

S500⁺ Series

Parts Processing & General Processing

Cutting edge protection

 with protection

 without protection

 Corner Edge 45°

Flute

 2 Flutes

 3 Flutes

 4 Flutes

 6 Flutes

 4 Flutes

Coating

 TA

 TN

Coating can be applied variously according to client's requirement.

Din

 DIN 6535 HA

 DIN 6535 HB

 DIN 6535 HE

Helix angle 1° / 15° / 25° / 30° / 35° / 40° / 42° / 45°

SMG Fine Grades

⚠ Please kindly visit our CityTools website to check available stock.

Customization available

Customized acceptable !
From **Coating, flute, Helix angle, cutting length, to total length.**

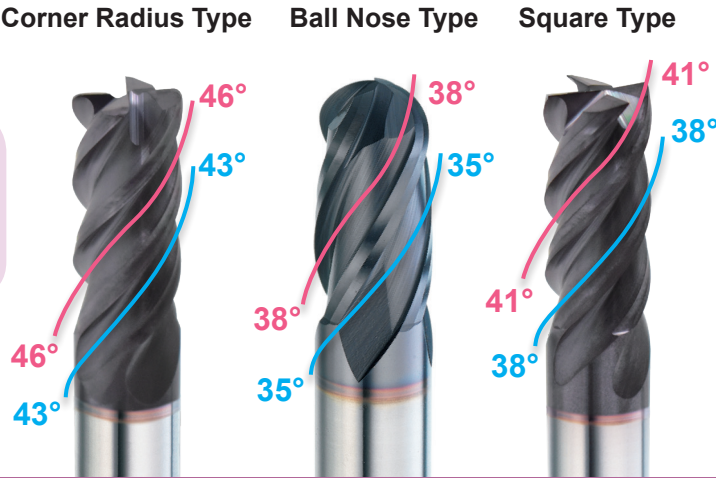
Flute Design

Variable helix angle
Uneven flute

Ideal for Mild steels,
Cast Irons, Hardened steels
with extended tool life.

Anti-Vibration
less noise

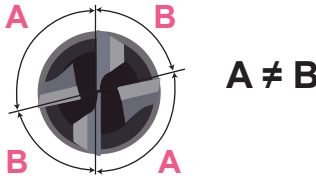
Unique coating
for wear reduction
and heat resistance.



End Mills - Variable helix angle

End Mills- Uneven flute

Anti-Vibration, Providing
smooth and steady chip
evaluation.

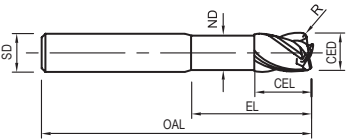


Adjustable helix angle.

Short Flute Provide

Multiple flute design provide

Heavy Duty Cutter design



Ideal for cutting different
hard metals.



Ideal for high hardness metals and
finishing applications.



Ideal for heavy duty
cutting operation.



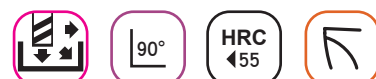
S500M⁺-11352TN

◆ Square Type - 2F Miniature End Mills 35°-2D

*Parts Processing
& General Processing*



Dia.(mm)		Tolerance (mm)
Above	Up to	
0.2	0.5	0~-0.005
0.5	0.9	0~-0.010



※ 3 types of coating to choose from

P	M	K	N	S	H
●	●	●	●	●	●

h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500M ⁺ -11352TN	CED	CEL	SD	OAL
	0.2	0.4	4	50
	0.3	0.6		
	0.4	0.8		
	0.5	1		
	0.6	1.2		
	0.7	1.4		
	0.8	1.6		
	0.9	1.8		

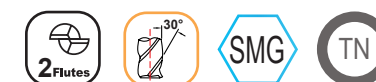
WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL				CAST IRON		REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		--			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
0.2MM	37200	125	37200	115	37200	100	37200	60	0.01	0.04
0.3MM	37200	190	37200	170	37200	150	37200	90	0.01	0.04
0.4MM	37200	250	37200	230	37200	200	37200	120	0.02	0.04
0.5MM	37200	320	37200	290	37200	250	37200	130	0.03	0.10
0.6MM	37200	380	37200	345	37200	310	37200	130	0.04	0.10
0.7MM	37200	512	37200	460	37200	370	37200	130	0.05	0.10
0.8MM	37200	690	37200	610	37200	440	37200	130	0.06	0.10
0.9MM	37200	715	37200	645	37200	510	37200	135	0.06	0.20

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.

S500M⁺-81302TN

◆ Ball Nose Type - 2F Miniature 30°

*Parts Processing
& General Processing*



Radius(mm)	Tolerance (mm)
R	±0.005



※ 3 types of coating to choose from

P	M	K	N	S	H
●	●	●	●	●	●

h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500M ⁺ -81302TN	Radius	CEL	SD	OAL
	0.3R	0.6	4	50
	0.4R	0.8		
	0.5R	1		
	0.6R	1.2		
	0.7R	1.4		
	0.8R	1.6		
	0.9R	1.8		

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
0.15R	42000	672	42000	672	42000	672	42000	504	0.02	0.06
0.2R	42000	1512	42000	1344	42000	1344	42000	1008	0.02	0.08
0.25R	42000	2352	42000	2184	42000	2184	42000	1274	0.03	0.1
0.3R	42000	3024	42000	2688	42000	2114	42000	1288	0.04	0.12
0.35R	42000	3528	42000	3192	42000	2051	42000	1215	0.04	0.14
0.4R	42000	4536	42000	4032	42000	2114	42000	1253	0.05	0.16
0.45R	42000	5299	42000	4186	42000	2170	42000	1225	0.06	0.2

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



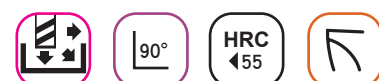
RP500⁺-14352TN

◆ Square Type - 2F End Mills 35°-Long Neck

Parts Processing & General Processing



Dia.(mm)		Tolerance (mm)
Above	Up to	
0.5	1	0~-0.015
1	3	0~-0.020
3	6	0~-0.025



※ 3 types of coating to choose from



h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

RP500+ -14352TN	CED	CEL	EL	SD	OAL
	0.5	0.7	4	4	50
			6		
			8		
	1	1.5	6	4	50
			8		
			10		
	1.5	2.3	6	4	50
			8		
			10		
	2	3	6	4	50
			8		
			10		

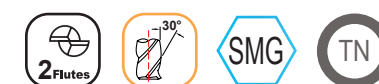
WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL				CAST IRON		REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		--			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
0.5MM	22000	400	22000	350	22000	220	20000	180	0.4	0.1
1MM	20000	700	19000	600	18000	500	15000	300	0.06	0.2
1.5MM	20000	700	19000	600	18000	500	15000	300	0.06	0.2
2MM	19000	900	16000	800	15000	700	12000	400	0.08	0.3

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.

RP500⁺-84302TN

◆ Ball Nose Type - 2F End Mills 30°- Long-Neck

Parts Processing & General Processing



Radius(mm)	Tolerance (mm)
R	±0.01



※ 3 types of coating to choose from



h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

RP500+ -84302TN	Radius	CEL	EL	SD	OAL
	0.25R	0.35	4	4	50
			6		
			8		
	0.5R	0.75	6	4	50
			8		
			10		
	0.75R	1.1	6	4	50
			8		
			10		
	1R	1.5	6	4	50
			8		
			10		

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL				CAST IRON		REFERENCE	
HARDNESS	25~35 HRC		25~35 HRC		35~50 HRC		--		--	
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
0.25R	9100	74	9100	70	6650	42	5565	21	0.04	0.16
0.5R	6230	88	6230	81	4445	49	3710	21	0.06	0.24
0.75R	4655	95	4655	81	3325	56	2765	28	0.08	0.32
1R	3570	97	3535	84	2520	60	2100	28	0.10	0.40

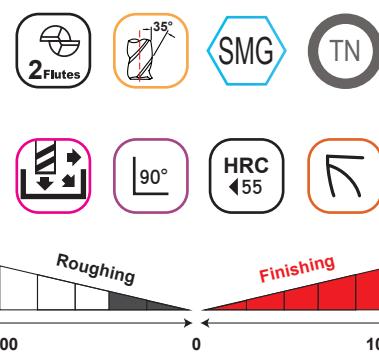
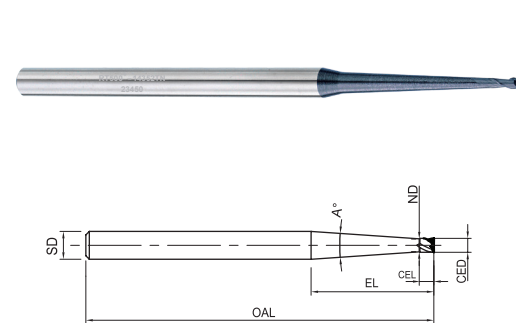
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



RT500⁺-14352TN

◆ Square Type - 2F End Mills 35°-Taper Neck

*Parts Processing
& General Processing*



Dia.(mm)		Tolerance (mm)
Above	Up to	
1	3	0~-0.020
3	8	0~-0.025

※ 3 types of coating to choose from



h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

RT500 ⁺ -14352TN	CED	CEL	EL	SD	OAL	Angle Taper
	0.5	0.7	8	4	50	1.5°
	1	1.5	10	4	50	1.5°
	1.5	2.3	12	4	50	1°
	2	3	14	4	50	1°

