



Application & Accessory Guide

Product No.: 2387-2004

Cutting Parameters

Cutting Speed

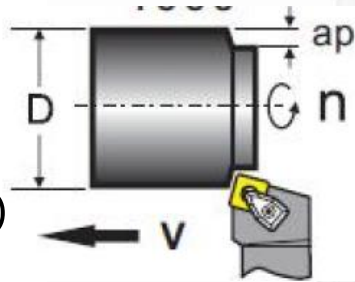
$$V = \frac{\pi \times D \times n}{1000} \text{ (in/min)}$$

- *V: Cutting Speed
- *D: Cutting Diameter
- *n: Number of Revolutions

Feed Speed

$$f = \frac{F}{n}$$

- f: Quantity per revolution
- F: Quantity per Min
- n: Number of Revolutions



Cutting depth

Ap: 0.012~0.08


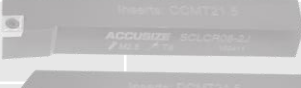





Material

Feed speed

0.003~0.012 in

SCLCR08-2J	Low-Carbon steel	55~70 in/min
SCLCL08-2J	Medium-Carbon steel	39~51 in/min
SDJCR08-2J	Alloy Steel	31~43 in/min
SDNCN08-2J	Tool Steel	35~47 in/min
SWGCR08-2J	Low-Carbon steel	39~70 in/min
SER0500J11	Medium-Carbon steel	31~63 in/min
	High-Carbon Steel	23~55 in/min
	Alloy Steel	27~62 in/min
MGEHR08-2J	Alloy Steel	23~43 in/min
	Low-Carbon steel	31~59 in/min
	Carbon steel≤HB200	39~78 in/min
Width	Carbon steel≥HB200	39~59 in/min
0.079"		

Accessories

Code of Cutter	Shank	Insert Code	Item No. of Inserts (Cutting Steel)		Item No of Inserts (Cutting Aluminum)
SCLCR08-2J	1/2 × 1/2	CCMT21.5	2200-1008		2000-1008
SCLCL08-2J	1/2 × 1/2	CCMT21.5	2200-1008		2000-1008
SDJCR08-2J	1/2 × 1/2	DCMT21.5	2104-1010		2004-1010
SDNCN08-2J	1/2 × 1/2	DCMT21.5	2104-1010		2004-1010
SWGCR08-2J	1/2 × 1/2	WCMT2.52	2139-1020		2039-1020
SER0500J11	1/2 × 1/2	11ER	2652-0015		2600-0015
MGEHR08-2J	1/2 × 1/2	MGMN200	2403-4022		2403-4023