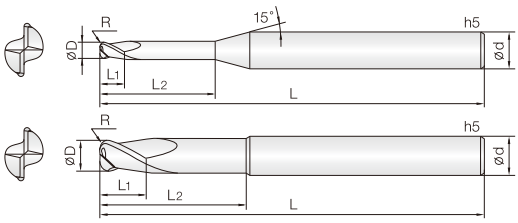
2COR

2 Flutes Rib Corner Radius End Mills for Copper

2날 동가공용 리브 코너 레디우스 엔드밀



- **동 및 동합금, 알루미늄 합금, 비철합금 가공용 엔드밀**
- JCRO 코팅 처리하여 다양한 피삭재 가공시 인선부에 스트레스가 적으며, 피삭재의 면조도가 향상됩니다.
- 깊은 포켓으로 설계하여 칩배출이 원활합니다.
- 항절력이 높은 미립자 초경합금 (0.5㎛)을채택, 엔드밀의 파손을 최소화 하였습니다.

- **Endmills for copper, copper alloy, nonferrous and non-metallic materials.**
- JCRO coating provides wear resistance improvement as well as avoid edge stress in various applications.
- Smooth chip outflow by deep chip pocket.
- Minimize fracturing by high TRS fine(0.5㎛) WC grade.

2 | WC 미립자 | JCRO Coating | R ± 0.005 R0.1 ~ 0.5 | R ± 0.01 R1 ~ 1.5 | 30° Helix Angle | CUTTING DATA 356P

D Size	D Tolerance
Ø 1 ~ 4	+0 ~ -0.01mm
Ø 6 ~ 12	-0.005 ~ -0.015mm

단위: mm

Order Number	날경 Diameter D×R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	생크 Shank Dia d	비고
2COR 010 001 040	1 X R0.1	1.5	4	50	4	
2COR 010 001 060	1 X R0.1	1.5	6	50	4	
2COR 010 001 080	1 X R0.1	1.5	8	50	4	
2COR 010 001 100	1 X R0.1	1.5	10	50	4	
2COR 010 001 120	1 X R0.1	1.5	12	50	4	
2COR 010 001 160	1 X R0.1	1.5	16	50	4	
2COR 010 001 200	1 X R0.1	1.5	20	50	4	
2COR 010 002 040	1 X R0.2	1.5	4	50	4	
2COR 010 002 060	1 X R0.2	1.5	6	50	4	
2COR 010 002 080	1 X R0.2	1.5	8	50	4	
2COR 010 002 100	1 X R0.2	1.5	10	50	4	
2COR 010 002 120	1 X R0.2	1.5	12	50	4	
2COR 010 002 160	1 X R0.2	1.5	16	50	4	
2COR 010 002 200	1 X R0.2	1.5	20	50	4	
2COR 010 003 040	1 X R0.3	1.5	4	50	4	
2COR 010 003 060	1 X R0.3	1.5	6	50	4	
2COR 010 003 080	1 X R0.3	1.5	8	50	4	
2COR 010 003 100	1 X R0.3	1.5	10	50	4	
2COR 010 003 120	1 X R0.3	1.5	12	50	4	
2COR 010 003 160	1 X R0.3	1.5	16	50	4	
2COR 010 003 200	1 X R0.3	1.5	20	50	4	
2COR 015 001 060	1.5 X R0.1	2	6	50	4	
2COR 015 001 100	1.5 X R0.1	2	10	50	4	
2COR 015 001 120	1.5 X R0.1	2	12	50	4	
2COR 015 001 160	1.5 X R0.1	2	16	50	4	
2COR 015 001 200	1.5 X R0.1	2	20	50	4	
2COR 015 001 250	1.5 X R0.1	2	25	60	4	
2COR 015 002 060	1.5 X R0.2	2	6	50	4	
2COR 015 002 100	1.5 X R0.2	2	10	50	4	
2COR 015 002 120	1.5 X R0.2	2	12	50	4	
2COR 015 002 160	1.5 X R0.2	2	16	50	4	
2COR 015 002 200	1.5 X R0.2	2	20	50	4	
2COR 015 002 250	1.5 X R0.2	2	25	60	4	
2COR 015 003 060	1.5 X R0.3	2	6	50	4	
2COR 015 003 100	1.5 X R0.3	2	10	50	4	
2COR 015 003 120	1.5 X R0.3	2	12	50	4	
2COR 015 003 160	1.5 X R0.3	2	16	50	4	
2COR 015 003 200	1.5 X R0.3	2	20	50	4	
2COR 015 003 250	1.5 X R0.3	2	25	60	4	
2COR 015 005 060	1.5 X R0.5	2	6	50	4	
2COR 015 005 100	1.5 X R0.5	2	10	50	4	
2COR 015 005 120	1.5 X R0.5	2	12	50	4	
2COR 015 005 160	1.5 X R0.5	2	16	50	4	
2COR 015 005 200	1.5 X R0.5	2	20	50	4	
2COR 015 005 250	1.5 X R0.5	2	25	60	4	
2COR 020 001 060	2 X R0.1	3	6	50	4	
2COR 020 001 100	2 X R0.1	3	10	50	4	
2COR 020 001 120	2 X R0.1	3	12	50	4	
2COR 020 001 160	2 X R0.1	3	16	50	4	
2COR 020 001 200	2 X R0.1	3	20	50	4	