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL				CAST IRON		REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		--			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
0.5MM	20000	700	19000	600	18000	500	15000	300	0.06	0.2
1MM	20000	700	19000	600	18000	500	15000	300	0.06	0.2
1.5MM	19000	900	16000	800	15000	700	12000	400	0.08	0.3
2MM	14000	900	13000	800	12000	700	9000	500	0.11	0.4

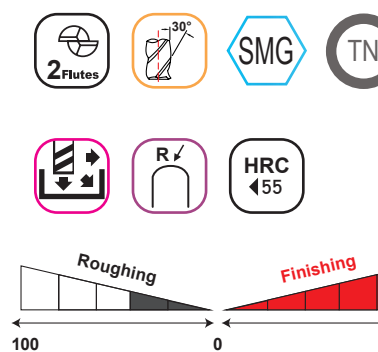
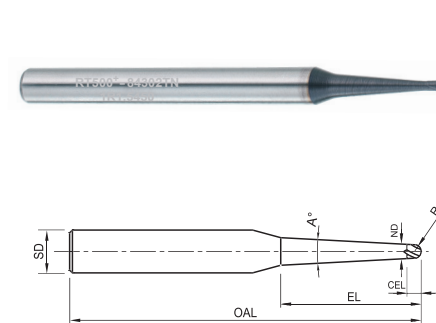
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



RT500⁺-84302TN

◆ Ball Nose Type - 2F End Mills 30°-Taper Neck

*Parts Processing
& General Processing*



Radius(mm)	Tolerance (mm)
R	±0.01

※ 3 types of coating to choose from



h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

RT500 ⁺ -84302TN	Radius	CEL	EL	SD	OAL	Angle Taper
	0.25R	0.35	8	4	50	1°
	0.5R	0.75	10	4	50	2°
	0.75R	1.1	12	4	50	0.5°
	1R	1.5	14	4	50	1°
						1°

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL				CAST IRON		REFERENCE	
HARDNESS	25~35 HRC		25~35 HRC		35~50 HRC		--		--	
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
0.25R	4500	90	4400	75	3000	50	2500	25	0.04	0.15
0.5R	4655	95	4655	81	3325	56	2765	28	0.08	0.32
0.75R	3185	102	3185	91	2205	63	1855	28	0.12	0.48
1R	2310	130	2310	95	1645	63	1365	28	0.14	0.52

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.

A700⁺Series

X600⁺Series

X550⁺Series

S500⁺Series

Specialized⁺Series

HSS⁺Series



S500⁺-14354TN

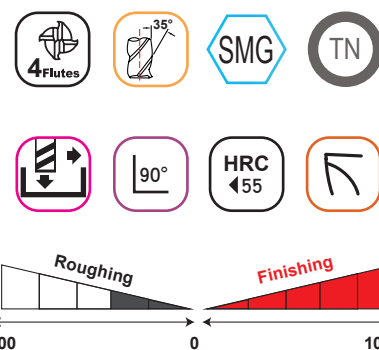
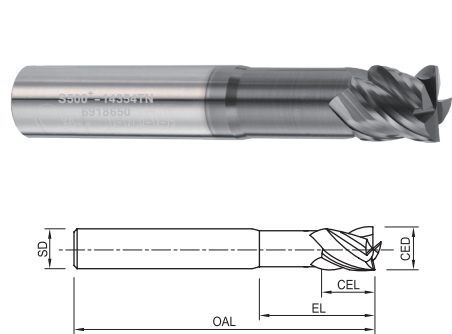
◆ Square Type - 4F Stub Length 35°-1.5D

Parts Processing
& General Processing

S500⁺-11352TN

◆ Square Type - 2F End Mills 35°

Parts Processing
& General Processing



Dia.(mm)		Tolerance (mm)
Above	Up to	
1	3	0~-0.020
3	12	0~-0.025
12	20	0~-0.030

※ 3 types of coating to choose from



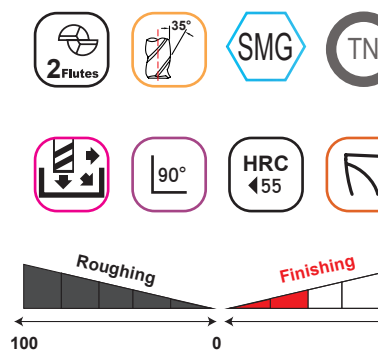
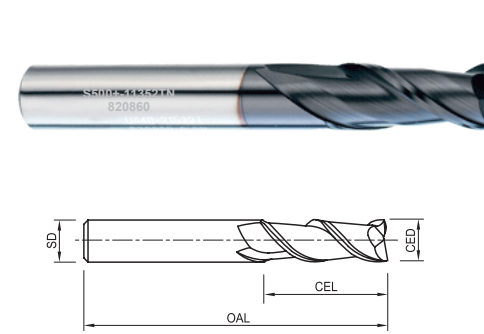
h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500 ⁺ -14354TN	CED	CEL	EL	SD	OAL
	0.5	0.7	1.5	4	50
	1	1.5	3	4	50
	2	3	6		50
	3	4.5	9		50
	4	6	12		50
	6	9	18	6	50

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~50HRC		60~65HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
0.5MM	35700	850	32194	765	28688	850	26031	595	1	0.1
1MM	35700	850	32194	765	28688	850	26031	595	1	0.1
2MM	28688	1700	25819	1530	23163	1329	20188	712	2	0.2
3MM	22950	1913	20613	1530	18551	1329	16681	712	4.5	0.3
4MM	18381	1913	10572	1530	8447	1329	7544	712	6	0.4
6MM	14769	2816	7066	2295	5631	2019	4250	1063	9	0.6

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



Dia.(mm)		Tolerance (mm)
Above	Up to	
1	3	0~-0.020
3	12	0~-0.025
12	20	0~-0.030

※ 3 types of coating to choose from



h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500 ⁺ -11352TN	CED	CEL	SD	OAL
	1	3	4	50
	2	6		
	3	8		
	4	12		
	6	16	6	60
	8	20	8	
	10	30	10	
	12	32	12	
				75

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL				CAST IRON		REFERENCE	
HARDNESS	25~35 HRC		25~35 HRC		35~50 HRC		--		--	
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
1MM	15050	150	8400	90	6740	70	16800	280	1	0.8
2MM	11320	160	6350	90	5065	70	12650	280	2	1.1
3MM	8540	170	4770	96	3820	75	9550	285	3	1.4
4MM	6400	190	3580	108	2865	87	7160	285	4	1.8
6MM	4270	215	2390	96	1900	75	4770	240	6	2.7
8MM	3200	190	1790	108	1430	87	3590	250	8	3.6
10MM	2560	205	1430	100	1150	81	2870	260	10	4.5
12MM	2135	215	1190	108	955	87	2390	265	12	5.4

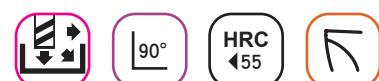
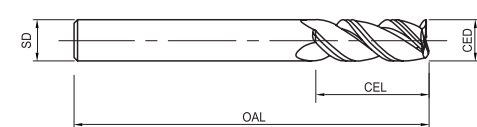
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S500⁺-11353TN

◆ Square Type - 3F End Mills 35°

Parts Processing & General Processing

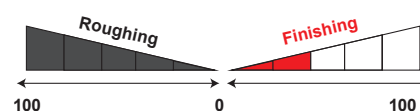


Dia.(mm)		Tolerance (mm)
Above	Up to	
1	3	0~-0.020
3	12	0~-0.025
12	20	0~-0.030

※ 3 types of coating to choose from



h6 (unit : mm)



★ Customized size, Coating, Inches size service available.

S500+ -11353TN	CED	CEL	SD	OAL
	1	3	4	50
	2	6		
	3	8		
	4	12		
	6	16	6	60
	8	20	8	
	10	30	10	75
	12	32	12	

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
1MM	14980	280	9375	170	7023	130	8425	150	1	0.8
2MM	11250	310	7040	185	5280	145	6335	165	2	1.1
3MM	8488	340	5305	213	3980	160	4775	190	4.5	1.4
4MM	6368	383	3980	240	2985	180	3580	215	6	1.8
6MM	4245	340	2653	213	1990	160	2388	190	9	1.8
8MM	3183	318	1990	200	1493	150	1790	180	12	3.6
10MM	2548	358	1593	223	1193	168	1433	190	15	4.5
12MM	2123	340	1328	213	995	160	1193	190	18	5.4

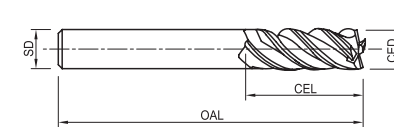
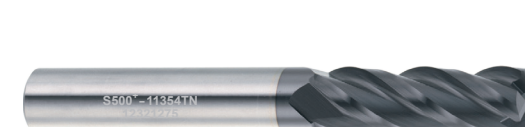
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500⁺-11354TN

◆ Square Type - 4F End Mills 35°

Parts Processing & General Processing

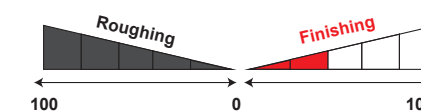


Dia.(mm)		Tolerance (mm)
Above	Up to	
1	3	0~-0.020
3	12	0~-0.025
12	20	0~-0.030

※ 3 types of coating to choose from



h6 (unit : mm)



★ Customized size, Coating, Inches size service available.

