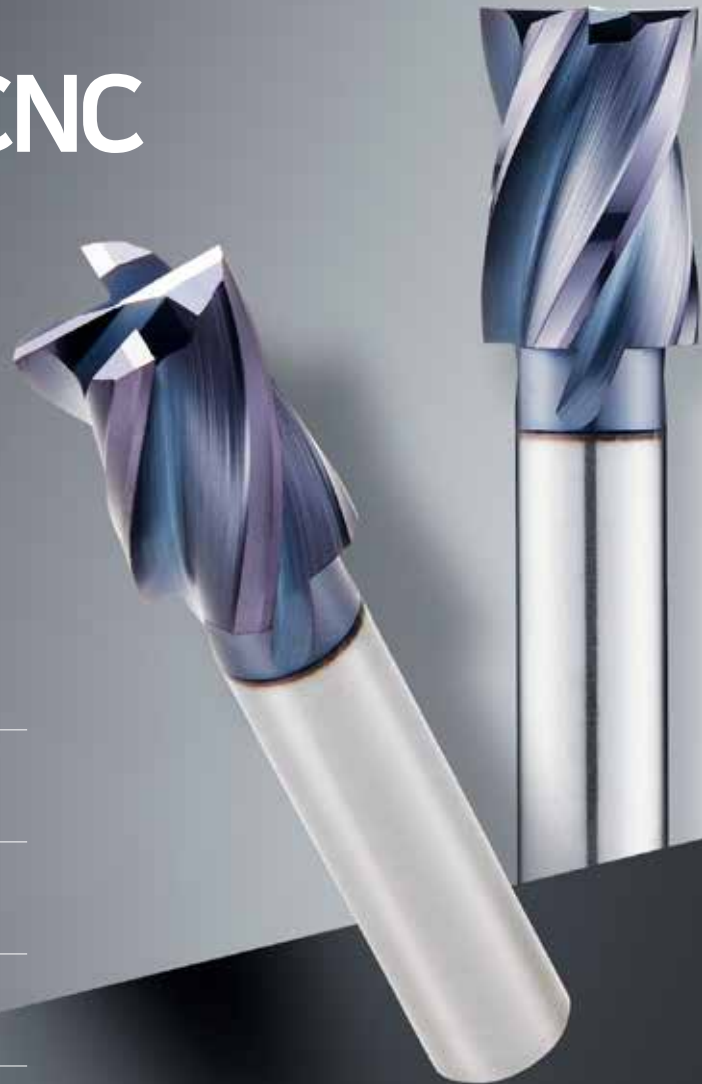




Automatic CNC Endmill ACE4



- ✓ Optimized Specification for Automatic CNC machining
Slim shank type
Special length for prevention of interruption

- ✓ Reduce cutting edge chipping with high toughness raw materials

- ✓ Superior toughness and wear resistance by AlTiN coating

- ✓ Suitable for up to HRC50 hardness material

RECOMMENDED CUTTING CONDITIONS

Workpiece	Non Alloy steels, Alloy steels, Cast Iron		Heat treated steels				Stainless steels	
	HRc30 ~ HRc40		HRc40 ~ HRc50		HRc50 ~ HRc55			
Tensile strength	~1000N/mm		1000 ~ 1500N/mm		1500 ~ 2000N/mm			
Diameter(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	12,100	320	7,900	195	2,700	47	6,600	160
3	9,400	370	5,840	230	2,000	58	4,850	195
4	7,900	655	4,850	405	1,500	58	4,070	320
5	6,600	690	3,970	415	1,300	58	3,320	345
6	5,830	760	3,530	470	1,150	58	2,980	380
8	4,410	815	2,650	435	880	58	2,200	405
10	3,420	700	2,100	345	720	46	1,760	345
12	2,880	600	1,760	290	590	46	1,430	275
16	2,310	470	1,430	230	460	29	1,150	230
20	1,760	370	1,110	185	340	29	880	175
25	1,430	290	880	150	270	23	715	140

※ Increase and reduce depending on the condition of the equipment, cutting oil, etc. (adjust within the first 15%)

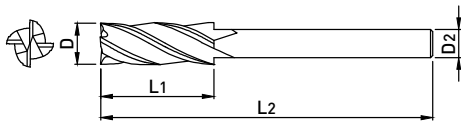
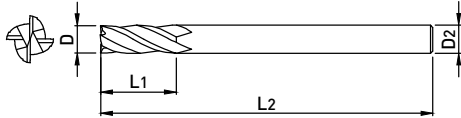
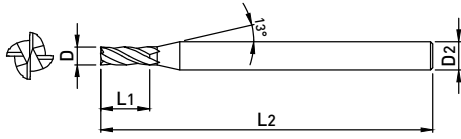
ACE4

4 FLUTES SQUARE ENDMILL



-Excellent Chip emission and General purpose with the suitable flute shape design for mid hardness steel

-Various specifications from Ø3 to Ø16



■ Tolerance

Diameter (D)		Shank Diameter
All size	0~-0.02mm	h6

EDP No.	Diameter	Flute length	Overall	Shank Diameter
	D	L1	L2	D2
ACE4030S04	3	3	35	4
ACE4040S04	4	4	35	4
ACE4060S06	6	6	35	6
ACE4070S07	7	20	45	7
ACE4080S06	8	8	35	6
ACE4080S08	8	8	45	8
ACE4080S07	8	15	45	7
ACE4090S07	9	15	45	7
ACE4100S06	10	10	35	6
ACE4100S07	10	15	45	7

EDP No.	Diameter	Flute length	Overall	Shank Diameter
	D	L1	L2	D2
ACE4100S10	10	15	45	10
ACE4110S07	11	15	45	7
ACE4120S06	12	12	35	6
ACE4120S10	12	12	45	10
ACE4120S07	12	15	45	7
ACE4120-25S10	12	25	55	10
ACE4130S10	13	25	55	10
ACE4140S07	14	25	55	7
ACE4140S10	14	25	55	10
ACE4160S10	16	25	60	10

■ EDP# System

A	C	E	4	030	S04
Automatic	CNC	Endmill	No. of Flute	Diameter D3	Shank Diameter D4

■ Application

Carbon steels ~HB225	Alloy steels HB225~325	pre-hardened Steels HRc30~50	Heat treated steels		Copper	Graphite	Cast Iron ~FCD500	Stainless steels	Aluminum
			SKD61~HRc55	SKD11~HRc55					
●	●	●			●		●		●

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