

4 Flutes UTCOAT Standard Taper Barrel Form



CSTB

Super
MG

UT
COAT

Form
±0.01

Shank Dia
0/-0.005

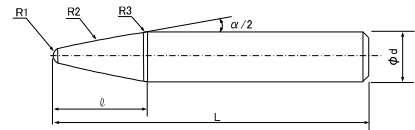
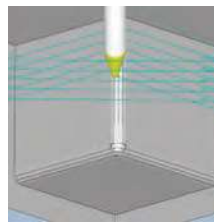
NEW

Material Applications (★ Highly Recommended ● Recommended ○ Suggested)

Work Material																	
Carbon Steels S45C S55C	Alloy Steels SK / SCM SUS	Prehardened Steels NAK HPM	Hardened Steels					Cast Iron	Aluminum Alloys	Graphite	Copper	Plastics	Glass Filled Plastics	Titanium Alloys	Heat Resistant Alloys	Cemented Carbide	Hard Brittle (Non-Metallic) Materials
			~ 50HRC	~ 55HRC	~ 60HRC	~ 65HRC	~ 70HRC										
●	●	●	●	●				○	●		●			○	○		

Features

**Broad range of application available with UTCOAT.
Suitable for finishing on straight and inclined walls with larger barrel R.**



Total 5 models

Unit (mm)

Model Number	Half Included Angle $\alpha/2$	Tip R R1	Barrel R R2	Third R R3	Length of Cut ℓ	Overall Length L	Shank Diameter ϕd	Suggested Retail Price ¥
CSTB 4020-200-30	15°	R1	R200	R3	8.6	60	6	23,400
CSTB 4030-250-40	20°	R1.5	R250	R4	8.7	70	8	29,000
CSTB 4040-250-40	20°	R2	R250	R5	10.7	80	10	33,330
CSTB 4060-250-45	22.5°	R3	R250	R6	10.7	100	12	40,320
CSTB 4020-200-85	42.5°	R1	R200	R1	6.4	100	12	40,320

φ3mm Shank
V Series

UDC-PCD
Series

CBN
Series

Square

Long Neck
Square

Radius

Long Neck
Radius

Taper Neck
Radius

Ball / Long
Shank Ball

Long Neck
Ball

Taper Neck
Ball

Taper

Barrel

Spiral
V Cutter

Drill

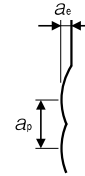
Technical Data

Milling Conditions for CSTB

WORK MATERIAL			ALUMINUM ALLOYS A7075				PREHARDENED STEELS PXA30(30~45HRC)				HARDENED STEELS SKD61 / STAVAX(45~55HRC)			
Model Number	Tip R (mm)	Barrel R (mm)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a_p Axial Depth (mm)	a_e Radial Depth (mm)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a_p Axial Depth (mm)	a_e Radial Depth (mm)	Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a_p Axial Depth (mm)	a_e Radial Depth (mm)
4020-200-30	R1	R200	18,000	2,400	2.85	0.1	11,500	1,800	1.9	0.075	9,000	1,440	1.5	0.075
4030-250-40	R1.5	R250	15,600	2,400	2.85	0.1	10,300	1,600	2.4	0.075	8,000	1,200	2	0.075
4040-250-40	R2	R250	13,200	2,400	2.85	0.1	9,100	1,600	2.4	0.075	7,000	1,200	2	0.075
4060-250-45	R3	R250	10,800	2,400	2.85	0.1	8,000	1,600	2.4	0.075	6,000	1,200	2	0.075
4020-200-85	R1	R200	10,800	1,200	2.85	0.1	8,000	700	2	0.075	6,000	500	2	0.05

Note:

•Set spindle speed, feed rate, and axial depth (a_p) in accordance with the required surface quality.



4 Flutes

φ3mm Shank
V Series

UDC-PCD
Series

CBN
Series

Square

Square

Long Neck
Square

Radius

Radius

Long Neck
Radius

Taper Neck
Radius

Ball

Ball / Long
Shank Ball

Long Neck
Ball

Taper Neck
Ball

Taper

Taper

Barrel

Spiral
V Cutter

Drill

Technical Data

575