Order Number	날경 Diameter D×R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	생크 Shank Dia d	비고
2COR 020 001 250	2 X R0.1	3	25	60	4	
2COR 020 002 060	2 X R0.2	3	6	50	4	
2COR 020 002 100	2 X R0.2	3	10	50	4	
2COR 020 002 120	2 X R0.2	3	12	50	4	
2COR 020 002 160	2 X R0.2	3	16	50	4	
2COR 020 002 200	2 X R0.2	3	20	50	4	
2COR 020 002 250	2 X R0.2	3	25	60	4	
2COR 020 003 060	2 X R0.3	3	6	50	4	
2COR 020 003 100	2 X R0.3	3	10	50	4	
2COR 020 003 120	2 X R0.3	3	12	50	4	
2COR 020 003 160	2 X R0.3	3	16	50	4	
2COR 020 003 200	2 X R0.3	3	20	50	4	
2COR 020 003 250	2 X R0.3	3	25	60	4	
2COR 020 005 060	2 X R0.5	3	6	50	4	
2COR 020 005 100	2 X R0.5	3	10	50	4	
2COR 020 005 120	2 X R0.5	3	12	50	4	
2COR 020 005 140	2 X R0.5	3	14	50	4	
2COR 020 005 160	2 X R0.5	3	16	50	4	
2COR 020 005 200	2 X R0.5	3	20	50	4	
2COR 020 005 250	2 X R0.5	3	25	60	4	
2COR 025 001 060	2.5 X R0.1	3.5	6	50	4	
2COR 025 001 100	2.5 X R0.1	3.5	10	50	4	
2COR 025 001 120	2.5 X R0.1	3.5	12	50	4	
2COR 025 001 160	2.5 X R0.1	3.5	16	50	4	
2COR 025 001 200	2.5 X R0.1	3.5	20	50	4	
2COR 025 001 250	2.5 X R0.1	3.5	25	60	4	
2COR 025 002 060	2.5 X R0.2	3.5	6	50	4	
2COR 025 002 100	2.5 X R0.2	3.5	10	50	4	
2COR 025 002 120	2.5 X R0.2	3.5	12	50	4	
2COR 025 002 160	2.5 X R0.2	3.5	16	50	4	
2COR 025 002 200	2.5 X R0.2	3.5	20	50	4	
2COR 025 002 250	2.5 X R0.2	3.5	25	60	4	
2COR 025 003 060	2.5 X R0.3	3.5	6	50	4	
2COR 025 003 100	2.5 X R0.3	3.5	10	50	4	
2COR 025 003 120	2.5 X R0.3	3.5	12	50	4	
2COR 025 003 160	2.5 X R0.3	3.5	16	50	4	
2COR 025 003 200	2.5 X R0.3	3.5	20	50	4	
2COR 025 003 250	2.5 X R0.3	3.5	25	60	4	
2COR 025 005 060	2.5 X R0.5	3.5	6	50	4	
2COR 025 005 100	2.5 X R0.5	3.5	10	50	4	
2COR 025 005 120	2.5 X R0.5	3.5	12	50	4	
2COR 025 005 160	2.5 X R0.5	3.5	16	50	4	
2COR 025 005 200	2.5 X R0.5	3.5	20	50	4	
2COR 025 005 250	2.5 X R0.5	3.5	25	60	4	
2COR 030 001 100	3 X R0.1	4	10	55	6	
2COR 030 001 120	3 X R0.1	4	12	55	6	
2COR 030 001 160	3 X R0.1	4	16	55	6	
2COR 030 001 200	3 X R0.1	4	20	60	6	
2COR 030 001 250	3 X R0.1	4	25	65	6	
2COR 030 001 300	3 X R0.1	4	30	70	6	

