm/tooth)
Cutting method	Air blow

Strong edge geometry is used.

MS2MD
End mill, Medium cut length, 2 flute, Strong geometry type

0 – -0.020

UWC MS 30° D1<3 3≤D1



● Strong edge type, 2 flute end mill with high resistance to corner fracturing.

Unit : mm

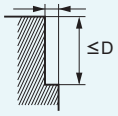
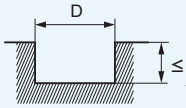
Order Number	Dia. D1	Length of Cut ap	Overall Length L1	Shank Dia. D4	No. of Flutes N	Stock	Type
MS2MDD0100	1	2.5	40	4	2	●	1
D0150	1.5	3.8	40	4	2	●	1
D0200	2	5	40	4	2	●	1
D0250	2.5	6.3	40	4	2	●	1
D0300	3	7.5	50	6	2	●	1
D0400	4	10	50	6	2	●	1
D0500	5	12.5	50	6	2	●	1
D0600	6	15	50	6	2	●	2
D0800	8	20	60	8	2	●	2
D1000	10	25	70	10	2	●	2
D1200	12	30	90	12	2	●	2

● : Inventory maintained.

MSTAR END MILLS

MS2MD

End mill, Medium cut length, 2 flute, Strong geometry type

Work material	Carbon steel, Alloy steel, Tool steel Pre-hardened steel (—45HRC) JIS S50C, JIS SCM, JIS SKD			Alloy steel, Tool steel (45—55HRC) JIS SKD61, STAVAX		
Dia. (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
1	40,000	2,000	0.06	32,000	1,600	0.06
1.5	40,000	3,000	0.12	32,000	1,900	0.08
2	30,000	3,000	0.18	24,000	1,900	0.10
2.5	24,000	2,600	0.25	19,000	1,600	0.13
3	20,000	2,300	0.30	16,000	1,400	0.15
4	15,000	2,000	0.40	12,000	1,200	0.20
5	12,000	1,600	0.50	9,000	900	0.25
6	10,000	1,400	0.60	7,000	700	0.30
8	8,000	1,000	0.80	5,600	550	0.40
10	6,400	900	1.00	4,500	500	0.50
12	5,400	820	1.00	3,800	450	0.50
Depth of cut	≤Please refer to the list above for depth of cut.   ≤Please refer to the list above for depth of cut. D:Dia.					

1) If the rigidity of the machine or the workpiece installation is very low, or chattering is generated, please reduce the revolution and the feed rate proportionately.
2) When slotting with end mills with ϕ3 or larger, reduce the revolution to 50—70% and the feed rate to 40—60%.
3) When drilling, reduce the feed rate by 70%.

For Your Safety
●Don't handle inserts and chips without gloves. ●Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

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(Tools specifications subject to change without notice.)

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