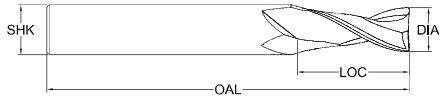
J2EXEN / J4EXEN (ECO-Extra)

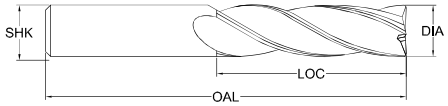
Work Materials

P	M	K
■	□	□

SOLID CARBIDE 2 / 4-FLUTE SQUARE END MILL

2/4刃钨钢平端铣刀





FEATURES:

- ECONOMICAL TYPE -
  For general machining of work materials up to 45 HRc.

J SERIES - Standard Length					
PRODUCT CODE		DIA	LOC	OAL	SHK
2-Flute	4-Flute				
J2EXEN 030C	**J4EXEN 030C**	**3.0**	9	50	4
J2EXEN 040C	**J4EXEN 040C**	**4.0**	12	50	4
J2EXEN 050C	**J4EXEN 050C**	**5.0**	15	50	5
J2EXEN 060C	**J4EXEN 060C**	**6.0**	18	50	6
J2EXEN 080C	**J4EXEN 080C**	**8.0**	24	60	8
J2EXEN 100C	**J4EXEN 100C**	**10.0**	30	75	10
J2EXEN 120C	**J4EXEN 120C**	**12.0**	36	75	12
J2EXEN 140C	**J4EXEN 140C**	**14.0**	42	100	14
J2EXEN 160C	**J4EXEN 160C**	**16.0**	48	100	16
J2EXEN 180C	**J4EXEN 180C**	**18.0**	50	100	18
J2EXEN 200C	**J4EXEN 200C**	**20.0**	50	100	20

Note: Length of Cut (LOC) = 3 x Tool Diameter

Note: All stocks come standard with C-Coat for extended tool life

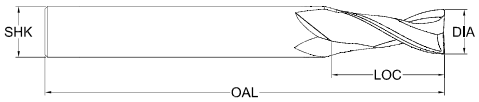
J2EXLS / J4EXLS (ECO-Extra)

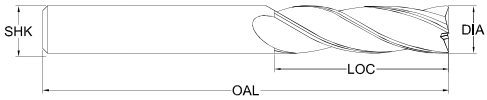
Work Materials

P	M	K
■	□	□

SOLID CARBIDE 2 / 4-FLUTE LONG SHANK SQUARE END MILL

2/4刃钨钢长柄平端铣刀



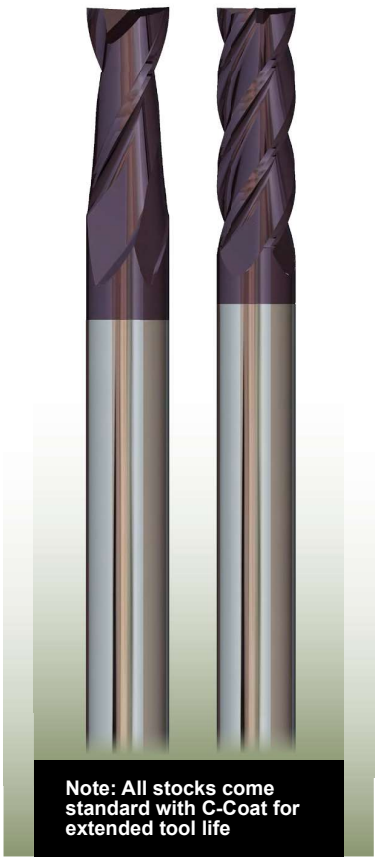


FEATURES:

- ECONOMICAL TYPE -
  For general machining of work materials up to 45 HRc.

