

ECO PLUS

KSUF Series

General Use Endmill



General Engineering



Mold&Die



Automotive



Finish



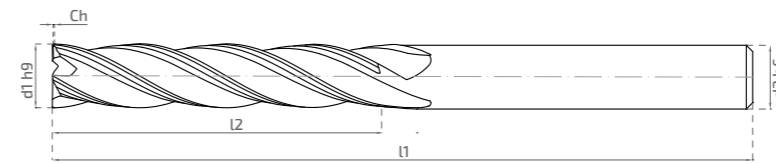
Rough

Brand-New Original Geometry, Unique Edge-Preparation, And Advanced Coating Technology,

Unrivalled To Machine Workpieces Till 55HRC Hardness In Price-Performance Ratio.

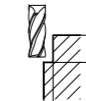
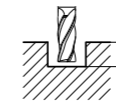
new *product*

www.karcan.com



Stock	Code	d1h9	d2h6	l1	l2	Ch
*	KSUF401550	1,5	4	50	9	-
*	KSUF402050	2	4	50	12	-
*	KSUF403050	3	3	50	15	0,1
*	KSUF403075	3	3	75	15	0,1
*	KSUF404075	4	4	75	20	0,1
*	KSUF404100	4	4	100	25	0,1
*	KSUF405075	5	5	75	20	0,1
*	KSUF406075	6	6	75	25	0,1
*	KSUF406100	6	6	100	30	0,1
*	KSUF408100	8	8	100	35	0,1
*	KSUF410110	10	10	110	40	0,1
*	KSUF412110	12	12	110	45	0,15
*	KSUF412150	12	12	150	60	0,15
*	KSUF414150	14	14	150	60	0,15
*	KSUF416150	16	16	150	75	0,15
*	KSUF418150	18	18	150	75	0,15
*	KSUF420150	20	20	150	75	0,15

Material	Cutting Parameters		
	Slotting ap=0.5 - 0.10 Vc (m/min)	Shoulder Milling ap=1.50 / ae=0.30 - 0.200 Vc (m/min)	Finish Milling ap=1.50 / ae=0.20 - 0.100 Vc (m/min)



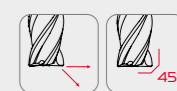
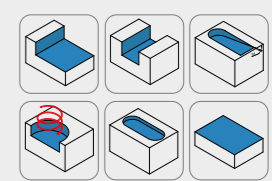
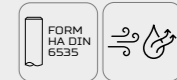
	Cutting Parameters			
	Slotting ap=0.5 - 0.10 Vc (m/min)	Shoulder Milling ap=1.50 / ae=0.30 - 0.200 Vc (m/min)	Finish Milling ap=1.50 / ae=0.20 - 0.100 Vc (m/min)	
Steel	Unalloyed Steel	95-125	180-210	210-230
	Steel	90-120	180-210	210-230
	Tempered Steel	80-110	160-190	190-120
	Cold Work Tool Steel	70-90	150-180	170-200
	Hot Work Tool Steel	60-80	140-170	160-190
Cast Iron	Gray Cast Iron	100-130	250-280	280-330
	Alloyed Cast Iron	70-100	150-190	190-240
	Precision Cast Iron	60-90	130-160	160-210

	Feed Per Tooth (mm/tooth)					
	ap=0.0500	ae=0.100	ae=0.300	ae=0.200	ae=0.150	ae=0.100
0						
3	0.005	0.006	0.031	0.036	0.038	0.040
4	0.008	0.011	0.038	0.042	0.044	0.046
5	0.013	0.017	0.041	0.043	0.045	0.047
6	0.016	0.022	0.048	0.052	0.054	0.056
8	0.021	0.027	0.054	0.058	0.061	0.064
10	0.029	0.035	0.062	0.066	0.069	0.072
12	0.038	0.043	0.067	0.072	0.075	0.079
14	0.047	0.052	0.072	0.077	0.080	0.083
16	0.056	0.063	0.076	0.081	0.086	0.090
18	0.068	0.073	0.079	0.085	0.089	0.095
20	0.078	0.084	0.084	0.092	0.097	0.098

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KSUF
General Use Endmill



≤ 55 HRC + TiSiN



Steel	●
Stainless Steel	○
Hardened Steel ≤54 HRC	○
Hardened Steel >54 HRC	○
Cast Iron	●
Graphite	○
Non Ferrous Material	○
HRSA	○
Titanium	○

● Recommended ○ Acceptable ○ Not Recommended

* Marked products can be delivered quickly from stock.

