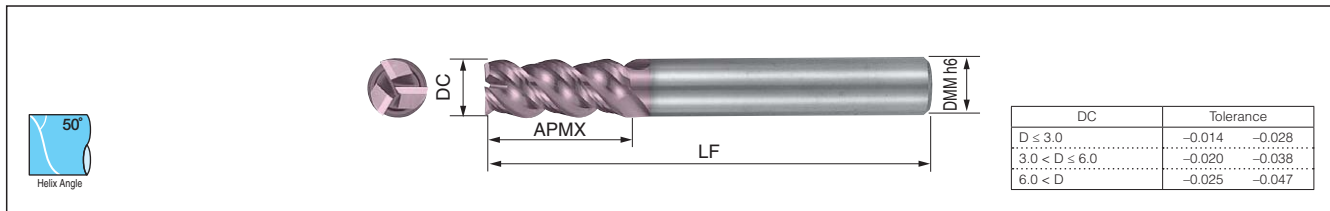


SSUP 3000ZX Type



Coated Carbide	Carbon Steel	Alloy Steel	Pre-hardened Steel	Tempered Steel	Hardened Steel			Stainless Steel	Ti Alloy	Cast Iron	Aluminum Alloy	Copper Alloy	Graphite	CFRP
⊙	⊙	⊙	⊙	⊙	45 to 55 HRC	55 to 60 HRC	60 to 65 HRC	⊙	⊙	⊙	⊙	⊙	⊙	⊙



Body

Cat. No.	Stock	Dimensions (mm)			
		Cutting diameter DC	Depth of cut APMX	Total Length LF	Shank diameter DMM
SSUP 3020ZX	●	2.0	6.0	50	4
3025ZX	●	2.5	8.0	50	4
3030ZX	●	3.0	8.0	50	6
3035ZX	●	3.5	10.0	50	6
3040ZX	●	4.0	11.0	50	6
SSUP 3045ZX	●	4.5	11.0	50	6
3050ZX	●	5.0	13.0	60	6
3055ZX	●	5.5	13.0	60	6
3060ZX	●	6.0	13.0	60	6
3065ZX	●	6.5	16.0	70	8
SSUP 3070ZX	●	7.0	16.0	70	8
3075ZX	●	7.5	16.0	70	8
3080ZX	●	8.0	19.0	80	8
3085ZX	●	8.5	19.0	90	10
3090ZX	●	9.0	19.0	90	10
SSUP 3095ZX	●	9.5	19.0	90	10
3100ZX	●	10.0	22.0	90	10
3110ZX	●	11.0	22.0	90	12
3120ZX	●	12.0	26.0	90	12
3130ZX	●	13.0	26.0	100	12
SSUP 3140ZX	●	14.0	26.0	110	16
3150ZX	●	15.0	26.0	110	16
3160ZX	●	16.0	32.0	115	16

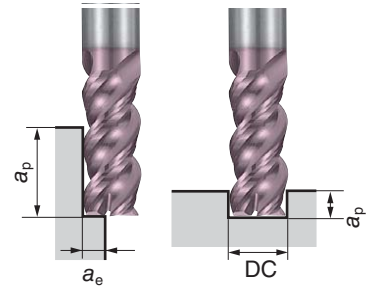
Grade: ACZ50M

Coated Endmills

- Square
- 2 Flutes
- 3 Flutes**
- 4 Flutes
- 6 Flutes
- 8 Flutes
- Radius
- Ballnose
- DLC
- SUMIDIA Coat
- Long Neck
- Uncoated
- CBN
- PCD

Recommended Cutting Conditions

1. If the machine cannot achieve the standard spindle speed, please use the max. spindle speed available.
2. If cutting noise and vibration are present, please reduce the cutting conditions accordingly.



Side Milling and Groove Milling

Work Material Cond.	Carbon Steel, Cast Iron (150 to 250HB)		Alloy Steel SCM (25 to 35HRC)		Tempered Steel, Hardened Steel (40 to 50HRC)		Stainless Steel (*)		Heat Resistant Alloy Titanium Alloy (20 to 45HRC)		
	DC (mm)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)
	2.0	9,000	540	6,000	320	4,000	240	5,500	240	2,600	90
	4.0	6,600	600	4,500	340	3,000	280	4,000	240	2,000	90
	6.0	4,800	720	3,000	360	2,500	280	3,000	360	1,200	90
	8.0	3,600	750	2,200	460	2,000	300	2,000	390	1,000	100
	10.0	2,800	750	1,800	460	1,500	300	1,700	410	800	120
	12.0	2,400	710	1,500	410	1,200	280	1,500	380	700	100
	14.0	2,200	660	1,300	370	1,000	270	1,200	320	600	95
	16.0	1,800	490	1,100	320	800	230	1,000	270	500	90
Side Milling	a _p	1.5DC									
	a _e	0.1DC		0.05DC		0.1DC		0.05DC			
Groove Milling	a _p	1.0DC				0.2DC		0.3DC		0.2DC	

1. For groove milling of Stainless steel, use 60% of recommended spindle speed and 40% of recommended feed rate. (*)
2. If cutting noise and vibration are present, please reduce the cutting conditions accordingly.

Slot Milling

Work Material Cond.	Carbon Steel, Cast Iron (150 to 250HB)		Alloy Steel SCM (25 to 35HRC)		Tempered Steel, Hardened Steel (40 to 50HRC)		Stainless Steel		Heat Resistant Alloy Titanium Alloy (20 to 45HRC)		
	DC (mm)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)
	2.0	9,000	150	6,000	100	4,000	60	6,400	25	2,600	20
	4.0	6,600	250	4,500	170	3,000	80	3,600	30	2,000	40
	6.0	4,800	300	3,000	200	2,500	110	2,650	40	1,200	40
	8.0	3,600	300	2,200	200	2,000	120	2,000	40	1,000	50
	10.0	2,800	300	1,800	200	1,500	120	1,600	40	800	50
	12.0	2,400	300	1,500	200	1,200	120	1,300	40	700	50
	14.0	2,200	250	1,300	150	1,000	80	1,150	35	600	40
	16.0	1,800	200	1,100	120	800	60	1,000	35	500	30

1. If cutting noise and vibration are present, please reduce the cutting conditions accordingly.
2. Supply water-soluble coolant when machining stainless steel, heat resistant alloy, and titanium alloy. Use dry machining (air blow) for all other work materials.