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CARBIDE END MILLS

End Mill Introduction Table

Reference Table for Processed Materials: Perfect ● Suitable ○ Unable ×

Rockwell Hardness HRC	Mild steel	Alloy steel	Die steel	High hardness steel		Stainless steel		Iron	Aluminum Alloy	Copper Alloy
	S45	NAK	30~40HRC	40~50HRC	50~65HRC	Rough mill	Fine mill	QT HT	AC	CU
55° END MILL	●	●	●	○	×	○	×	●	●	○
60° END MILL	×	○	●	●	○	×	○	○	●	●
65° END MILL	×	○	●	●	●	×	●	○	×	×
68° END MILL	×	×	○	●	●	×	●	×	×	×
60S END MILL	●	●	○	×	×	●	○	●	○	○

Table of commonly used ordinary CNC cutting parameters

Material	Die steel lower than HRC45			Aluminium Alloy Process			Heat treated steel more than HRC50		
Spec.(Dia.)	Speed(S)	Feed (F)	Removal	Speed(S)	Feed (F)	Removal	Speed(S)	Feed (F)	Removal
0.5	8000	500	0.05-0.1	8000	1000-2000	0.05-0.15	7000-8000	350-500	0.02-0.05
1	4500-5000	1000-1500	0.1-0.2	6500-8000	1000-2000	0.15-0.5	3800-4500	1000-2000	0.05-0.1
1.5	4200-4500	1500-2000	0.1-0.2	6000-8000	1000-2000	0.3-0.6	3200-4500	1500-2500	0.05-0.15
2	4000-4500	2000-2500	0.1-0.2	6000-8000	1500-3000	0.5-1.5	3200-4500	1500-2500	0.05-0.15
2.5	4000-4200	2000-2500	0.1-0.2	5000-8000	1500-3000	0.5-2	3200-4500	1500-2500	0.05-0.15
3	4000-4200	2500-3000	0.1-0.2	5000-8000	1500-3000	0.5-2	2500-4200	2000-3000	0.05-0.15
4	3300-4200	2500-3000	0.1-0.3	5000-8000	1500-3500	0.5-2.5	2200-4000	2000-3500	0.05-0.15
5	2800-4200	2200-3500	0.1-0.3	5000-8000	1500-3500	0.5-3	2000-3800	2000-3500	0.05-0.15
6	2500-4000	2000-3500	0.1-0.3	4200-7000	1500-3500	0.5-3	2000-3800	2000-3500	0.05-0.15
8	2500-4000	2000-3500	0.1-0.3	3500-7000	1500-3500	0.5-5	2000-3800	2000-3500	0.05-0.15
10	2200-3500	2000-3500	0.1-0.35	3200-6000	1500-3500	1.0-5.0	1500-3300	1500-2800	0.05-0.25
12	2200-3500	2000-3500	0.1-0.35	3200-6000	1500-3500	1.0-5.0	1350-3200	1500-2500	0.05-0.3
14	1850-2800	1500-3000	0.2-0.4	2500-5500	1500-3500	1.0-8.0	1300-3000	1000-2300	0.05-0.3
16	1500-2200	1500-2800	0.3-0.5	2200-5000	1500-3500	1.0-8.0	850-2200	1000-2200	0.05-0.3
20	1350-2000	1200-2300	0.3-0.5	2200-5000	1500-3500	1.0-8.0	680-2000	1000-2300	0.05-0.3

Description:

HRC55 END MILL Made of high-quality Chinese produced tungsten steel bars, with a surface coating of purple or black gray color nano coating. It has good versatility and can be used for rough and fine machining. It can process various die steels, cast iron, copper parts, etc. which hardness below HRC45. This end mill is cheap.

HRC60S END MILL Made of high-quality Chinese tungsten steel material with a purple black nano coating, suitable for processing stainless steel, die steel with a hardness lower than HRC45, alloy steel, cast iron, etc. Suitable for low speed and large cutting capacity processing, it belongs to the heavy cutting type milling cutter. The product is characterized by excellent toughness and it is not easy to break.

HRC60 END MILL Made of Taiwan tungsten steel material, with a silicon containing bronze color on the surface, suitable for processing steel below HRC52 degrees, suitable for precision machining, especially for mold steel, alloy steel, etc., with good performance. The product is characterized by good wear resistance.

HRC 65 END MILL Made of Taiwan tungsten steel, with a blue nano coating on the surface. Various materials below HRC52 can be processed and cutted, exhibiting high wear resistance. Suitable for precision machining and exhibiting good performance on mold steel, alloy steel, stainless steel, etc. The product has good wear resistance.

