

## MAGIC CUT

## QEBN

► Square / for **H** **P** **K**

unit: mm

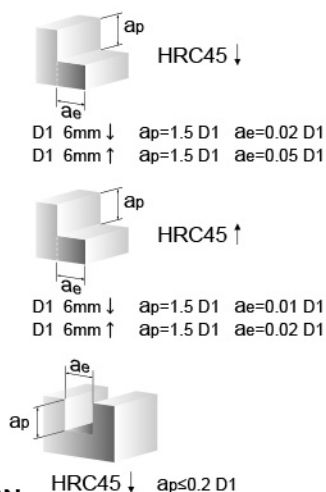
Order No.	Diameter D1	Flute Length L1	O.A.L. L2	Shank Dia D2
QEBN 0304	3.0	8	50	4
QEBN 0404	4.0	11	50	4
QEBN 0506	5.0	13	50	6
QEBN 0606	6.0	16	50	6
QEBN 0808	8.0	20	60	8
QEBN 1010	10.0	25	75	10
QEBN 1212	12.0	30	75	12
QEBN 1616	16.0	40	100	16
QEBN 2020	20.0	45	100	20



## ▼ Recommended cutting condition for QEBN

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 <sup>-1</sup> )	FEED mm / min	SPEED (min <sup>-1</sup> )	FEED mm / min	SPEED (min <sup>-1</sup> )	FEED mm / min	
Side Milling	3	20000	2000	16000	1000	9000	500
	4	19000	2000	12000	1300	6000	550
	5	13000	1800	10000	1400	5000	500
	6	10000	3000	8000	1500	4500	700
	8	8000	3200	5000	1300	3500	600
	10	7000	3000	4500	1200	3000	500
	12	5000	2000	4000	1100	2000	500
	16	4000	1800	3500	1000	1800	450
20	3500	1600	3000	1000	1300	450	
Grooving	3	20000	2000	20000	1200	16000	1200
	4	16000	2000	16000	1200	12000	1300
	5	13000	1800	13000	1100	10000	1400
	6	10000	3000	10000	2100	8000	1500
	8	8000	2900	8000	1800	6000	1400
	10	7000	2800	6000	1700	5000	1300
	12	5000	2300	5500	1700	4500	1200
	16	3500	1800	4500	1800	3500	1200
20	3000	1400	3000	1500	2600	1100	

## ▼ Depth of cut



QEBN