S500+ -11354TN	CED	CEL	SD	OAL
	1	3	4	50
	1.5	4.5		
	2	6		
	2.5	8		
	3	8		
	3.5	11		
	4	12		
	4.5	14	6	60
	5	15	6	
	6	16	6	
	7	16	8	
	8	20	8	75
	9	27	10	
	10	30	10	
	11	30	12	
	12	32	12	100
	16	45	16	
	20		20	

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
1MM	17976	336	11250	204	8427	156	10110	180	1	0.1
2MM	13500	372	8448	222	6336	174	7602	198	2	0.2
3MM	10185	408	6366	255	4776	192	5730	228	4.5	0.3
4MM	7641	459	4776	288	3582	216	4296	258	6	0.4
6MM	5094	408	3183	255	2388	192	2865	228	9	0.6
8MM	3819	381	2388	240	1791	180	2148	216	12	0.8
10MM	3057	429	1911	267	1431	201	1719	228	15	1
12MM	2547	408	1593	255	1194	192	1431	228	18	1.2
16MM	1527	396	954	249	717	186	858	222	24	1.6
20MM	1224	378	765	237	573	180	690	210	30	2

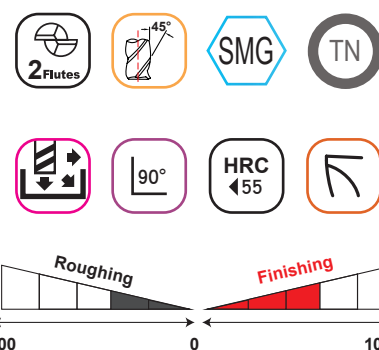
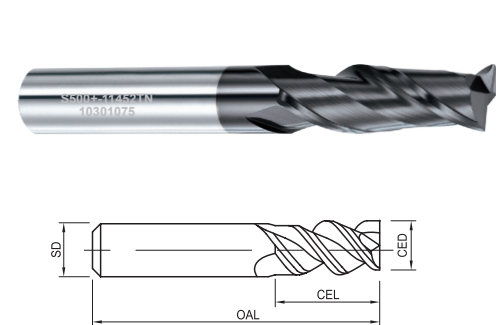
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500⁺-11452TN

◆ Square Type - 2F End Mills 45°

Parts Processing & General Processing



Dia.(mm)		Tolerance (mm)
Above	Up to	
1	3	0~-0.020
3	12	0~-0.025
12	20	0~-0.030

※ 3 types of coating to choose from



h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500 ⁺ -11452TN	CED	CEL	SD	OAL
	1	3	4	50
	2	6		
	3	8		
	4	12		
	6	16	6	60
	8	20	8	
	10	30	10	75
	12	32	12	

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC		a _p	a _e
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED		
1MM	15050	143	8400	86	6740	67	16800	266	1	1
2MM	11320	152	6350	86	5065	67	12650	266	2	1
3MM	8540	162	4770	91	3820	71	9550	271	3	1
4MM	6400	181	3580	103	2865	83	7160	271	4	2
6MM	4270	204	2390	91	1900	71	4770	228	6	3
8MM	3200	181	1790	103	1430	83	3590	238	8	4
10MM	2560	195	1430	95	1150	77	2870	247	10	5
12MM	2135	204	1190	103	955	83	2390	252	12	5

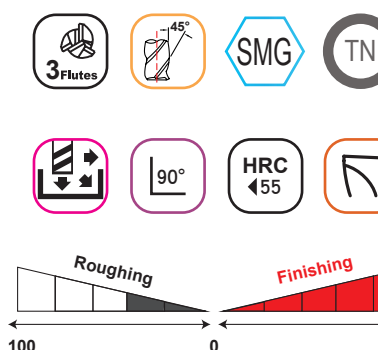
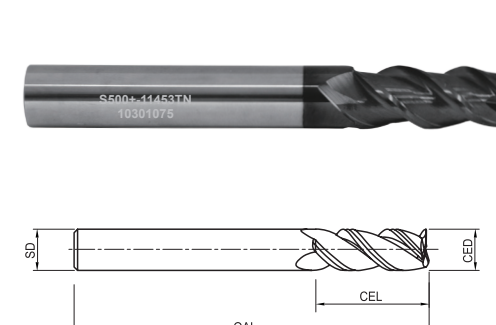
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500⁺-11453TN

◆ Square Type - 3F End Mills 45°

Parts Processing & General Processing



Dia.(mm)		Tolerance (mm)
Above	Up to	
1	3	0~-0.020
3	12	0~-0.025
12	20	0~-0.030

※ 3 types of coating to choose from



h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500 ⁺ -11453TN	CED	CEL	SD	OAL
	1	3	4	50
	2	6		
	3	8		
	4	12		
	6	16	6	60
	8	20	8	
	10	30	10	75
	12	32	12	

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC		a _p	a _e
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED		
1MM	14980	280	9375	170	7023	130	8425	150	1	1
2MM	11250	310	7040	185	5280	145	6335	165	2	1
3MM	8488	340	5305	213	3980	160	4775	190	5	1
4MM	6368	383	3980	240	2985	180	3580	215	6	2
6MM	4245	340	2653	213	1990	160	2388	190	9	2
8MM	3183	318	1990	200	1493	150	1790	180	12	4
10MM	2548	358	1593	223	1193	168	1433	185	15	5
12MM	2123	340	1328	213	995	160	1193	190	18	5

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500⁺-11454TN

◆ Square Type - 4F End Mills 45°

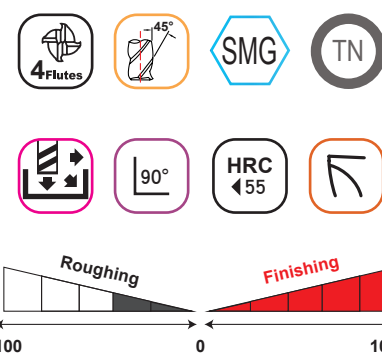
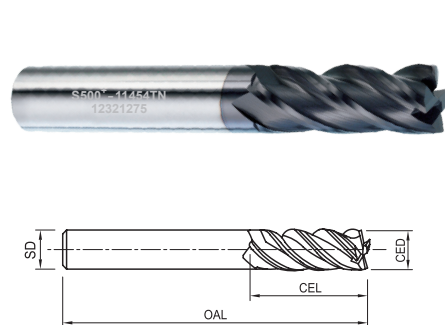
Parts Processing & General Processing



S500⁺-12354TN

◆ Square Type - 4F Long Flute 35°-4D

Parts Processing & General Processing



Dia.(mm)		Tolerance (mm)
Above	Up to	
1	3	0~-0.020
3	12	0~-0.025
12	20	0~-0.030

※ 3 types of coating to choose from

P	M	K	N	S	H
●	●	●	●	●	●

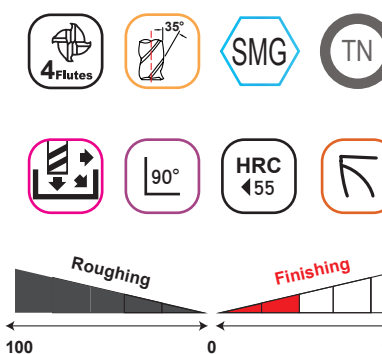
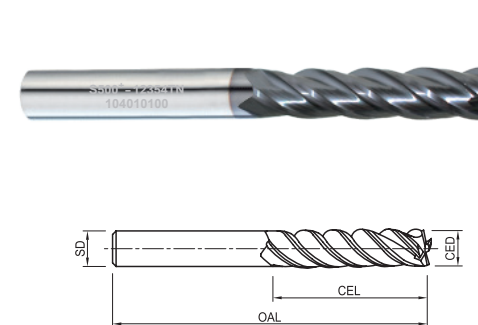
h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500 ⁺ -11454TN	CED	CEL	SD	OAL
	1	3	4	50
	1.5	4.5		
	2	6		
	2.5	8		
	3	8		
	3.5	11		
	4	12	6	60
	4.5	14		
	5	15		
	6	16		
	7	16	8	75
	8	20	8	
	9	27	10	
	10	30	10	
	11	30	12	100
	12	32	12	
	16	45	16	
	20		20	

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
1MM	19474	364	12188	221	9129	169	10953	195	1	0.1
2MM	14625	403	9152	241	6864	189	8236	215	2	0.2
3MM	11034	442	6897	276	5174	208	6208	247	4.5	0.3
4MM	8278	497	5174	312	3881	234	4654	280	6	0.4
6MM	5519	442	3448	276	2587	208	3104	247	9	0.6
8MM	4137	413	2587	260	1940	195	2327	234	12	0.8
10MM	3312	465	2070	289	1550	218	1862	235	15	1
12MM	2759	442	1726	276	1294	208	1550	247	18	1.2
16MM	1654	429	1034	270	777	202	930	241	24	1.6
20MM	1326	410	829	257	621	195	748	228	30	2