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단위: mm

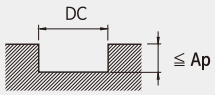
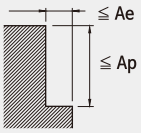
Order Number	날경 Diameter D×R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	생크 Shank Dia d	비고
2COR 030 001 350	3 X R0.1	4	35	75	6	
2COR 030 001 400	3 X R0.1	4	40	80	6	
2COR 030 002 100	3 X R0.2	4	10	55	6	
2COR 030 002 120	3 X R0.2	4	12	55	6	
2COR 030 002 160	3 X R0.2	4	16	55	6	
2COR 030 002 200	3 X R0.2	4	20	60	6	
2COR 030 002 250	3 X R0.2	4	25	65	6	
2COR 030 002 300	3 X R0.2	4	30	70	6	
2COR 030 002 350	3 X R0.2	4	35	75	6	
2COR 030 002 400	3 X R0.2	4	40	80	6	
2COR 030 003 100	3 X R0.3	4	10	55	6	
2COR 030 003 120	3 X R0.3	4	12	55	6	
2COR 030 003 160	3 X R0.3	4	16	55	6	
2COR 030 003 200	3 X R0.3	4	20	60	6	
2COR 030 003 250	3 X R0.3	4	25	65	6	
2COR 030 003 300	3 X R0.3	4	30	70	6	
2COR 030 003 350	3 X R0.3	4	35	75	6	
2COR 030 003 400	3 X R0.3	4	40	80	6	
2COR 030 005 100	3 X R0.5	4	10	55	6	
2COR 030 005 120	3 X R0.5	4	12	55	6	
2COR 030 005 160	3 X R0.5	4	16	55	6	
2COR 030 005 200	3 X R0.5	4	20	60	6	
2COR 030 005 250	3 X R0.5	4	25	65	6	
2COR 030 005 300	3 X R0.5	4	30	70	6	
2COR 030 005 350	3 X R0.5	4	35	75	6	
2COR 030 005 400	3 X R0.5	4	40	80	6	
2COR 030 010 100	3 X R1	4	10	55	6	
2COR 030 010 120	3 X R1	4	12	55	6	
2COR 030 010 160	3 X R1	4	16	55	6	
2COR 030 010 200	3 X R1	4	20	60	6	
2COR 030 010 250	3 X R1	4	25	65	6	
2COR 030 010 300	3 X R1	4	30	70	6	
2COR 030 010 350	3 X R1	4	35	75	6	
2COR 030 010 400	3 X R1	4	40	80	6	
2COR 040 001 120	4 X R0.1	5	12	55	6	
2COR 040 001 160	4 X R0.1	5	16	55	6	
2COR 040 001 200	4 X R0.1	5	20	60	6	
2COR 040 001 300	4 X R0.1	5	30	70	6	
2COR 040 001 400	4 X R0.1	5	40	80	6	
2COR 040 002 120	4 X R0.2	5	12	55	6	
2COR 040 002 160	4 X R0.2	5	16	55	6	
2COR 040 002 200	4 X R0.2	5	20	60	6	
2COR 040 002 300	4 X R0.2	5	30	70	6	
2COR 040 002 400	4 X R0.2	5	40	80	6	
2COR 040 003 120	4 X R0.3	5	12	55	6	
2COR 040 003 160	4 X R0.3	5	16	55	6	
2COR 040 003 200	4 X R0.3	5	20	60	6	
2COR 040 003 300	4 X R0.3	5	30	70	6	
2COR 040 003 400	4 X R0.3	5	40	80	6	
2COR 040 005 120	4 X R0.5	5	12	55	6	

Order Number	날경 Diameter D×R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	생크 Shank Dia d	비고
2COR 040 005 160	4 X R0.5	5	16	55	6	
2COR 040 005 200	4 X R0.5	5	20	60	6	
2COR 040 005 300	4 X R0.5	5	30	70	6	
2COR 040 005 400	4 X R0.5	5	40	80	6	
2COR 040 010 120	4 X R1	5	12	55	6	
2COR 040 010 160	4 X R1	5	16	55	6	
2COR 040 010 200	4 X R1	5	20	60	6	
2COR 040 010 300	4 X R1	5	30	70	6	
2COR 040 010 400	4 X R1	5	40	80	6	
2COR 060 001 200	6 X R0.1	7	20	60	6	
2COR 060 002 200	6 X R0.2	7	20	60	6	
2COR 060 003 200	6 X R0.3	7	20	60	6	
2COR 060 005 200	6 X R0.5	7	20	60	6	
2COR 060 010 200	6 X R1	7	20	60	6	
2COR 060 015 200	6 X R1.5	7	20	60	6	
2COR 080 005 250	8 X R0.5	9	25	65	8	
2COR 080 010 250	8 X R1	9	25	65	8	
2COR 080 015 250	8 X R1.5	9	25	65	8	
2COR 100 005 320	10 X R0.5	11	32	70	10	
2COR 100 010 320	10 X R1	11	32	70	10	
2COR 100 015 320	10 X R1.5	11	32	70	10	
2COR 120 005 380	12 X R0.5	12	38	80	12	
2COR 120 010 380	12 X R1	12	38	80	12	
2COR 120 015 380	12 X R1.5	12	38	80	12	