J SERIES - Long Shank					
PRODUCT CODE		DIA	LOC	OAL	SHK
2-Flute	4-Flute				
J2EXLS 040C	J4EXLS 040C	4.0	12	75	4
J2EXLS 060C	J4EXLS 060C	6.0	18	75	6
J2EXLS 080C	J4EXLS 080C	8.0	24	100	8
J2EXLS 100C	J4EXLS 100C	10.0	30	100	10
J2EXLS 120C	J4EXLS 120C	12.0	36	100	12
J2EXLS 140C	J4EXLS 140C	14.0	42	150	14
J2EXLS 160C	J4EXLS 160C	16.0	48	150	16
J2EXLS 180C	J4EXLS 180C	18.0	50	150	18

Note: Length of Cut (LOC) = 3 x Tool Diameter



Note: All stocks come standard with C-Coat for extended tool life

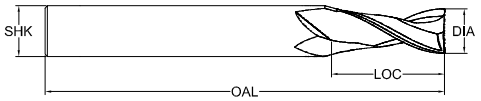
J2EXTLS / J4EXTLS (ECO-Extra)

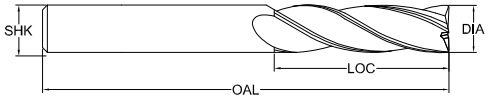
Work Materials

P	M	K
■	□	□

SOLID CARBIDE 2 / 4-FLUTE EXTRA LONG SHANK SQUARE END MILL

2/4刃钨钢特长柄平端铣刀





FEATURES:

- ECONOMICAL TYPE -
  For general machining of work materials up to 45 HRc.

J SERIES – Extra Long Shank					
PRODUCT CODE		DIA	LOC	OAL	SHK
2-Flute	4-Flute				
J2EXTLS 040C	**J4EXTLS 040C**	**4.0**	12	100	4
J2EXTLS 060C	**J4EXTLS 060C**	**6.0**	18	100	6
J2EXTLS 080C	**J4EXTLS 080C**	**8.0**	24	150	8
J2EXTLS 100C	**J4EXTLS 100C**	**10.0**	30	150	10
J2EXTLS 120C	**J4EXTLS 120C**	**12.0**	36	150	12

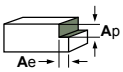
Note: Length of Cut (LOC) = 3 x Tool Diameter

Note: All stocks come standard with C-Coat for extended tool life

Operating Parameters For J-Series

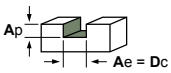
J2EXEN

SIDE MILLING 侧面切削



ISO WORK MATERIAL CODE	P K	Carbon Steel & Cast Iron (~25HRC)		P	Alloy Steel (~30HRC)		P	Prehardened Steel (30~38HRC)		P	Prehardened Steel (38~45HRC)	
Dc (mm)		n (min^{-1})	Vf (mm/min)		n (min^{-1})	Vf (mm/min)		n (min^{-1})	Vf (mm/min)		n (min^{-1})	Vf (mm/min)
3.0		5880	85		4760	75		3640	55		2940	40
4.0		4760	110		3780	85		2940	65		2380	45
5.0		4060	135		3220	110		2520	80		2100	55
6.0		3500	160		2800	135		2100	100		1820	65
8.0		2660	175		2100	135		1680	120		1400	65
10.0		2240	175		1820	135		1330	105		1120	65
12.0		1820	135		1540	120		1120	80		935	55
14.0		1680	125		1330	100		980	75		810	45
16.0		1400	110		1145	85		840	65		700	40
18.0		1260	95		980	80		770	55		585	35
20.0		1120	85		910	65		670	55		560	35
Radial DOC, Ae		≤ 0.05 x **Dc** (max 0.5 mm)									≤ 0.02 x **Dc** (max 0.3 mm)	
Axial DOC, Ap		≤ 2.5 x **Dc**									≤ 2.0 x **Dc**	

