

2 Flute MSTAR Strong Geometry Type End Mill (M)







MS2MD

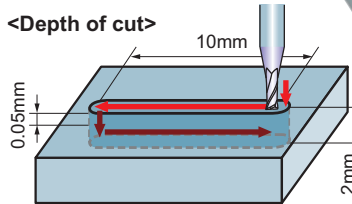
MSTAR

2 flute square strong geometry type now available!

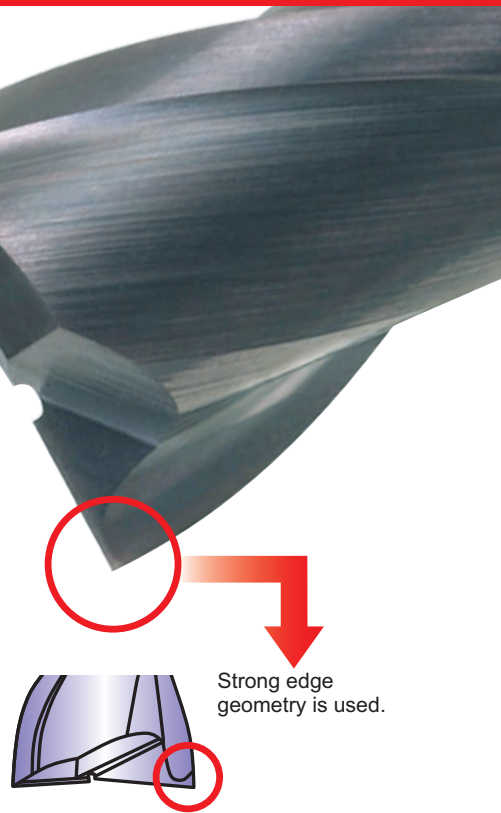
■ Machining of JIS SKD61 (52HRC)

■ After machining 40 grooves

	End cutting edge	Peripheral cutting edge
MS2MD		
Conventional		
Competitor		



End mill	MS2MD $\phi 2$
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.

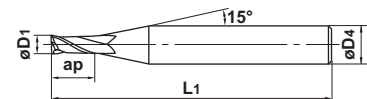
MS2MD

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

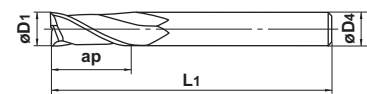


$D_1 < 3$

$3 \leq D_1$



Type 1



Type 2

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

Unit : mm

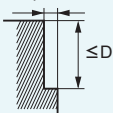
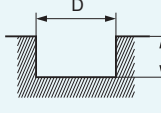
Order Number	Dia.	Length of Cut	Overall Length	Shank Dia.	No. of Flutes N	Stock	Type
	D1	ap	L1	D4			
MS2MDD0100	1	2.5	40	4	2	●	1
D0150	1.5	3.8	40	4	2	●	1
D0200	2	5	40	4	2	●	1
D0250	2.5	6.3	40	4	2	●	1
D0300	3	7.5	50	6	2	●	1
D0400	4	10	50	6	2	●	1
D0500	5	12.5	50	6	2	●	1
D0600	6	15	50	6	2	●	2
D0800	8	20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

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	<p>≤ Please refer to the list above for depth of cut.</p> 		<p>≤ Please refer to the list above for depth of cut.</p> 		D: Dia.
	<p>≤ Please refer to the list above for depth of cut.</p>				

- 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 $\phi 3$ 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.)