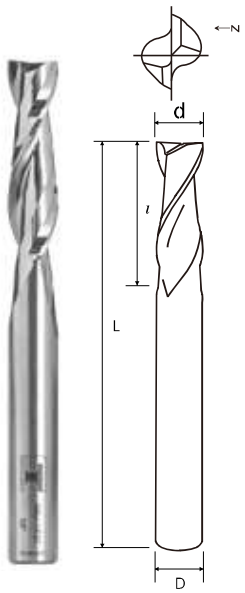
ISEU

Up Cut - 2 Flutes

Cutting Condition P53-54



FRACTIONAL

MODE	Diameter	Flute Length	Full Length	Shank Diameter	Flutes
	d	*l*	L	D	Z
ISEU1/8"2	1/8	1/2	2	1/8	2
ISEU1/4"2	1/4	1	2-1/2	1/4	2
ISEU3/8"2	3/8	1	2-1/2	3/8	2
ISEU1/2"2	1/2	1-1/4	3	1/2	2

Unit:inch



Up Cut

Sends them up to ward the shank.

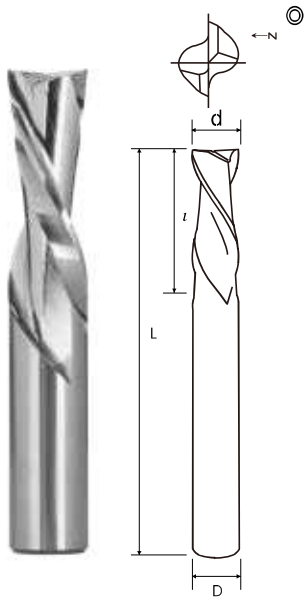
◎ : Excellent ○ : Good

P				H	M	K	S		N			
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hard-ened Steels	Stainless Steels	Cast Iron	Titanium	High Temperature Alloy	Copper	Aluminum	Wood	Plastic
~HB225	HB225~325	HRC30~	HRC40~45	HRC55~70								
									○	○	◎	◎

ISED

Down Cut - 2 Flutes

Cutting Condition P53-54



FRACTIONAL

MODE	Diameter	Flute Length	Full Length	Shank Diameter	Flutes
	d	*l*	L	D	Z
ISED1/8"2	1/8	1/2	2	1/8	2
ISED1/4"2	1/4	1	2-1/2	1/4	2
ISED3/8"2	3/8	1	2-1/2	3/8	2
ISED1/2"2	1/2	1-1/4	3	1/2	2

Unit:inch



Down Cut

Cause the chip flow to be directed downward.

◎ : Excellent ○ : Good

P				H	M	K	S		N			
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hard-ened Steels	Stainless Steels	Cast Iron	Titanium	High Temperature Alloy	Copper	Aluminum	Wood	Plastic
~HB225	HB225~325	HRC30~	HRC40~45	HRC55~70								
									○	○	◎	◎

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