



MG

DLC
Coating

30

SD
0-0.003R
±0.005R
±0.007

R≤3

R4~10

Highly recommend ★ ○ ○
/Recommend/Suggest

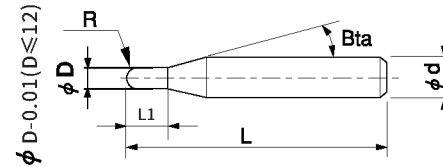
DIE STEEL	Grade
Carbon steels (S45C/S55C)	
Alloy steels (SK/SCM/SUS)	
Prehardened steels (NAK/HPM)	
Hardened steels (~55/~60/~70HRC)	
SPECIAL MATERIAL	
Aluminum alloys	○
Graphite	
Copper	★
Plastics	○
Carbon fiber	
Titanium alloys	
Heat resistant alloys	
Cemented carbide	
Hard brittle (non-metallic) material	

Specialty

* Special geometry design, sharp cutting edge, highly efficient milling and chip evacuation;

* The coating, with good thermal stability, makes it maintain the hardness and mechanical properties under high temperature;

* Lower coefficient of friction reduces wear during cutting and provides better surface quality;



Total 31 models

Unit (mm)

Model Number	D Outside Diameter	L1 Length Of Cut	BTa Shank Taper Angle	L Overall Length	T Number Of Flutes	d Shank Diameter	In Stock
SHDR2-002002	R0.1	0.2	12°	50	2	4	○
SHDR2-003003	R0.15	0.3	12°	50	2	4	○
SHDR2-004006	R0.2	0.6	12°	50	2	4	○
SHDR2-005008	R0.25	0.8	12°	50	2	4	○
SHDR2-006009	R0.3	0.9	12°	50	2	4	○
SHDR2-008012	R0.4	1.2	12°	50	2	4	○
SHDR2-010015	R0.5	1.5	12°	50	2	4	○
SHDR2-012018	R0.6	1.8	12°	50	2	4	○
SHDR2-015023	R0.75	2.3	12°	50	2	4	○
SHDR2-020030	R1	3	12°	50	2	4	○
SHDR2-030045-3	R1.5	4.5	-	50	2	3	○
SHDR2-030045-4	R1.5	4.5	12°	50	2	4	○
SHDR2-030045-6	R1.5	4.5	12°	50	2	6	○
SHDR2-040060	R2	6	-	50	2	4	○
SHDR2-040060-75	R2	6	-	75	2	4	○
SHDR2-040060-100	R2	6	-	100	2	4	○
SHDR2-040060-6	R2	6	12°	50	2	6	○
SHDR2-050075	R2.5	7.5	12°	50	2	6	○
SHDR2-060090	R3	9	-	50	2	6	○
SHDR2-060090-75	R3	9	-	75	2	6	○

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Total 31 models

Unit (mm)

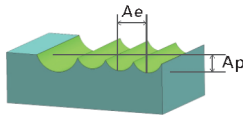
Model Number	D Outside Diameter	L1 Length Of Cut	BTa Shank Taper Angle	L Overall Length	T Number Of Flutes	d Shank Diameter	In Stock
SHDR2-060090-100	R3	9	-	100	2	6	○
SHDR2-080120	R4	12	-	60	2	8	○
SHDR2-080120-75	R4	12	-	75	2	8	○
SHDR2-080160-100	R4	16	-	100	2	8	○
SHDR2-080160-150	R4	16	-	150	2	8	○
SHDR2-100150	R5	15	-	75	2	10	○
SHDR2-100200-100	R5	20	-	100	2	10	○
SHDR2-100200-150	R5	20	-	150	2	10	○
SHDR2-120180	R6	18	-	75	2	12	○
SHDR2-120240-100	R6	24	-	100	2	12	○
SHDR2-120240-150	R6	24	-	150	2	12	○

*New size added from this series.

○ Stocked items.

2 Flutes

Ball



Work Material	Oxygen-free & Copper			
(mm) Diameter	(min-1) Speed	(mm/min) Feed	Ap(mm) Axial depth	Ae(mm) Radial depth
D0.2	30000	150	0.006	0.006
D0.3	26000	300	0.01	0
D0.4	22000	400	0.015	0.015
D0.5	20000	400	0.015	0.015
D0.6	20000	800	0.02	0.02
D0.8	18000	1200	0.02	0.03
D1	16000	1200	0.03	0.04
D1.5	16000	1500	0.03	0.05
D2	15000	1800	0.03	0.05
D2	15000	1800	0.04	0.05
D3	14000	2200	0.04	0.07
D3	14000	2200	0.05	0.07
D3	14000	2200	0.04	0.07
D4	14000	2400	0.04	0.08
D4	14000	2400	0.05	0.08
D5	12000	2600	0.05	0.08
D6	12000	2600	0.05	0.08
D8	10000	3000	0.05	0.1
D10	9000	3000	0.05	0.12
D12	9000	3000	0.05	0.15

Note:

*The above milling parameters are calculated based on 3D. Decrease both spindle speed and feed rate proportionally if the overhang length exceeds $3 \times D$;

*Recommend oil coolant for Stainless Steels and Heat Resistance Alloys;

*Decrease both spindle speed and feed rate proportionally when the milling parameters exceed the machine's maximum spindle speed.