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



Dia.(mm)		Tolerance (mm)
Above	Up to	
4	12	0~-0.025
12	20	0~-0.030

※ 3 types of coating to choose from

P	M	K	N	S	H
●	●	●	●	●	●

h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500 ⁺ -12354TN	CED	CEL	SD	OAL
	6	24	6	75
	8	32	8	100
	10	40	10	100
	12	48	12	100
	16	64	16	150
	20	80	20	150

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
6MM	3420	135	2880	100	1800	75	3420	325	6	2.7
8MM	2800	135	2340	100	1440	75	2880	360	8	3.6
10MM	2160	155	1800	110	1080	75	2160	360	10	4.5
12MM	1710	155	1440	120	870	75	1710	380	12	5.4
16MM	1440	155	1200	120	720	75	1440	400	14	7.2
20MM	1400	160	1200	120	720	75	1440	400	16	9

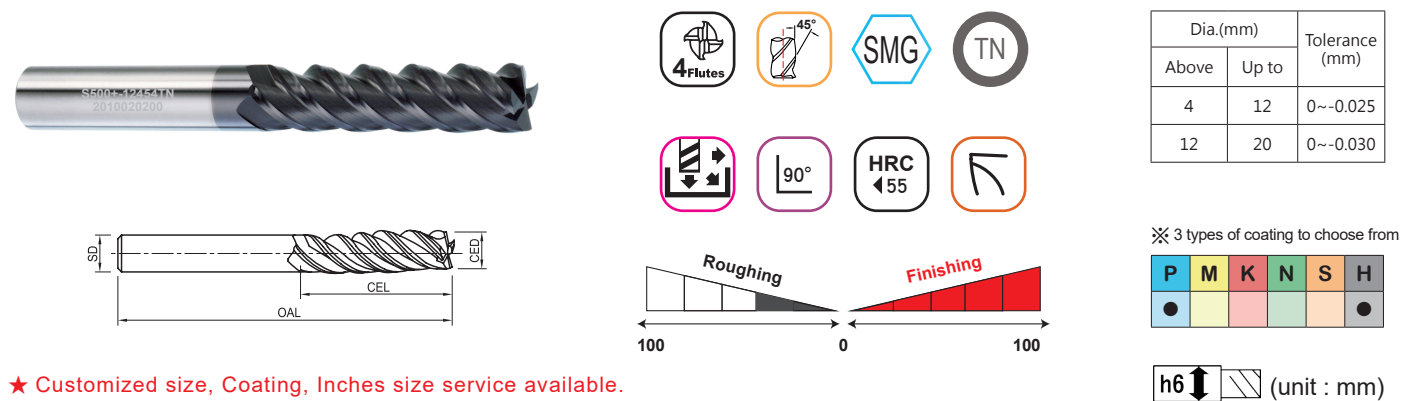
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500⁺-12454TN

◆ Square Type - 4F Long Flute 45°-5D

*Parts Processing
& General Processing*



★ Customized size, Coating, Inches size service available.

S500 ⁺ -12454TN	CED	CEL	SD	OAL
	6	30	6	75
	8	40	8	100
	10	50	10	
	12	60	12	120
	16	80	16	150
	20	100	20	200

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
6MM	3420	128	2880	95	1800	71	3420	309	6	2.7
8MM	2800	128	2340	95	1440	71	2880	342	8	3.6
10MM	2160	147	1800	105	1080	71	2160	342	10	4.5
12MM	1710	147	1440	114	870	71	1710	361	12	5.4
16MM	1440	147	1200	114	720	71	1440	380	14	7.2
20MM	1400	152	1200	114	720	71	1440	380	16	9

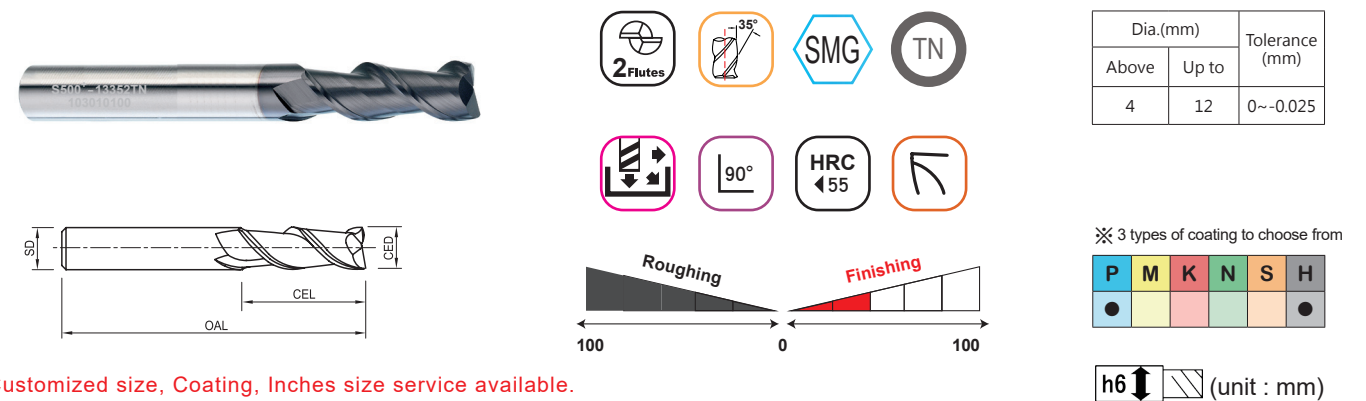
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500⁺-13352TN

◆ Square Type - 2F End Mills 35° - Long Shank-3D

*Parts Processing
& General Processing*



★ Customized size, Coating, Inches size service available.

S500+ -13352TN	CED	CEL	SD	OAL
	4	12	4	75
	5	15	6	
	6	18		
	8	24	8	100
	10	30	10	
	12	36	12	

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
4MM	4320	135	3600	100	2160	65	4320	290	4	1.8
6MM	2800	135	2340	100	1440	75	2880	360	8	3.6
8MM	2160	155	1800	110	1080	75	2160	360	10	4.5
10MM	1710	155	1440	120	870	75	1710	380	12	5.4
12MM	1440	155	1200	120	720	75	1440	400	14	7.2

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500⁺-13354TN

◆ Square Type - 4F End Mills 35° -Long Shank-3D

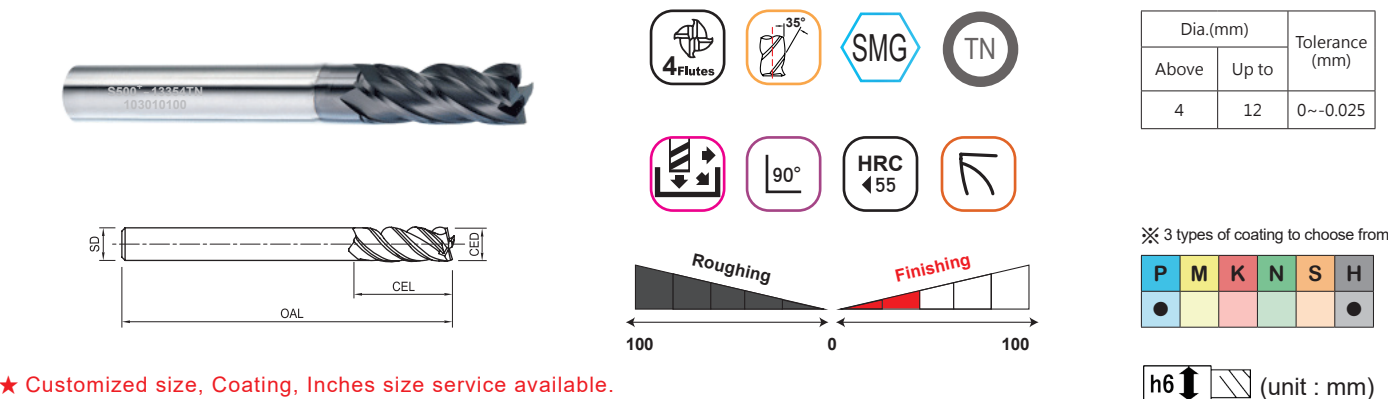
*Parts Processing
& General Processing*



S500⁺-11456TN

◆ Square Type - 6F End Mills 45°-3D

*Parts Processing
& General Processing*

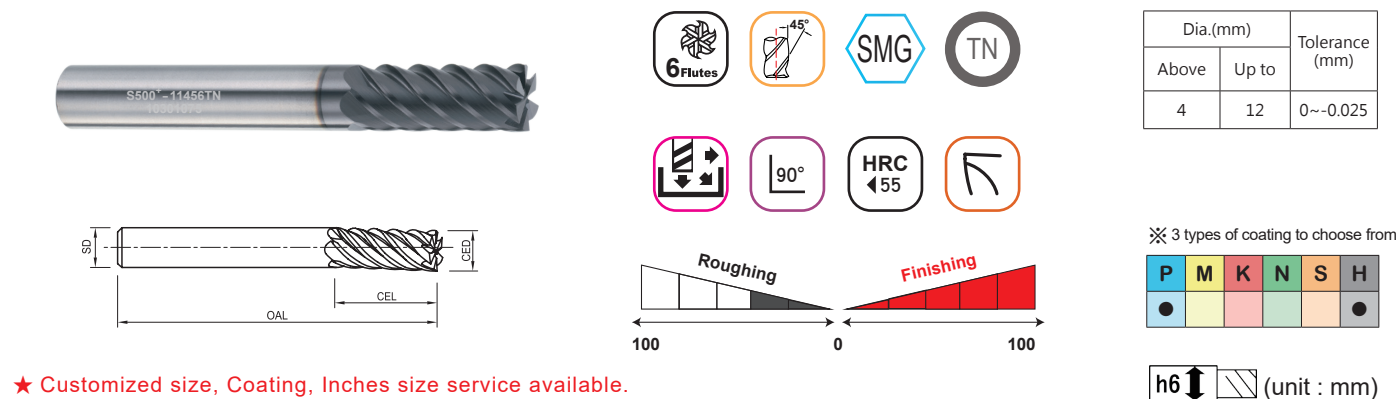


★ Customized size, Coating, Inches size service available.

