OSAWA

MDCAB2

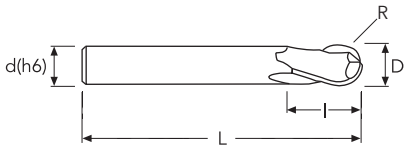
cylindrical shank, 2 flutes ball nose, polished

OSAWA NORM | ALU | MG POLISHED | 40° | BALL NOSE | Z2 BALL

P	M	K	N	S	H
			★		

★ 1st choice ☆ suitable

COPYING



D	D Tol.	R	R Tol.	d(h6)	l	l1	L	z	EDP No.	Stock
1	0/-0.020	0.50	+/-0.010	4	2		50	2	MDCAB2010	●
1.5	0/-0.020	0.75	+/-0.010	4	3		50	2	MDCAB2015	●
2	0/-0.020	1.00	+/-0.010	4	4		50	2	MDCAB2020	●
3	0/-0.020	1.50	+/-0.010	4	6		50	2	MDCAB2030	●
4	0/-0.020	2.00	+/-0.010	4	8		50	2	MDCAB2040	●
5	0/-0.020	2.50	+/-0.010	6	10		50	2	MDCAB2050	●
6	0/-0.020	3.00	+/-0.010	6	12		50	2	MDCAB2060	●
8	0/-0.025	4.00	+/-0.010	8	16		60	2	MDCAB2080	●
10	0/-0.025	5.00	+/-0.010	10	20		75	2	MDCAB2100	●
12	0/-0.025	6.00	+/-0.010	12	24		75	2	MDCAB2120	●

● stock standard ○ non-standard stock ∇ stock exhaustion

INFO
TYPHOON TA-HTA-4HTA
TYPHOON PU-HPU
TYPHOON SUH
TYPHOON ALH
TYPHOON HRC
TYPHOON SUH MINI
TYPHOON HL
C-SD-TA
LFTA
SUTA
HSS-HSS/CO DRILLS
G2
MDTA
HF VH/UP
MEF
ALU
MEX
UH
HSS/CO-HSSP END MILLS
CARBIDE BURRS

CUTTING PARAMETERS

MDCAB2

	Material Group ISO 513		N1			N2 N3			N4			N5		
	Material		Alluminium ≤ 12% Si - Copper Alloy			Alluminium > 12% Si - Copper Alloy			Brass and bronze			Plastics		
	ap x ae		0.2D x 0.4D			0.2D x 0.4D			0.2D x 0.4D			0.2D x 0.4D		
	Vc (m/min)		200-600			250-450			200-400			600-1000		
ap ae COPYING	D (mm)	D (eff.) (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	**0.80**	40000	0.013	1010	111460	0.011	2530	95540	0.010	1930	254780	0.013	6420
	1.5	**1.20**	84930	0.017	2850	74310	0.015	2250	63690	0.013	1710	169850	0.017	5710
	2	**1.60**	63690	0.017	2140	55730	0.015	1690	47770	0.013	1280	127390	0.017	4280
	2.5	**2.00**	50960	0.021	2140	44590	0.019	1690	38220	0.017	1280	101910	0.021	4280
	3	**2.40**	42460	0.025	2140	37150	0.023	1690	31850	0.020	1280	84930	0.025	4280
	4	**3.20**	31850	0.035	2230	27870	0.032	1760	23890	0.028	1340	63690	0.035	4460
	5	**4.00**	25480	0.045	2280	22290	0.040	1800	19110	0.036	1370	50960	0.045	4570
	6	**4.80**	21230	0.053	2260	18580	0.048	1780	15920	0.043	1360	42460	0.053	4520
	8	**6.40**	15920	0.067	2140	13930	0.060	1680	11940	0.054	1280	31850	0.067	4280
	10	**8.00**	12740	0.080	2030	11150	0.072	1600	9550	0.064	1220	25480	0.080	4070
	12	**9.60**	10620	0.094	1990	9290	0.084	1570	7960	0.075	1190	21230	0.094	3980