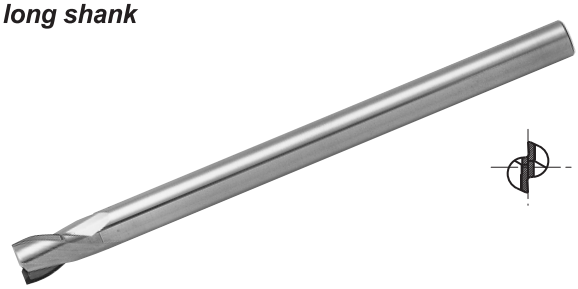
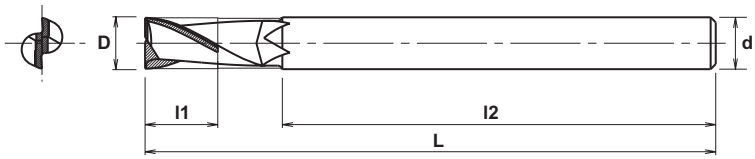
Beam End Mill

METRIC

VN-OCES2-LS Type

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





CATALOG NUMBER	STK	DIMENSIONS				
		D	l1	l2	L	d
VN-OCES2030-LS	□	3.0	6	66	80	4
VN-OCES2040-LS	□	4.0	7	64	80	4
VN-OCES2050-LS	□	5.0	7	69	85	4
VN-OCES2060-LS	□	6.0	9	69	85	5
VN-OCES2080-LS	□	8.0	9	89	105	7
VN-OCES2100-LS	□	10.0	12	102	120	9
VN-OCES2120-LS	□	12.0	12	122	140	11

- **Stocked standard**
- □ **Inquire regarding delivery**

Recommended Cutting Data

Material	Graphite		Carbon		Metal Matrix Composite (up to 30% Ceramic content)	
Type of Machining - Shoulder Cutting	Vc=125m/min ap=0.5D ae=0.05D		Vc=100m/min ap=0.5D ae=0.2D		Vc=15m/min ap=0.5D ae=0.02D	
Diameter	N (min⁻¹)	Vc (mm/min)	N (min⁻¹)	Vc (mm/min)	N (min⁻¹)	Vc (mm/min)
3	13,500	125	10,500	80	1,600	20
4	10,000	125	8,000	80	1,200	20
5	8,000	125	6,500	80	950	20
6	6,500	140	5,000	120	800	20
8	5,000	140	4,000	120	600	20
10	4,000	140	3,200	120	500	20
12	3,250	140	2,650	120	400	20

Material	Graphite		Carbon		Metal Matrix Composite (up to 30% Ceramic content)	
Type of Machining - Slotting	Vc=125m/min ap=0.5D ae=D		Vc=100m/min ap=0.5D ae=D		Vc=15m/min ap=0.5D ae=D	
Diameter	N (min⁻¹)	Vc (mm/min)	N (min⁻¹)	Vc (mm/min)	N (min⁻¹)	Vc (mm/min)
3	13,500	30	10,500	60	1,600	3
4	10,000	30	8,000	60	1,200	3
5	8,000	30	6,500	60	950	3
6	6,500	40	5,000	90	800	4
8	5,000	40	4,000	90	600	4
10	4,000	40	3,200	90	500	4
12	3,250	40	2,650	90	400	4