

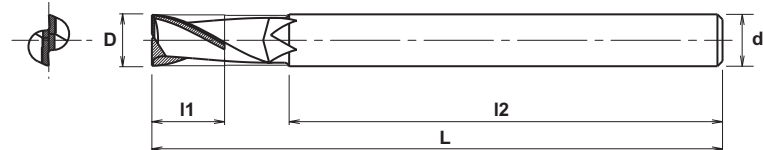
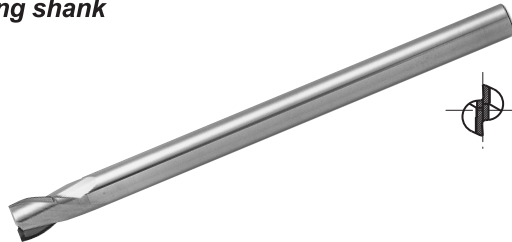


METRIC

Beam End Mill

VN-OCAS2-LS Type

- For aluminum cutting
- 2 Flute with 30° Helix, possible center cutting and long shank



CATALOG NUMBER	STK	DIMENSIONS				
		D	l1	l2	L	d
VN-OCAS2030-LS	<input type="checkbox"/>	3.0	6	66	80	4
VN-OCAS2040-LS	<input type="checkbox"/>	4.0	7	64	80	4
VN-OCAS2050-LS	<input type="checkbox"/>	5.0	7	69	85	4
VN-OCAS2060-LS	<input type="checkbox"/>	6.0	9	69	85	5
VN-OCAS2080-LS	<input type="checkbox"/>	8.0	9	89	105	7
VN-OCAS2100-LS	<input type="checkbox"/>	10.0	12	102	120	9
VN-OCAS2120-LS	<input type="checkbox"/>	12.0	12	122	140	11

- Stocked standard
- Inquire regarding delivery

Recommended Cutting Data

Material	Aluminum Alloy		Carbon	
Type of Machining - Shoulder Cutting	$V_c=175\text{m/min}$ $a_p=0.5D$ $a_e=0.2D$		$V_c=100\text{m/min}$ $a_p=0.5D$ $a_e=0.05D$	
Diameter	N (min ⁻¹)	Vc (mm/min)	N (min ⁻¹)	Vc (mm/min)
3	18,500	140	10,500	70
4	14,000	140	8,000	70
5	11,000	140	6,500	70
6	9,500	160	5,000	100
8	7,000	160	4,000	100
10	5,500	160	3,200	100
12	4,500	160	2,650	100

Material	Aluminum Alloy		Carbon	
Type of Machining - Shoulder Cutting	$V_c=175\text{m/min}$ $a_p=0.5D$ $a_e=D$		$V_c=100\text{m/min}$ $a_p=0.5D$ $a_e=D$	
Diameter	N (min ⁻¹)	Vc (mm/min)	N (min ⁻¹)	Vc (mm/min)
3	18,500	100	10,500	20
4	14,000	100	8,000	20
5	11,000	100	6,500	20
6	9,500	120	5,000	30
8	7,000	120	4,000	30
10	5,500	120	3,200	30
12	4,500	120	2,650	30