S500+ -13354TN	CED	CEL	SD	OAL
	4	12	4	75
	5	15	6	
	6	18		
	8	24	8	100
	10	30	10	
	12	36	12	

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC		a _p	a _e
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED		
4MM	7800	1350	7800	1150	5800	490	7000	800	8	0.4
6MM	7450	1350	7450	1150	5300	510	6350	840	9	0.6
8MM	5550	1250	5550	1050	4000	540	4800	765	12	0.8
10MM	4450	1250	4450	1050	3200	510	3800	765	15	1
12MM	3700	1250	3700	1050	2650	510	3200	765	18	1.2

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



★ Customized size, Coating, Inches size service available.

S500 ⁺ -11456TN	CED	CEL /	SD	OAL
	6	18	6	50
	8	24	8	70
	10	30	10	75
	12	36	12	80
	16	48	16	100
	20	60	20	120

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC		a _p	a _e
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED		
6MM	6077	582	5065	487	4053	391	5065	487	7.5	0.10
8MM	4559	549	3800	458	3041	363	3800	458	12	0.10
10MM	3647	568	3041	473	2430	377	3041	473	15	0.10
12MM	3041	549	2535	458	2024	363	2535	458	18	0.10
16MM	2277	544	1900	458	1518	363	1518	458	24	0.20
20MM	1824	549	1518	454	1217	368	1217	454	30	0.20

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500R⁺-11404TN

◆ Square Type - 4F Heavy Duty End Mills 40° -2.5D

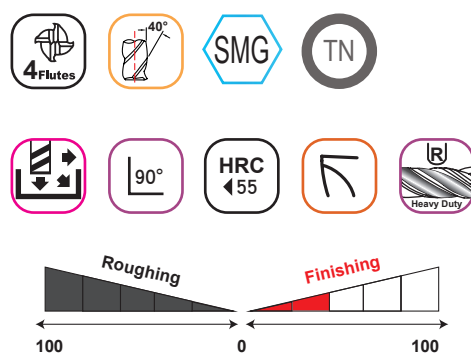
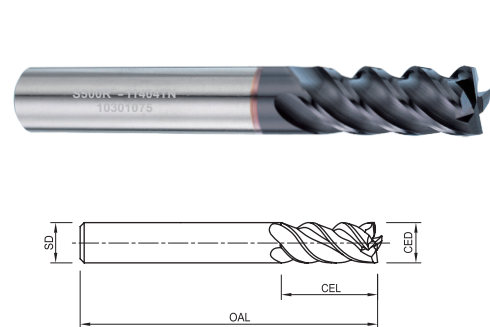
Parts Processing & General Processing



S500I⁺-11354TA

◆ Square Type - 4F End Mills 35°
◆ Uneven flute-2.5D

Parts Processing & General Processing



Dia.(mm)		Tolerance (mm)
Above	Up to	
4	12	0~-0.025

※ 3 types of coating to choose from



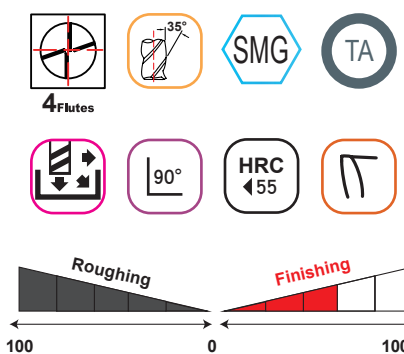
h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500R ⁺ -11404TN	CED	CEL	SD	OAL
	4	10	6	50
	6	15		
	8	20	8	60
	10	25	10	75
	12	30	12	80

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
4MM	6410	385	4007	242	3005	181	3604	216	6	0.4
6MM	4274	342	2670	214	2003	161	2404	191	9	0.6
8MM	3204	320	2003	201	1503	151	1802	181	12	0.8
10MM	2565	360	1603	224	1201	169	1442	198	15	1
12MM	2137	342	1336	214	1002	161	1201	191	18	1.2

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



Dia.(mm)		Tolerance (mm)
Above	Up to	
6	12	0~-0.020

※ 3 types of coating to choose from



h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500I ⁺ -11354TA	CED	CEL	SD	OAL
	1	2.5	4	50
	2	5	4	50
	3	7.5	4	50
	4	10	6	50
	6	15		
	8	20	8	60
	10	25	10	75
	12	25	12	

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
1MM	13000	820	12500	550	10500	400	8400	240	1	1.2
2MM	12500	980	11000	590	9700	440	7200	290	2	1.4
3MM	11000	1050	10000	620	9100	490	6500	320	3	1.6
4MM	10400	1190	9600	750	8000	520	6000	354	4	1.8
6MM	6900	1350	6400	1000	5400	700	4200	415	6	2.7
8MM	5200	1150	4800	1000	4200	690	3500	440	8	3.6
10MM	4100	1070	3800	890	3400	650	2900	435	10	4.5
12MM	3500	910	3200	830	2900	500	2450	410	12	5.4

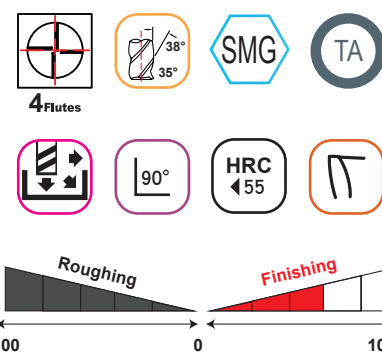
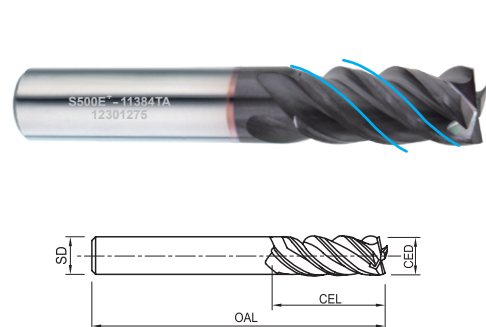
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500E⁺-11384TA

- ◆ Square Type - 4F End Mills 35°/38°
- ◆ Variable helix angle-2.5D

Parts Processing & General Processing



Dia.(mm)		Tolerance (mm)
Above	Up to	
6	12	0~-0.020

※ 3 types of coating to choose from



h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

	CED	CEL	SD	OAL
S500E ⁺ -11384TA	1	2.5	4	50
	2	5	4	50
	3	7.5	4	50
	4	10	6	50
	6	15		
	8	20	8	60
	10	25	10	75
	12	30	12	

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~65HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
1MM	13000	820	12500	550	10500	400	8400	240	1	1.2
2MM	12500	980	11000	590	9700	440	7200	290	2	1.4
3MM	11000	1050	10000	620	9100	490	6500	320	3	1.6
4MM	10400	1190	9600	750	8000	520	6000	345	4	1.8
6MM	6900	1350	6400	1000	5400	700	4200	415	6	2.7
8MM	5200	1150	4800	1000	4200	690	3500	440	8	3.6
10MM	4100	1070	3800	890	3400	650	2900	435	10	4.5
12MM	3500	910	3200	930	2900	500	2450	410	12	5.4

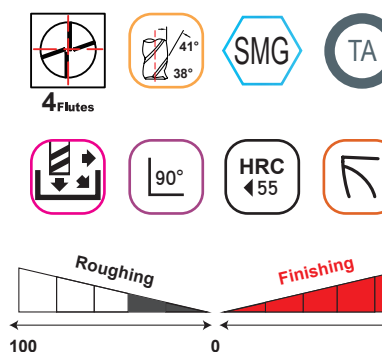
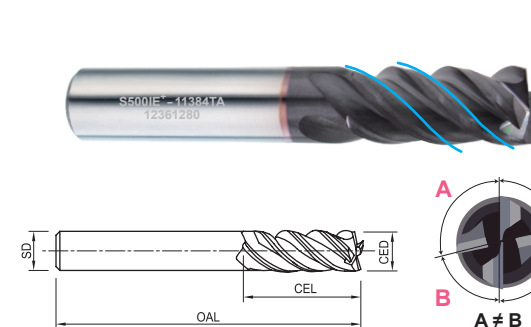
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500IE⁺-11384TA

