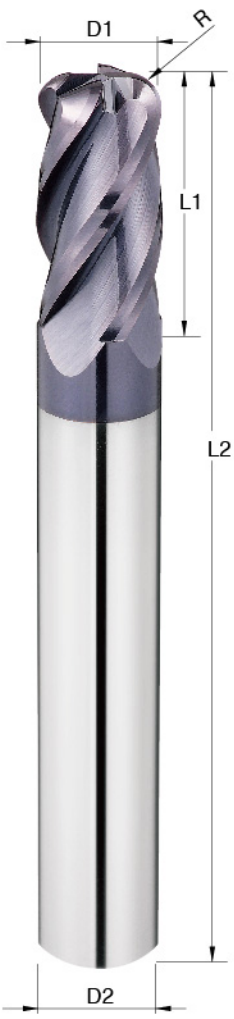
SUPER MILL

SRD



S MG

4 Flutes

35°

R

HRC 60

ALTiN

Finishing
Semi-Finishing

Side

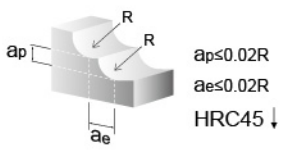
Profiling

▶ Corner Radius / for H P K

unit: mm

Order No.	Diameter D1	Corner R R	Flute Length L1	O.A.L. L2	Shank Dia D2
SRD **01502**	1.5	0.2	3	50	4
SRD **0202**	2.0	0.2	4	50	4
SRD **0205**	2.0	0.5	4	50	4
SRD **0302**	3.0	0.2	6	50	3
SRD **0302.4**	3.0	0.2	6	50	4
SRD **0303.4**	3.0	0.3	6	50	4
SRD **0305**	3.0	0.5	6	50	3
SRD **0305.4**	3.0	0.5	6	50	4
SRD **0310.4**	3.0	1.0	6	50	4
SRD **0402**	4.0	0.2	8	50	4
SRD **0405**	4.0	0.5	8	50	4
SRD **0410**	4.0	1.0	8	50	4
SRD **0602**	6.0	0.2	12	50	6
SRD **0603**	6.0	0.3	12	50	6
SRD **0605**	6.0	0.5	12	50	6
SRD **0610**	6.0	1.0	12	50	6
SRD **0615**	6.0	1.5	12	50	6
SRD **0620**	6.0	2.0	12	50	6
SRD **0803**	8.0	0.3	16	60	8
SRD **0805**	8.0	0.5	16	60	8
SRD **0810**	8.0	1.0	16	60	8
SRD **0815**	8.0	1.5	16	60	8
SRD **0820**	8.0	2.0	16	60	8
SRD **1003**	10.0	0.3	20	75	10
SRD **1005**	10.0	0.5	20	75	10
SRD **1010**	10.0	1.0	20	75	10
SRD **1015**	10.0	1.5	20	75	10
SRD **1020**	10.0	2.0	20	75	10
SRD **1030**	10.0	3.0	20	75	10
SRD **1205**	12.0	0.5	24	75	12
SRD **1210**	12.0	1.0	24	75	12
SRD **1215**	12.0	1.5	24	75	12
SRD **1220**	12.0	2.0	24	75	12
SRD **1230**	12.0	3.0	24	75	12

▼ *Depth of cut*



ap≤0.02R
ae≤0.02R
HRC45 ↓

ap≤D1
ae≤0.02 D1
HRC45 ↑

R=Corner R

▼ *Recommended cutting condition for SRD*

MATERIAL	Carbon Steels . Alloy Steels S45C , FC , FCD , SCM , S50C , SKS...		Alloy Steels . Tool Steels SCr , SNCM , SKD11 , SKD61 , NAK80...		Hardened Steels SKD11	
HARDNESS	~HRC30		~HRC50		~HRC60	
Dia. (D1)	SPEED (min^{-1})	FEED mm / min	SPEED (min^{-1})	FEED mm / min	SPEED (min^{-1})	FEED mm / min
2	26000	1600	16500	1000	7500	300
3	19000	1800	12000	1200	5400	360
4	16000	3200	10000	1900	4800	480
5	14000	3300	8000	2000	3800	500
6	12000	3600	7200	2200	3500	650
8	9600	4000	5600	2200	2700	750
10	7000	3400	4400	1700	2100	650
12	6000	2800	3600	1400	1800	600
16	4500	2000	2800	1000	1400	450