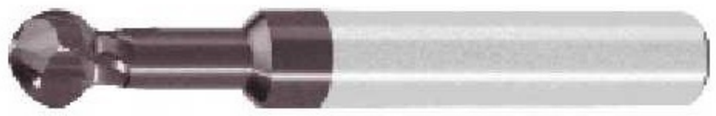
HRC68 END MILL Using German ultrafine particle material, the surface coating is a composite copper nano coating, suitable for processing steel with HRC62 degree or below. Good grinding process, high-precision processing, suitable for precision machining of molds and related products. The product is characterized by good smoothness during high-speed processing.

HRC66 END MILL Using 0.2um ultrafine particle material, the surface coating is a composite black nano coating, suitable for processing steel with HRC62 degree or below. Good grinding process, high-precision processing, suitable for precision machining of molds and related products. The product is characterized by good smoothness during high-speed processing.

通用表 Parameters	特长刃刀具 Super long end mill	深沟铣刀、深沟圆鼻铣刀 Deep groove nose mill
标刀刀具 Standard tool	钨钢粗柄加长球刀 large shank ball blade	钨钢粗皮铣刀、钨钢铰刀 Rough End mill /reamer
钨钢通柄钻头 Tungsten steel drill bit	钨钢二刃球刀 2F End mill	钨钢雕刻刀、单刃刀 1F End mill
钨钢定柄钻头 Fixed shank drill bit	加长球头铣刀、不常用球头铣刀 Ball mill	内R刀 R mill
棒棒糖球刀 Lollipop mill blade	二刃平铣刀 2F flat end mill	圆棒价格表 Round Rod
四刃铣刀 4F End mill blade	铝用三刃铣刀(二刃) Aluminium End mill	合金T型铣刀 T blade
粗柄加长四刃铣刀 Large shank 4F blade	钨钢四刃圆鼻铣刀 4F Round nose Mill	单牙钨钢螺纹铣刀报价单 Screw mill
小数点铣刀 Decimal point mill blade	高精密微小径铣刀 Micro diameter mill	三牙钨钢螺纹铣刀报价单
加长铣刀 Long shank end mill blade	直刃倒角刀(90° 60°) Chamfering blade	全牙钨钢螺纹铣刀报价单 Full screw mill
不常用铣刀 Unusual used End mill	定心钻(90° 60°定心和倒角双用) Drill bits	钨钢燕尾铣刀 Dovetail milling cutter
模架模框铣刀 Mold frame milling blade	深沟小径刀、深沟球刀 Deep groove mill	四刃球刀 4F ball blade

钨钢定柄钻头（单数粗柄径）
Fixed shank drill bit

钨钢定柄钻头(3倍径) 棒棒糖球刀
Fixed shank drill bit(3times diameter) Lollipop mill blade



钨钢四刃铣刀 4F End mill
60度以上的刀具的直径6以上的标刀为2.5倍径

粗柄加长四刃铣刀 Large shank 4F End mill blade

加长铣刀系列

Long shank End mill blade

模架模框刀系列

Mold frame End mill blade

钨钢二刃球刀
Tungsten 2F ball mill blade

加长球头铣刀

Long shank ball mill blade

不常用球头铣刀

Unusual used ball mill

二刃平铣刀
2F End mill

铝用三刃铣刀（二刃）
Aluminium blade 2F / 3F

二刃平铣刀

2F flat End mill

铝用三刃铣刀(二刃)

Aluminium blade 3F/2F

钨钢四刃圆鼻铣刀
注意：铝用圆鼻刀为三刃

4F End mill round nose mill blade (Aluminium 3F)

高精密微小径铣刀
Micro diameter mill

直刃倒角刀（90° 60° ）
Chamfering blade

定心钻（90 ° 60 °定心和倒角双用）

Centering drill bit

深沟小径刀

平刀/球刀

Deep groove small diameter blade flat/ball

深沟球刀

二刃/铝用

2F for aluminium

深沟铣刀

四刃/二刃/铝用

Deep groove End mill

深沟圆鼻铣刀

四刃/三刃铝用

Deep groove nose mill

钨钢粗皮铣刀 Rough End mill

钨钢铰刀 Reamer bit

注：铰刀的精度一律为H7

钨钢雕刻刀 Carving End mill

单刃刀 1F mill

表中的柄4的也可以改为3.175柄

内R刀 R mill

圆棒价格表

Tungsten steel round rod

合金T型铣刀 Alloy T shape mill blade

单牙钨钢螺纹铣刀

1 thread End mill

三牙钨钢螺纹铣刀

3 thread End mill

全牙钨钢螺纹铣刀

Full thread End mill

钨钢燕尾铣刀

Dovetail end mill

四刃球刀

4F ball blade