- ◆ Square Type - 4F End Mills 38°/41°
- ◆ Uneven flute and Variable helix angle

Parts Processing & General Processing



Dia.(mm)		Tolerance (mm)
Above	Up to	
4	20	0~-0.020

※ 3 types of coating to choose from



h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

	CED	CEL	SD	OAL
S500IE ⁺ -11384TA	1	3	4	50
	2	6	4	50
	3	9	6	50
	4	12	6	50
	6	18		
	8	24	8	65
	10	30	10	75
	12	36	12	80
	16	48	16	100
	20	60	20	120

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
1MM	15500	850	14000	560	12000	400	8100	250	1	1.2
2MM	14000	950	13500	630	11500	450	8400	280	2	1.4
3MM	13800	1080	12700	700	10800	500	8000	310	3	1.6
4MM	10400	1190	9600	750	8000	520	6000	345	4	1.8
6MM	6900	1350	6400	1000	5400	700	4200	415	6	2.7
8MM	5200	1150	4800	1000	4200	690	3500	440	8	3.6
10MM	4100	1070	3800	890	3400	650	2900	435	10	4.5
12MM	3500	910	3200	830	2900	500	2450	410	12	5.4
16MM	2590	670	2380	620	2200	400	1800	330	14	7.2
20MM	2070	540	1910	500	1800	280	1500	300	16	9

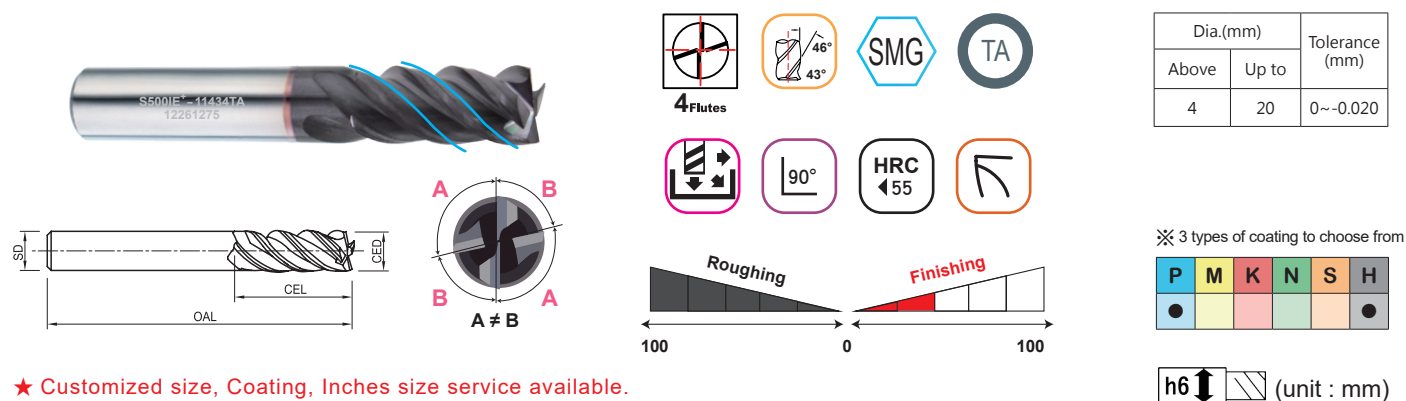
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500IE⁺-11434TA

- ◆ Square Type - 4F End Mills 43°/46°
- ◆ Uneven flute and Variable helix angle

Parts Processing & General Processing



S500IE ⁺ -11434TA	CED	CEL	SD	OAL
	1	2	4	50
	2	4	4	50
	3	7	6	50
	4	9	6	50
	6	13		
	8	18	8	60
	10	22	10	75
	12	26	12	75
	16	34	16	100
	20	42	20	

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC		--	
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
1MM	15500	850	14000	560	12000	400	8900	250	1	1.2
2MM	14000	950	13500	630	11500	450	8400	280	2	1.4
3MM	13800	1080	12700	700	10800	500	8000	310	3	1.6
4MM	10400	1190	9600	750	8000	520	6000	345	4	1.8
6MM	6900	1350	6400	1000	5400	700	4200	415	6	2.7
8MM	5200	1150	4800	1000	4200	690	3500	440	8	3.6
10MM	4100	1070	3800	890	3400	650	3900	435	10	4.5
12MM	3500	910	3200	830	2900	500	2450	410	12	5.4
16MM	2590	670	2380	620	2200	400	1800	330	14	7.2
20MM	2070	540	1910	500	1800	280	1500	300	16	9

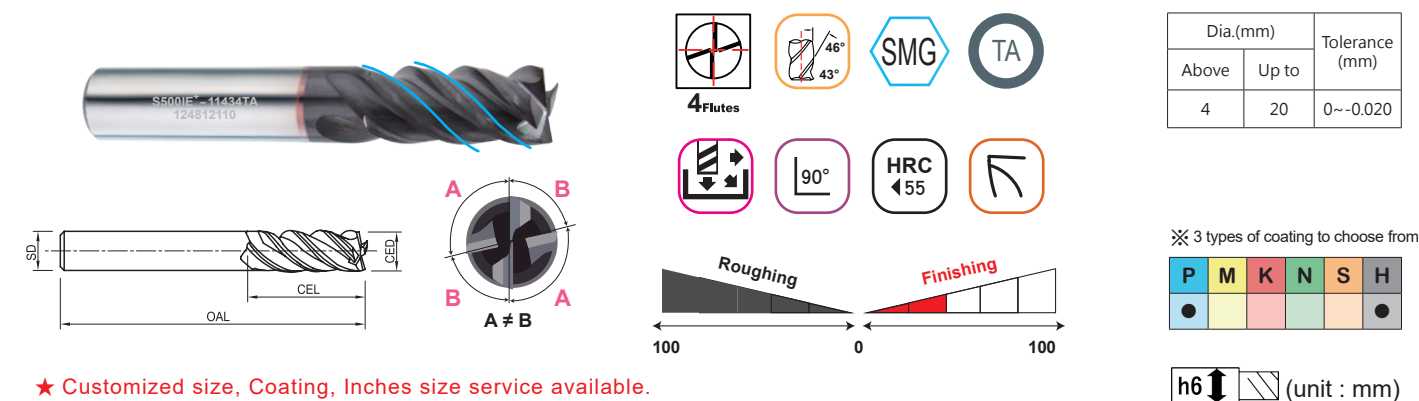
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500IE⁺-11434TA

- ◆ Square Type - 4F End Mills 43°/46°
- ◆ Uneven flute and Variable helix angle-4D

Parts Processing & General Processing



S500IE ⁺ -11434TA	CED	CEL	SD	OAL
	2	8	4	50
	3	12	6	
	4	16	6	55
	5	20	6	60
	6	24	6	65
	8	32	8	90
	10	40	10	100
	12	48	12	110
	16	64	16	140
	20	80	20	160

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC		--	
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
2MM	16250	1000	15000	660	11400	400	9370	305	2	1
3MM	13000	1090	11900	700	9500	460	7500	325	3	1.3
4MM	10400	1190	9600	750	8000	520	6000	345	4	1.8
5MM	8300	1290	7600	800	6600	590	4800	360	5	2.0
6MM	6900	1350	6400	1000	5400	700	4200	415	6	2.7
8MM	5200	1150	4800	1000	4200	690	3500	440	8	3.6
10MM	4100	1070	3800	890	3400	650	3900	435	10	4.5
12MM	3500	910	3200	830	2900	500	2450	410	12	5.4
16MM	2590	670	2380	620	2200	400	1800	330	14	7.2
20MM	2070	540	1910	500	1800	280	1500	300	16	9

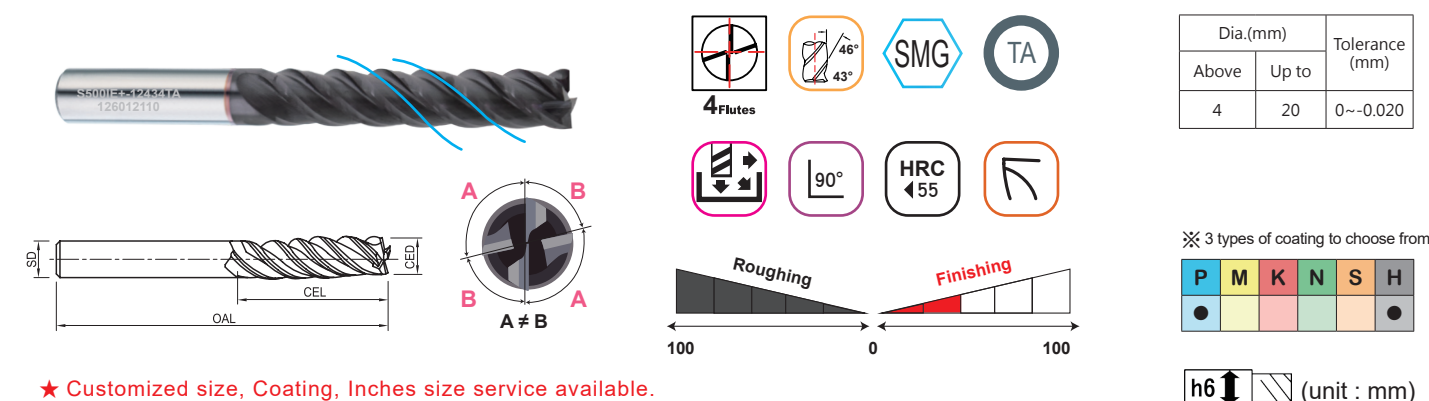
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500IE⁺ - 12434TA

