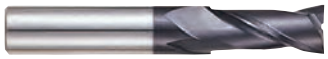
MEFCS2

cylindrical shank, 2 flutes

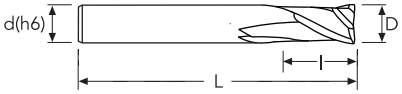
OSAWA NORM | VA | UMG ENDLESS | <45 HRC | 35° | SQUARE | Z2



P	M	K	N	S	H
★	★			★	

★ 1st choice ☆ suitable

SLOTTING | SIDE MILLING | DRILLING



D	D Tol.	C	C Tol.	d(h6)	l	l1	L	z	EDP No.	Stock
1	0/-0.030			4	2.5		40	2	MEFCS2010	●
1.5	0/-0.030			4	4		40	2	MEFCS2015	●
2	0/-0.030			4	6		40	2	MEFCS2020	●
2.5	0/-0.030			4	8		40	2	MEFCS2025	●
3	0/-0.030			6	8		45	2	MEFCS2030	●
4	0/-0.030			6	11		45	2	MEFCS2040	●
5	0/-0.030			6	13		50	2	MEFCS2050	●
6	0/-0.030			6	13		50	2	MEFCS2060	●
8	0/-0.030			8	19		60	2	MEFCS2080	●
10	0/-0.030			10	22		70	2	MEFCS2100	●
12	0/-0.030			12	26		75	2	MEFCS2120	●
14	0/-0.030			14	26		85	2	MEFCS2140	●
16	0/-0.030			16	32		100	2	MEFCS2160	●

● stock standard ○ non-stock standard ▽ stock exhaustion

MEFCS2

Material Group ISO 513	P1 P2 P3			P4 M1 M2			P5 M3 M4 S1 S2 S4			M5 S3 S5		
Hardness/Rm	< 700 N/mm²			700-1000 N/mm²			< 35 HRC			< 45 HRC		
ap x ae	**0.5D x D**			**0.5D x D**			**0.3D x D**			**0.2D x D**		
Vc (m/min)	**90-110**			**50-70**			**30-50**			**20-40**		
D (mm)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)
1	31850	0.005	290	19110	0.004	150	12740	0.004	90	9550	0.004	70
2	15920	0.009	290	9550	0.008	150	6370	0.007	90	4780	0.007	70
3	10620	0.012	240	6370	0.010	120	4250	0.009	80	3180	0.009	60
4	7960	0.017	270	4780	0.015	140	3180	0.014	90	2390	0.014	70
5	6370	0.023	290	3820	0.020	150	2550	0.018	90	1910	0.018	70
6	5310	0.029	310	3180	0.024	160	2120	0.023	100	1590	0.023	70
8	3980	0.035	270	2390	0.029	140	1590	0.028	90	1190	0.028	70
10	3180	0.040	260	1910	0.034	130	1270	0.032	80	960	0.032	60
12	2650	0.046	240	1590	0.039	120	1060	0.037	80	800	0.037	60
14	2270	0.052	230	1360	0.044	120	910	0.041	80	680	0.041	60
16	1990	0.058	230	1190	0.049	120	800	0.046	70	600	0.046	60

< D3 mm: ap = 0.1D - 0.2D

Material Group ISO 513	P1 P2 P3			P4 M1 M2			P5 M3 M4 S1 S2 S4			M5 S3 S5		
Hardness/Rm	< 700 N/mm²			700-1000 N/mm²			< 35 HRC			< 45 HRC		
ap x ae	**1.5D x 0.5D**			**1.5D x 0.5D**			**D x 0.3D**			**D x 0.1D**		
Vc (m/min)	**90-110**			**60-80**			**40-60**			**30-50**		
D (mm)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)
1	31850	0.006	350	22290	0.005	210	15920	0.004	140	12740	0.004	110
2	15920	0.011	350	11150	0.009	210	7960	0.009	140	6370	0.009	110
3	10620	0.014	290	7430	0.012	170	5310	0.011	120	4250	0.011	90
4	7960	0.021	330	5570	0.018	200	3980	0.017	130	3180	0.017	110
5	6370	0.028	350	4460	0.023	210	3180	0.022	140	2550	0.022	110
6	5310	0.035	370	3720	0.029	220	2650	0.028	150	2120	0.028	120
8	3980	0.041	330	2790	0.035	200	1990	0.033	130	1590	0.033	110
10	3180	0.048	310	2230	0.041	180	1590	0.039	120	1270	0.039	100
12	2650	0.055	290	1860	0.047	170	1330	0.044	120	1060	0.044	90
14	2270	0.062	280	1590	0.053	170	1140	0.050	110	910	0.050	90
16	1990	0.069	270	1390	0.059	160	1000	0.055	110	800	0.055	90

< D3 mm: ae = 0.05D - 0.2D

Material Group ISO 513	P1 P2 P3			P4 M1 M2			P5 M3 M4 S1 S2 S4			M5 S3 S5		
Hardness/Rm	< 700 N/mm²			700-1000 N/mm²			< 35 HRC			< 45 HRC		
ap x ae	**D x D**			**D x D**			**0.5D x D**			**0.2D x D**		
Vc (m/min)	**90-110**			**50-70**			**30-50**			**20-40**		
D (mm)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)
1	31850	0.003	180	19110	0.002	90	12740	0.002	60	9550	0.022	420
2	15920	0.006	180	9550	0.005	90	6370	0.004	60	4780	0.044	420
3	10620	0.007	150	6370	0.006	70	4250	0.006	50	3180	0.055	350
4	7960	0.010	160	4780	0.009	80	3180	0.008	50	2390	0.083	400
5	6370	0.014	180	3820	0.012	90	2550	0.011	60	1910	0.110	420
6	5310	0.017	180	3180	0.015	90	2120	0.014	60	1590	0.138	440
8	3980	0.021	160	2390	0.018	80	1590	0.017	50	1190	0.166	390
10	3180	0.024	150	1910	0.021	80	1270	0.019	50	960	0.193	370
12	2650	0.028	150	1590	0.023	70	1060	0.022	50	800	0.221	350
14	2270	0.031	140	1360	0.026	70	910	0.025	50	680	0.248	340
16	1990	0.035	140	1190	0.029	70	800	0.028	40	600	0.276	330

< D3 mm: ap = 0.1D - 0.2D