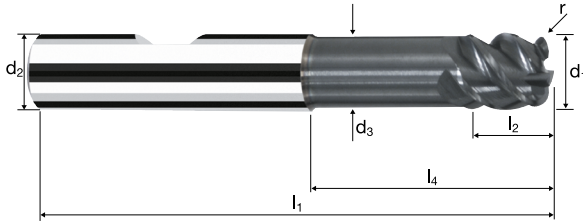


Corner radius end mills HX-R

Smooth-edged, normal version with neck



HM
MG10 λ 55°
 γ -10°



Roughing

Finishing



ToolSchool

Rm
1100-1300

Rm
1300-1500

HRC
48-56

HRC
56-60

HRC
> 60

Ti
Titanium

GG(G)

Example:
Order-N°.

Coating Article-N° ø-Code
D **5356** **300**



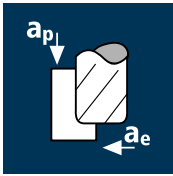
DURO-S

D5356

D5256

Ø Code	d ₁ e8	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	r 0/+0.03	z		
300	6.00	6.00	5.50	57	7.00	19.34	20.00	1.500	4		●
391	8.00	8.00	7.40	63	9.00	25.29	26.00	2.000	4		●
450	10.00	10.00	9.20	72	11.00	30.20	31.00	2.500	4		●
501	12.00	12.00	11.00	83	13.00	36.13	37.00	3.000	4		●
605	16.00	16.00	15.00	92	17.00	42.13	43.00	2.500	4		●
610	16.00	16.00	15.00	92	17.00	42.13	43.00	3.500	4		●
615	16.00	16.00	15.00	92	17.00	42.13	43.00	4.000	4		●

Application



Material

Steel
1100 - 1300 N/mm²



D



D

Hardened tool steel
42 - 48 HRC



D

Hardened tool steel
48 - 52 HRC

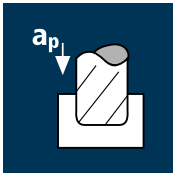


D

Hardened tool steel
52 - 56 HRC



D



Steel
1100 - 1300 N/mm²



D



D

Hardened tool steel
42 - 48 HRC



D

Hardened tool steel
48 - 52 HRC



D

Hardened tool steel
52 - 56 HRC



D

d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
6.00	4	150	0.050	6.000	3.600	7960	1590	34.4
8.00	4	150	0.065	8.000	4.800	5970	1550	59.6
10.00	4	150	0.085	10.000	6.000	4775	1625	97.4
12.00	4	150	0.100	12.000	7.200	3980	1590	137.5
16.00	4	150	0.135	16.000	6.400	2985	1610	165.0
6.00	4	120	0.035	6.000	3.600	6365	890	19.3
8.00	4	120	0.045	8.000	4.800	4775	860	33.0
10.00	4	120	0.055	10.000	6.000	3820	840	50.4
12.00	4	120	0.065	12.000	7.200	3185	830	71.5
16.00	4	120	0.090	16.000	6.400	2385	860	88.0
6.00	4	80	0.025	6.000	3.600	4245	425	9.2
8.00	4	80	0.035	8.000	4.800	3185	445	17.1
10.00	4	80	0.045	10.000	6.000	2545	460	27.5
12.00	4	80	0.055	12.000	7.200	2120	465	40.3
16.00	4	80	0.075	16.000	6.400	1590	475	48.9
6.00	4	60	0.020	6.000	3.600	3185	255	5.5
8.00	4	60	0.025	8.000	4.800	2385	240	9.2
10.00	4	60	0.035	10.000	6.000	1910	265	16.0
12.00	4	60	0.040	12.000	7.200	1590	255	22.0
16.00	4	60	0.055	16.000	6.400	1195	265	26.9
6.00	4	120	0.040	3.000	6.000	6365	1020	18.3
8.00	4	120	0.050	4.000	8.000	4775	955	30.6
10.00	4	120	0.070	5.000	10.000	3820	1070	53.5
12.00	4	120	0.080	6.000	12.000	3185	1020	73.3
16.00	4	120	0.110	4.000	16.000	2385	1050	67.2
6.00	4	100	0.030	3.000	6.000	5305	635	11.5
8.00	4	100	0.035	4.000	8.000	3980	555	17.8
10.00	4	100	0.045	5.000	10.000	3185	575	28.6
12.00	4	100	0.050	6.000	12.000	2655	530	38.2
16.00	4	100	0.070	4.000	16.000	1990	555	35.7
6.00	4	60	0.020	3.000	6.000	3185	255	4.6
8.00	4	60	0.030	4.000	8.000	2385	285	9.2
10.00	4	60	0.035	5.000	10.000	1910	265	13.4
12.00	4	60	0.045	6.000	12.000	1590	285	20.6
16.00	4	60	0.060	4.000	16.000	1195	285	18.3
6.00	4	40	0.015	3.000	6.000	2120	125	2.3
8.00	4	40	0.020	4.000	8.000	1590	125	4.1
10.00	4	40	0.030	5.000	10.000	1275	155	7.6
12.00	4	40	0.030	6.000	12.000	1060	125	9.2
16.00	4	40	0.045	4.000	16.000	795	145	9.2