- ◆ Square Type - 4F End Mills 43°/46°-Long flute
- ◆ Uneven flute and Variable helix angle

Parts Processing & General Processing



S500IE ⁺ -12434TA	CED	CEL	SD	OAL
	4	20	6	60
	6	30		75
	8	40	8	90
	10	50	10	100
	12	60	12	110
	16	80	16	160
	20	100	20	200

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC		--	
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
4MM	7200	144	6400	130	5600	110	4780	100	4	1.8
6MM	4800	192	4200	170	3700	150	3200	130	6	2.7
8MM	3600	290	3200	260	2800	220	2400	190	8	3.6
10MM	2900	290	2500	250	2200	220	1900	190	10	4.5
12MM	2400	300	2100	250	1900	230	1600	190	12	5.4
16MM	1800	250	1600	220	1400	200	1200	170	14	7.2
20MM	1430	230	1270	200	1100	180	960	150	16	9

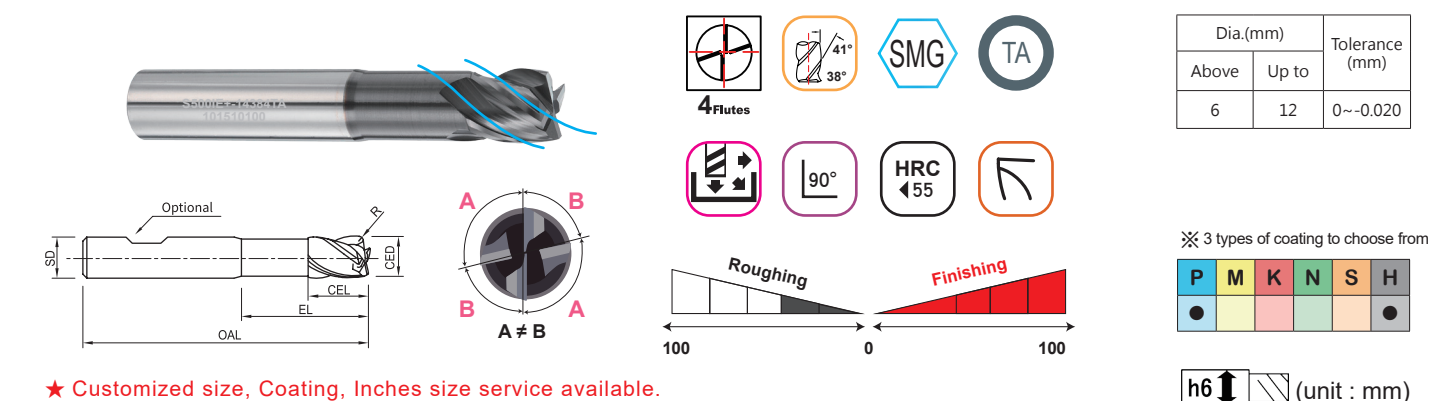
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500IE⁺ - 14384TA

- ◆ Square Type - 4F End Mills 38°/41°
- ◆ Uneven flute and Variable helix angle-1.5D

Parts Processing & General Processing



S500IE ⁺ -14384TA	CED	CEL	EL	SD	OAL
	6	9	30	6	70
	8	12	40	8	80
	10	15	50	10	100
	12	18	60	12	110

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC		--	
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
6MM	4700	860	3180	400	2120	370	4770	860	8	3.6
8MM	3580	860	2380	410	1590	370	3580	860	10	4.5
10MM	2860	880	1910	410	1270	360	2860	880	12	5.4
12MM	2380	810	1590	380	1050	340	2380	810	14	7.2

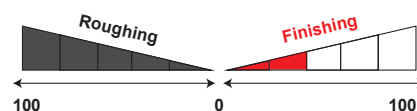
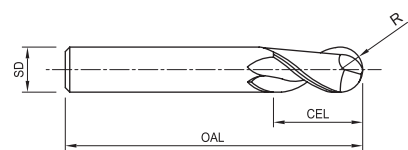
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500⁺-81302TN

◆ Ball Nose Type - 2F- 30° -2D

Parts Processing & General Processing



Radius(mm)	Tolerance (mm)
R	±0.01

※ 3 types of coating to choose from



h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500 ⁺ -81302TN	Radius	CEL	SD	OAL
	1R	4	4	50
	2R	8	4	50
	3R	12	6	60
	4R	16	8	60
	5R	20	10	75
	6R	24	12	75
	7R	28	16	100
	8R	32	16	100
	10R	40	20	100

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
1R	16100	486	12320	308	6600	146	12500	308	0.07	0.07
2R	11520	583	8780	454	4680	235	8780	454	0.12	0.12
3R	7700	729	5860	486	3120	292	5860	486	0.15	0.15
4R	5760	729	4420	486	2330	292	4420	486	0.17	0.17
5R	4590	729	3520	486	1850	292	3520	486	0.20	0.20
6R	3830	729	2920	502	1555	292	2920	502	0.25	0.25
7R	3810	740	2910	505	1500	295	2900	505	0.28	0.28
8R	3800	750	2900	510	1450	300	2850	510	0.30	0.30
10R	3750	760	2850	525	1350	310	2800	520	0.35	0.35

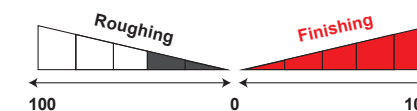
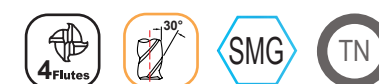
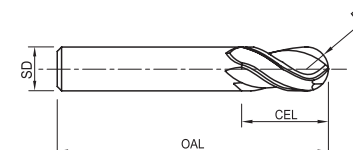
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500⁺-81304TN

◆ Ball Nose Type - 4F- 30° -2D

Parts Processing & General Processing



Radius(mm)	Tolerance (mm)
R	±0.01

※ 3 types of coating to choose from



h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500 ⁺ -81304TN	Radius	CEL	SD	OAL
	1R	4	4	50
	2R	8	4	50
	3R	12	6	60
	4R	16	8	60
	5R	20	10	75
	6R	24	12	75
	7R	28	16	100
	8R	32	16	100
	10R	40	20	100

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
1R	17710	600	13552	380	7260	180	13750	380	0.07	0.07
2R	12672	720	9658	560	5148	290	9658	560	0.12	0.12
3R	8470	900	6446	600	3432	360	6446	600	0.15	0.15
4R	6336	900	4862	600	2563	360	4862	600	0.17	0.17
5R	5049	900	3872	600	2035	360	3872	600	0.20	0.2
6R	4870	900	3212	620	2000	360	3600	620	0.25	0.25
7R	4750	900	3200	620	1980	360	3590	620	0.27	0.27
8R	4610	900	3150	620	1950	360	3550	620	0.30	0.30
10R	4500	910	3000	630	1900	370	3500	630	0.35	0.35

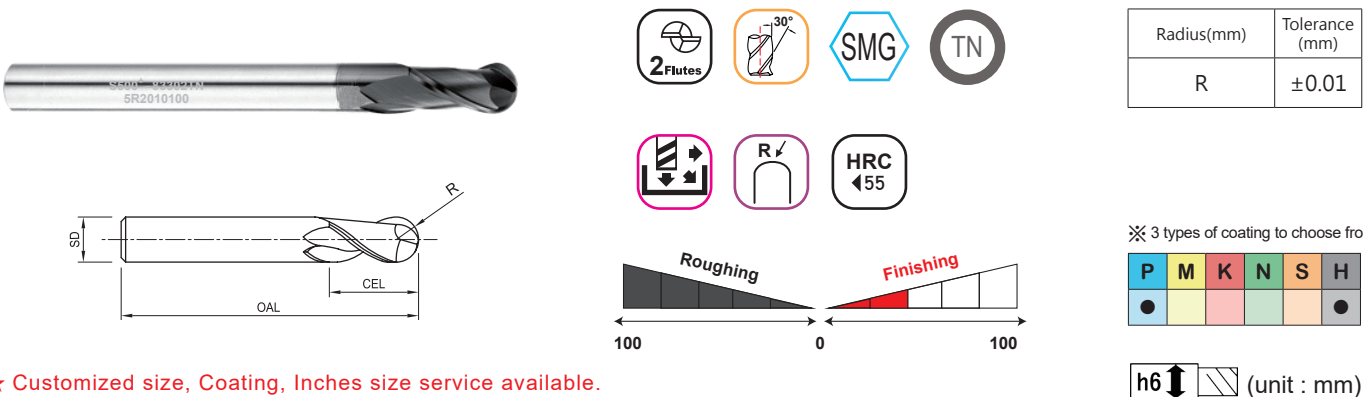
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500⁺-83302TN

◆ Ball Nose Type - 2F End Mills 30° -Long Shank

Parts Processing & General Processing



S500 ⁺ -83302TN	Radius	CEL	SD	OAL
	3R	12	6	75
	4R	16	8	100
	5R	20	10	100
	6R	24	12	100
	7R	28	16	150
	8R	32	16	150
	10R	40	20	150

