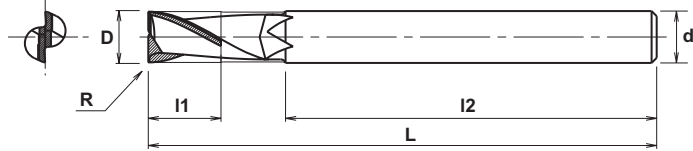
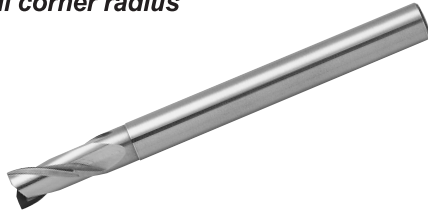


Beam End Mill

METRIC

VN-OCAS2-R Type

- 2 Flute with 30° Helix, possible center cutting and small corner radius



CATALOG NUMBER	STK	DIMENSIONS					
		D	R	I1	I2	L	d
VN-OCAS2030R015	□	3.0	0.15	6	45	60	4
VN-OCAS2035R015	□	3.5	0.15	6	45	60	4
VN-OCAS2040R015	□	4.0	0.15	7	43	60	4
VN-OCAS2045R015	□	4.5	0.15	7	43	60	6
VN-OCAS2050R015	□	5.0	0.15	7	48	65	6
VN-OCAS2055R015	□	5.5	0.15	9	46	65	6
VN-OCAS2060R025	□	6.0	0.25	9	46	65	6
VN-OCAS2065R025	□	6.5	0.25	9	46	65	8
VN-OCAS2070R025	□	7.0	0.25	9	66	85	8
VN-OCAS2075R025	□	7.5	0.25	9	66	85	8

CATALOG NUMBER	STK	DIMENSIONS					
		D	R	I1	I2	L	d
VN-OCAS2080R025	□	8.0	0.25	9	66	85	8
VN-OCAS2085R025	□	8.5	0.25	9	66	85	10
VN-OCAS2090R025	□	9.0	0.25	9	81	100	10
VN-OCAS2095R025	□	9.5	0.25	9	81	100	10
VN-OCAS2100R040	□	10.0	0.40	12	78	100	10
VN-OCAS2105R040	□	10.5	0.40	12	78	100	12
VN-OCAS2110R040	□	11.0	0.40	12	98	120	12
VN-OCAS2115R040	□	11.5	0.40	12	98	120	12
VN-OCAS2120R040	□	12.0	0.40	12	98	120	12

- Stocked standard
- Inquire regarding delivery

Recommended Cutting Data for VN-OCAS2 & VN-OCAS2-R

Material	Aluminum Alloy		Copper Alloy		Quartz Glass (Note: tool needs to be modified for this material)	
Type of Machining - Shoulder Cutting	$V_c=350\text{m/min}$ $a_p=0.5D$ $a_e=0.33D$		$V_c=200\text{m/min}$ $a_p=0.5D$ $a_e=0.05D$		$V_c=60\text{m/min}$ $a_p=0.5D$ $a_e=0.1D$	
Diameter	N (min ⁻¹)	Vc (mm/min)	N (min ⁻¹)	Vc (mm/min)	N (min ⁻¹)	Vc (mm/min)
3	37,000	750	21,000	1,250	6,300	190
4	28,000	1,100	16,000	1,300	4,800	190
5	22,000	1,100	13,000	1,550	3,800	210
6	19,000	1,300	10,000	1,700	3,200	220
8	14,000	1,400	8,000	1,900	2,400	220
10	11,000	1,500	6,400	2,000	2,000	200
12	9,000	1,800	5,300	2,100	1,600	200

Material	Aluminum Alloy		Copper Alloy		Quartz Glass (Note: tool needs to be modified for this material)	
Type of Machining - Slotting	$V_c=350\text{m/min}$ $a_p=0.5D$ $a_e=D$		$V_c=200\text{m/min}$ $a_p=0.5D$ $a_e=D$		$V_c=60\text{m/min}$ $a_p=0.1D$ $a_e=D$	
Diameter	N (min ⁻¹)	Vc (mm/min)	N (min ⁻¹)	Vc (mm/min)	N (min ⁻¹)	Vc (mm/min)
3	37,000	700	21,000	500	6,300	100
4	28,000	1,000	16,000	550	4,800	100
5	22,000	1,050	13,000	650	3,800	120
6	19,000	1,200	10,000	700	3,200	120
8	14,000	1,300	8,000	800	2,400	130
10	11,000	1,400	6,400	800	2,000	110
12	9,000	1,700	5,300	850	1,600	110