

**DLTMJ550 End mill for dieoperation parameter:**

**DLTMJ550-S2 For Alloy Steel,Hardened Steel-Side Milling**

Grades	Tool shape S2	Workpiece Material	Cutting depth (mm)	VC m/min	Tool Diameter(mm)	2	4	6	8	10	12	16	20
DLTMJ550	Square,corner radius	Alloy steel,hardened steel HRC55	ap≤1D	120	Speed (min-1)	19100	9550	6730	4780	3820	3190	2390	1910
			ae≤0.05D		Feed speed (mm/min)	380	380	380	380	370	360	310	290

**DLTMJ550-S4 For Alloy Steel,Hardened Steel-Side Milling**

Grades	Tool shape S4	Workpiece Material	Cutting depth (mm)	VC m/min	Tool Diameter(mm)	2	4	6	8	10	12	16	20
DLTMJ550	Square,corner radius	Alloy steel,hardened steel HRC55	ap≤1D	120	Speed (min-1)	19100	9550	6730	4780	3820	3190	2390	1910
			ae≤0.05D		Feed speed (mm/min)	760	760	760	760	730	710	620	570

DLTMJ550-S2 For Alloy Steel,Hardened Steel-Profiling

Grades	Tool shape S2	Workpiece Material	Cutting depth (mm)	VC m/min	Tool Diameter(mm)	2	4	6	8	10	12	14	16
DLTMJ550	Ball nose	HRC55	$a_p \leq 0.03D$	200	Speed (min-1)	31850	15920	10620	7960	6370	5310	4550	3980
			$a_e \leq 0.03D$		Feed speed (mm/min)	510	570	590	610	570	570	530	490

DLTMJ550-S4 For Alloy Steel,Hardened Steel-Profiling

Grades	Tool shape S4	Workpiece Material	Cutting depth (mm)	VC m/min	Tool Diameter(mm)	2	4	6	8	10	12	14	16
DLTMJ550	Ball nose	HRC55	$a_p \leq 0.03D$	200	Speed (min-1)	31850	15920	10620	7960	6370	5310	4550	3980
			$a_e \leq 0.03D$		Feed speed (mm/min)	1020	1150	1190	1210	1150	1150	1060	990