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC		a _p	a _e
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED		
3R	5860	600	3750	450	3120	360	5860	600	0.15	0.15
4R	4420	600	2800	450	2330	360	4420	600	0.17	0.17
5R	3520	600	2260	450	1850	360	3521	600	0.20	0.20
6R	2920	750	1888	470	1550	360	2920	600	0.25	0.25
7R	2900	790	1750	480	1510	365	2850	605	0.28	0.28
8R	2800	800	1500	490	1500	370	2800	610	0.30	0.30
10R	2700	810	1450	500	1450	380	2750	620	0.35	0.35

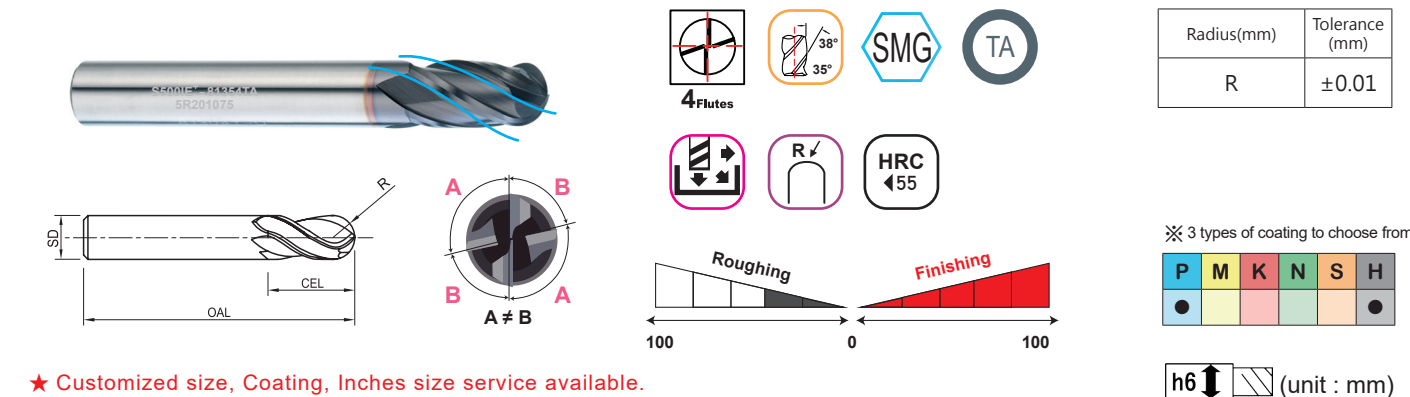
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500IE⁺-81354TA

◆ Ball NoseType - 4F -35°/38°
◆ Uneven flute and Variable helix angle

Parts Processing & General Processing



S500IE ⁺ -81354TA	Radius	CEL	SD	OAL
	2R	8	4	50
	3R	12	6	50
	4R	16	8	60
	5R	20	10	75
	6R	24	12	75

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC		a _p	a _e
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED		
2R	13300	750	10200	580	5400	300	10150	590	0.12	0.12
3R	8890	940	6800	630	3600	370	6800	630	0.15	0.15
4R	6650	940	5100	630	2700	370	5100	630	0.17	0.17
5R	5300	940	4100	630	2150	370	4100	630	0.20	0.20
6R	4450	940	3400	650	1790	370	3400	650	0.25	0.25

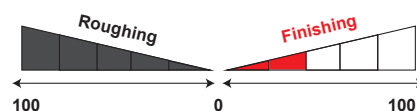
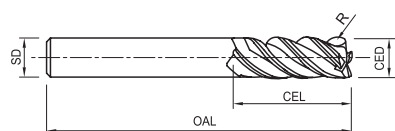
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500⁺-21354TN

◆ Corner Radius Type - 4F End Mills 35°

Parts Processing & General Processing



Dia.(mm)		Tolerance (mm)
Above	Up to	
4	12	0~-0.025

※ 3 types of coating to choose from

P	M	K	N	S	H
●	●	●	●	●	●

h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

S500 ⁺ -21354TN	CED	CEL	SD	OAL	Radius
	4	12	4	50	0.2R
					0.5R
	6	16	6	50	0.2R
					0.5R
	8	20	8	60	0.2R
					0.5R
	10	30	10	75	0.2R
					0.5R
	12	32	12	75	0.2R
					0.5R

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
4MM	7004	421	4378	264	3284	198	3938	237	0.17	0.17
6MM	4670	374	2918	234	2189	176	2626	209	0.20	0.2
8MM	3501	349	2189	220	1642	165	1969	198	0.25	0.25
10MM	2802	393	1752	245	1312	184	1576	180	0.30	0.3
12MM	2335	374	1460	234	1095	176	1312	209	0.35	0.35

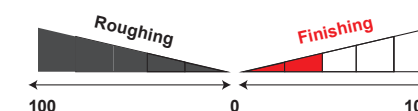
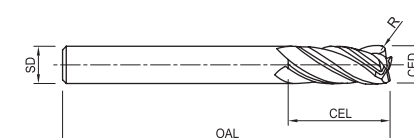
※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



S500⁺-23354TN

◆ Corner Radius Type - 4F End Mills 35°
◆ Long Shank-3D

Parts Processing & General Processing



Dia.(mm)		Tolerance (mm)
Above	Up to	
4	12	0~-0.025

※ 3 types of coating to choose from

P	M	K	N	S	H
●	●	●	●	●	●

h6 (unit : mm)

★ Customized size, Coating, Inches size service available.

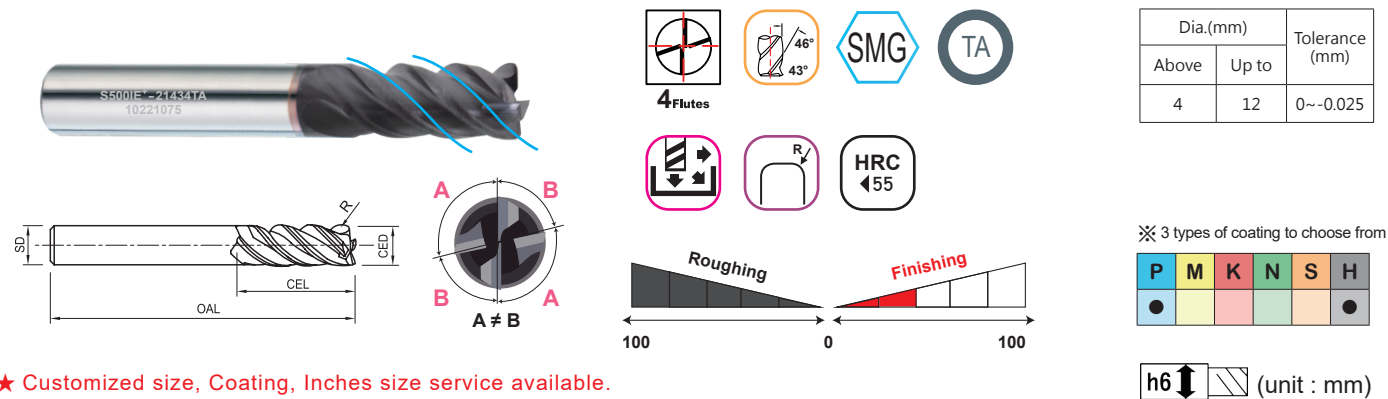
S500 ⁺ -23354TN	CED	CEL	SD	OAL	Radius
	4	12	4	75	0.2R
					0.5R
	6	18	6	75	0.2R
					0.5R
	8	24	8	100	0.2R
					0.5R
	10	30	10	100	0.2R
					0.5R
	12	36	12	100	0.2R
					0.5R

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
4MM	7004	383	4378	240	3284	180	3938	215	0.6	1.6
6MM	4670	340	2918	213	2189	160	2626	190	0.6	2.4
8MM	3501	318	2189	200	1642	150	1969	180	0.6	3.2
10MM	2802	358	1752	223	1312	168	1576	185	0.6	4.0
12MM	2335	340	1460	213	1095	160	1312	190	0.6	4.8

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.



Parts Processing & General Processing



S500IE+ -21434TA	CED	CEL	SD	OAL	Radius
	4	9	6	50	0.2R
					0.5R
	6	13	6	50	0.2R
					0.5R
	8	18	8	60	0.5R
					1R
	10	22	10	75	0.5R
					1R
	12	26	12	75	0.5R
1R					

WORKING MATERIAL	ALLOY STEELS/ TOOLS STEELS		HARDENED STEEL						REFERENCE	
HARDNESS	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	a _p	a _e
4MM	7896	474	4935	298	3701	223	4439	267	0.6	1.6
6MM	5264	422	3289	264	2468	198	2961	236	0.6	2.4
8MM	3946	394	2468	248	1851	186	2220	223	0.6	3.2
10MM	3159	443	1975	276	1479	208	1776	230	0.6	4.0
12MM	2632	422	1646	264	1234	198	1479	236	0.6	4.8

※The cutting parameters is for reference value only. Please adjust it according to your working conditions.

This image shows a full page of blank graph paper. The background is a solid light gray color. Overlaid on this background is a precise grid of thin, light blue horizontal and vertical lines. These lines intersect to form a series of small, identical squares that cover the entire area of the page, leaving no margins or other markings.