SLOT MILLING 槽切削



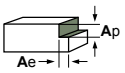
3.0	4100	80	4620	70	3500	50	2940	35
4.0	3200	105	3640	80	2800	60	2380	40
5.0	2800	125	3080	100	2380	75	2100	50
6.0	2400	150	2660	125	1960	95	1820	60
8.0	1800	160	2030	125	1540	110	1400	60
10.0	1500	160	1680	125	1260	95	1120	60
12.0	1200	125	1400	110	1050	75	935	50
14.0	1100	120	1260	95	910	65	810	40
16.0	950	100	1090	80	770	60	700	35
18.0	820	90	910	75	700	50	585	25
20.0	760	80	795	60	630	50	560	25
Radial DOC, Ae	**Dc**						**Dc**	
Axial DOC, Ap	≤ 0.3 x **Dc** (Max 0.3 mm)						≤ 0.05 x **Dc** (max 0.5mm)	

Note: For Long Shank Series **(J2EXLS & J2EXTLS)** , reduce both spindle speed by 30% and feedrate by 40% accordingly due to the tool overhang extension length.

Dc = Cutter Diameter (mm) 切削直径
n = Spindle Speed (mm^{-1}) 转速
Vf = Feed Rate (mm/min) 进给速
Ap = Depth of cut (mm) 切削深度
Ae = Width of Cut (mm) 切削宽度

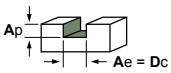
J4EXEN

SIDE MILLING 侧面切削



ISO WORK MATERIAL CODE	P K	Carbon Steel & Cast Iron (~25HRC)		P	Alloy Steel (~30HRC)		P	Prehardened Steel (30~38HRC)		P	Prehardened Steel (38~45HRC)	
Dc (mm)		n (min^{-1})	Vf (mm/min)		n (min^{-1})	Vf (mm/min)		n (min^{-1})	Vf (mm/min)		n (min^{-1})	Vf (mm/min)
3.0		5880	175		4760	150		3640	110		2940	80
4.0		4760	220		3780	175		2940	135		2380	95
5.0		4060	270		3220	220		2520	160		2100	110
6.0		3500	320		2800	270		2100	205		1820	135
8.0		2660	350		2100	270		1680	240		1400	135
10.0		2240	350		1820	270		1330	205		1120	135
12.0		1820	270		1540	240		1120	160		935	110
14.0		1680	250		1330	200		980	145		810	95
16.0		1400	220		1145	175		840	125		700	80
18.0		1260	190		980	160		770	110		585	65
20.0		1120	170		910	135		670	110		560	65
Radial DOC, Ae		≤ 0.05 x **Dc** (max 0.5 mm)									≤ 0.02 x **Dc** (max 0.3 mm)	
Axial DOC, Ap		≤ 2.5 x **Dc**									≤ 2.0 x **Dc**	

SLOT MILLING 槽切削



3.0	4100	165	4620	145	3500	105	2940	70
4.0	3200	208	3640	165	2800	125	2380	85
5.0	2800	255	3080	205	2380	150	2100	105
6.0	2400	305	2660	255	1960	190	1820	125
8.0	1800	325	2030	255	1540	220	1400	125
10.0	1500	325	1680	255	1260	190	1120	125
12.0	1200	255	1400	225	1050	150	935	105
14.0	1100	240	1260	190	910	135	810	85
16.0	950	205	1090	160	770	120	700	70
18.0	820	185	910	150	700	105	585	55
20.0	760	165	795	125	630	105	560	55
Radial DOC, Ae	**Dc**						**Dc**	
Axial DOC, Ap	≤ 0.3 x **Dc** (Max 0.3 mm)						≤ 0.05 x **Dc** (max 0.5mm)	

Note: For Long Shank Series **(J4EXLS & J4EXTLS)** , reduce both spindle speed by 30% and feedrate by 40% accordingly due to the tool overhang extension length.

Dc = Cutter Diameter (mm) 切削直径
n = Spindle Speed (mm^{-1}) 转速
Vf = Feed Rate (mm/min) 进给速
Ap = Depth of cut (mm) 切削深度
Ae = Width of Cut (mm) 切削宽度