FOR COPPER

2COR / 3COR Cutting Condition

• RPM : rev./min • Feed : mm/min

			홈절삭 Slotting				측면절삭 Side Cutting			
피삭재 Material			동/ 동합금 Copper / Copper Alloys				동/ 동합금 Copper / Copper Alloys			
외경 Outside Diameter	반경 Corner Radius	유효장 Effective Length	RPM	FEED	Ap Axial Depth	Ap Radial Depth	RPM	FEED	Ap Axial Depth	Ap Radial Depth
ø 1	R0.1, R0.2	3	45,000	2,500	0.036	1	45,000	4,500	0.036	0.2
〃	〃	6	40,000	2,000	0.03	1	40,000	3,000	0.03	0.2
〃	〃	10	35,000	1,600	0.025	1	35,000	2,000	0.025	0.2
ø 1.5	R0.1, R0.2	5	23,000	1,800	0.08	1.5	50,000	6,000	0.08	0.3
〃	〃	8	26,000	1,600	0.06	1.5	45,000	5,500	0.06	0.3
〃	〃	12	30,000	1,500	0.05	1.5	40,000	4,500	0.04	0.3
ø 2	R0.1, R0.2	6	35,000	1,800	0.14	2	45,000	5,000	0.12	0.8
〃	〃	10	30,000	1,600	0.12	2	40,000	4,700	0.1	0.6
〃	〃	14	30,000	1,200	0.08	2	30,000	3,800	0.06	0.4
ø 3	R0.2, R0.3	10	30,000	2,200	0.14	3	40,000	6,500	0.12	1
〃	〃	16	20,000	2,000	0.12	3	35,000	6,000	0.1	0.6
〃	〃	20	20,000	2,000	0.12	3	35,000	6,000	0.1	0.6
〃	R0.5	10	20,000	2,600	0.14	3	38,000	10,000	0.12	0.8
〃	〃	16	20,000	2,200	0.12	3	35,000	8,000	0.1	0.6
〃	〃	20	20,000	2,200	0.12	3	35,000	8,000	0.1	0.6
ø 4	R0.2, R0.3	12	20,000	2,600	0.5	4	40,000	8,000	0.18	0.12
〃	〃	16	15,000	2,400	0.3	4	32,000	5,000	0.16	0.1
〃	〃	20	15,000	2,000	0.25	4	32,000	5,000	0.15	0.8
〃	R0.5	12	20,000	2,400	0.5	4	35,000	10,000	0.3	0.1
〃	〃	16	15,000	2,200	0.25	4	32,000	7,000	0.15	0.8
〃	〃	20	15,000	2,200	0.25	4	32,000	7,000	0.15	0.8
절입량 Depth of Cut										

- 상기 조건은 V/C 100, Fz 0.03 기준이며, 실 가공시 가공 목적, 적용 기계에 따라 조건변경 요망 합니다.
- 조건표가 기계의 최대 스핀들 속도를 초과할시 스핀들 속도와 이송 속도를 비례적으로 조정 하십시오.
- 에어브로, 절삭유, 오일 미스트 쿨런트를 추천하며, 칩을 잘 제거하고 가공시의 발열과 발화에 주의 하십시오

- Above the parameters are based on V/C 100 with Fz 0.03. Actual machining can be changed depending on your machining purpose and condition of your machine.
- If the table over the maximum RPM and feed of your machine, or found red heat on the material, adjust RPM and feed in the same proportion.
- Air blow or mist coolants are recommended and note for chip emission, heat, or ignition.

Your specials are our standards.

당신의스페셜은우리의표준품입니다.

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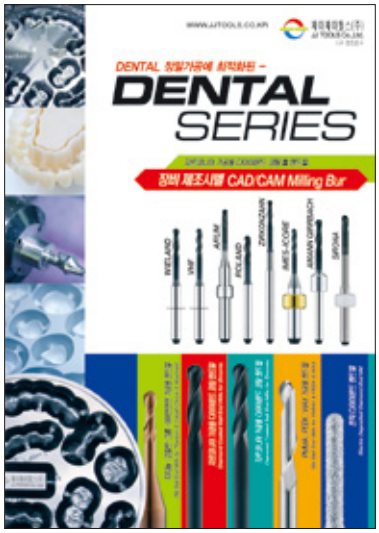

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ISO 9001 ISO 14001

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