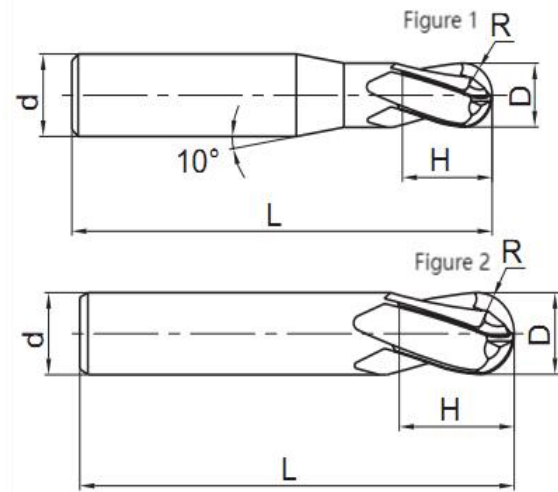
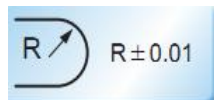
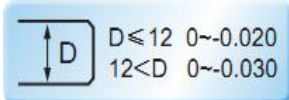
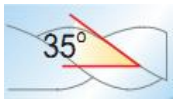


QCM2F							mm
Type Specification	Basic Size					Number of Flute	Figure
	D	R	d	H	L		
QCM2F-RO.5S	1.0	0.5	4	2.0	50	2	1
QCM2F-RO.75S	1.5	0.8	4	3.0	50	2	1
QCM2F-R1.0S	2.0	1.0	4	4.0	50	2	1
QCM2F-R1.25S	2.5	1.3	4	5.0	50	2	1
QCM2F-R1.5S	3.0	1.5	4	6.0	50	2	1
QCM2F-R2.0S	4.0	2.0	4	8.0	50	2	2
QCM2F-R0.5	1.0	0.5	6	2.0	50	2	1
QCM2F-R0.75	1.5	0.8	6	3.0	50	2	1
QCM2F-R1.0	2.0	1.0	6	4.0	50	2	1
QCM2F-R1.25	2.5	1.3	6	5.0	50	2	1
QCM2F-R1.5	3.0	1.5	6	6.0	50	2	1
QCM2F-R1.75	3.5	1.8	6	8.0	50	2	1
QCM2F-R2.0	4.0	2.0	6	8.0	50	2	1
QCM2F-R2.5	5.0	2.5	6	10.0	50	2	1
QCM2F-R2.75	5.5	2.8	6	12.0	50	2	1
QCM2F-R3.0	6.0	3.0	6	12.0	50	2	2
QCM2F-R3.5	7.0	3.5	8	14.0	60	2	1
QCM2F-R4.0	8.0	4.0	8	16.0	60	2	2
QCM2F-R4.5	9.0	4.5	10	18.0	75	2	1
QCM2F-R5.0	10.0	5.0	10	20.0	75	2	2
QCM2F-R6.0	12.0	6.0	12	24.0	75	2	2
QCM2F-R7.0	14.0	7.0	14	28.0	75	2	2
QCM2F-R8.0	16.0	8.0	16	32.0	100	2	2
QCM2F-R10.0	20.0	10.0	20	40.0	100	2	2

# The Cutting Parameters of QCM-2F

## QCM-2F Cutting conditions

Processed Material	Cast Iron/ Ductile Iron		Carbon Steel/ Alloy Steel (~750N/mm <sup>2</sup> )		Carbon Steel/ Alloy Steel (~30HRC)		Pre-hardened Steel/ Quenched and Tempered Steel (~40HRC)		Stainless Steel		Pre-hardened Steel/ Quenched and Tempered Steel (~50HRC)	
	Diameter (mm)	Rotational Speed (min <sup>-1</sup> )	Feed Speed (mm/min)	Rotational Speed (min <sup>-1</sup> )	Feed Speed (mm/min)	Rotational Speed (min <sup>-1</sup> )	Feed Speed (mm/min)	Rotational Speed (min <sup>-1</sup> )	Feed Speed (mm/min)	Rotational Speed (min <sup>-1</sup> )	Feed Speed (mm/min)	Rotational Speed (min <sup>-1</sup> )
R0.5	40000	800	40000	800	38000	700	32000	320	22300	200	25000	275
R1.0	24000	900	24000	900	19000	760	16000	400	11150	230	13000	275
R1.5	15500	950	15500	950	12750	760	10600	450	7400	290	8500	280
R2.0	11500	950	11500	950	9550	760	8000	550	5550	370	6500	370
R2.5	9500	1050	9500	1050	7650	800	6400	550	4450	370	5000	375
R3.0	8000	1050	8000	1050	6400	800	5300	580	3700	390	4200	390
R4.0	6000	1300	6000	1300	4800	950	4000	700	2750	455	3200	440
R5.0	4800	1200	4800	1200	3800	900	3200	650	2200	430	2500	440
R6.0	4000	1100	4000	1100	3200	840	2650	610	1850	430	2100	420
R8.0	3000	1050	3000	1050	2400	800	2000	600	1350	380	1600	375
R10.0	2000	950	2000	950	1900	680	1600	560	1100	370	1250	330



# QCM4F mm

Type Specification n	Basic Size(mm)					Number of Flutes	Figure
	D	R	d	H	L		
QCM4F-R1.5	3.0	1.5	6	6.0	50	4	1
QCM4F-R2.0	4.0	2.0	6	8.0	50	4	1
QCM4F-R2.5	5.0	2.5	6	10.0	50	4	1
QCM4F-R3.0	6.0	3.0	6	12.0	50	4	2
QCM4F-R4.0	8.0	4.0	8	16.0	60	4	2
QCM4F-R5.0	10.0	5.0	10	20.0	75	4	2
QCM4F-R6.0	12.0	6.0	12	24.0	75	4	2
QCM4F-R7.0	14.0	7.0	14	28.0	75	4	2
QCM4F-R8.0	16.0	8.0	16	32.0	100	4	2
QCM4F-R9.0	18.0	9.0	18	36.0	100	4	2
QCM4F-R10.0	20.0	10.0	20	40.0	100	4	2

# The Cutting Parameters of QCM-4F

## QCM-4F Cutting Conditions

Processed Material	Cast Iron/ Ductile Iron		Carbon Steel/ Alloy Steel (~750N/mm <sup>2</sup> )		Carbon Steel/ Alloy Steel (~30HRC)		Pre-hardened Steel/ Quenched and Tempered Steel (~40HRC)		Stainless Steel		Pre-hardened Steel/ Quenched and Tempered Steel (~50HRC)	
Cutting Speed (m/min)	150m/min		150m/min		120m/min		100m/min		70m/min		80m/min	
Diameter(mm)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)
R1.5	15500	1710	15500	1710	12750	1340	10600	810	7400	520	8500	500
R2.0	11500	1710	11500	1710	9550	1340	8000	990	5550	660	6500	665
R2.5	9500	1890	9500	1890	7650	1440	6400	990	4450	660	5000	675
R3.0	8000	1890	8000	1890	6400	1440	5300	1040	3700	700	4200	700
R4.0	6000	2340	6000	2340	4800	1710	4000	1260	2750	820	3200	790
R5.0	4800	2160	4800	2160	3800	1620	3200	1170	2200	770	2500	790
R6.0	4000	1980	4000	1980	3200	1510	2650	1100	1850	770	2100	755
R8.0	3000	1890	3000	1890	2400	1440	2000	1080	1350	680	1600	675
R10.0	2400	1710	2400	1710	1900	1220	1000	1000	1100	680	1250	595