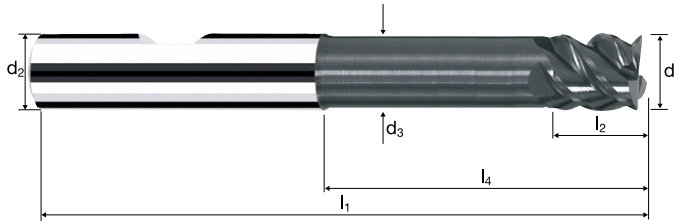
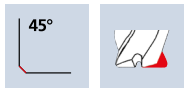


Cylindrical end mills HX

Smooth-edged, medium length version with neck



HM
MG10 λ 55°
 γ -10°



Roughing

Finishing

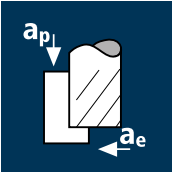


ToolSchool

		Rm 1100-1300	Rm 1300-1500	HRC 48-56	HRC 56-60	HRC > 60	Ti Titanium	GG(G)
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Ø Code	d ₁ e8	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	45°	z	Coating	
										POLYCHROM	DURO-S
Example: Order-N°.										Coating: D Article-N°: 5351 ø-Code: 300	
300	6.00	6.00	5.50	70	7.00	32.34	33.00	0.15	4	P5351	D5351
391	8.00	8.00	7.40	80	9.00	42.29	43.00	0.15	4	P5251	D5251
450	10.00	10.00	9.20	84	11.00	42.20	43.00	0.20	4		
501	12.00	12.00	11.00	97	13.00	50.13	51.00	0.20	4		
610	16.00	16.00	15.00	115	17.00	65.13	66.00	0.20	4		
682	20.00	20.00	19.00	130	21.00	78.13	79.00	0.20	4		

Application



Material

Hardened tool steel
42 - 48 HRC



Hardened tool steel
48 - 52 HRC



Hardened tool steel
52 - 56 HRC



Hardened tool steel
56 - 60 HRC



Hardened tool steel
42 - 48 HRC



Hardened tool steel
48 - 52 HRC



Hardened tool steel
52 - 56 HRC



Hardened tool steel
56 - 60 HRC



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	90	0.035	6.000	2.400	4775	670	9.6
8.00	4	90	0.045	8.000	3.200	3580	645	16.5
10.00	4	90	0.055	10.000	4.000	2865	630	25.2
12.00	4	90	0.070	12.000	4.800	2385	670	38.5
16.00	4	90	0.090	16.000	3.200	1790	645	33.0
20.00	4	90	0.115	20.000	4.000	1430	660	52.7
6.00	4	70	0.030	6.000	2.400	3715	445	6.4
8.00	4	70	0.040	8.000	3.200	2785	445	11.4
10.00	4	70	0.050	10.000	4.000	2230	445	17.8
12.00	4	70	0.060	12.000	4.800	1855	445	25.7
16.00	4	70	0.080	16.000	3.200	1395	445	22.8
20.00	4	70	0.100	20.000	4.000	1115	445	35.7
6.00	4	50	0.025	6.000	2.400	2655	265	3.8
8.00	4	50	0.035	8.000	3.200	1990	280	7.1
10.00	4	50	0.040	10.000	4.000	1590	255	10.2
12.00	4	50	0.050	12.000	4.800	1325	265	15.3
16.00	4	50	0.065	16.000	3.200	995	260	13.2
20.00	4	50	0.080	20.000	4.000	795	255	20.4
6.00	4	25	0.020	6.000	2.400	1325	105	1.5
8.00	4	25	0.025	8.000	3.200	995	100	2.5
10.00	4	25	0.030	10.000	4.000	795	95	3.8
12.00	4	25	0.035	12.000	4.800	665	95	5.3
16.00	4	25	0.050	16.000	3.200	495	100	5.1
20.00	4	25	0.060	20.000	4.000	400	95	7.6
6.00	4	75	0.025	2.400	6.000	3980	400	5.7
8.00	4	75	0.040	3.200	8.000	2985	475	12.2
10.00	4	75	0.045	4.000	10.000	2385	430	17.2
12.00	4	75	0.055	4.800	12.000	1990	440	25.2
16.00	4	75	0.070	3.200	16.000	1490	420	21.4
20.00	4	75	0.090	4.000	20.000	1195	430	34.4
6.00	4	60	0.025	2.400	6.000	3185	320	4.6
8.00	4	60	0.035	3.200	8.000	2385	335	8.6
10.00	4	60	0.045	4.000	10.000	1910	345	13.8
12.00	4	60	0.055	4.800	12.000	1590	350	20.2
16.00	4	60	0.070	3.200	16.000	1195	335	17.1
20.00	4	60	0.090	4.000	20.000	955	345	27.5
6.00	4	40	0.020	2.400	6.000	2120	170	2.4
8.00	4	40	0.030	3.200	8.000	1590	190	4.9
10.00	4	40	0.035	4.000	10.000	1275	180	7.1
12.00	4	40	0.045	4.800	12.000	1060	190	11.0
16.00	4	40	0.060	3.200	16.000	795	190	9.8
20.00	4	40	0.070	4.000	20.000	635	180	14.3
6.00	4	20	0.015	2.400	6.000	1060	65	0.9
8.00	4	20	0.021	3.200	8.000	795	65	1.7
10.00	4	20	0.026	4.000	10.000	635	65	2.6
12.00	4	20	0.031	4.800	12.000	530	65	3.8
16.00	4	20	0.041	3.200	16.000	400	65	3.3
20.00	4	20	0.051	4.000	20.000	320	65	5.2