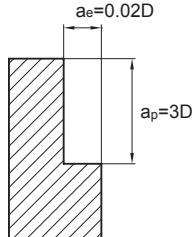
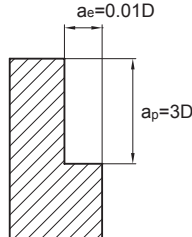


### HMX-6E

Workpiece material	Pre-hardened steel, Hardened steel 40~50HRC		Hardened steel 50~60HRC		Hardened steel 60~68HRC	
cutting speed	300m/min		150m/min		100m/min	
Diameter (mm)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)
6	16000	1850	8000	925	5300	610
8	12000	1850	6000	925	4000	610
10	9600	1850	4800	925	3200	610
12	8000	1920	4000	960	2700	650
14	6800	1600	3400	815	2300	550
16	6000	1440	3000	720	2000	480
18	5300	1270	2700	635	1800	430
20	4800	1150	2400	575	1600	385
Maximum cutting depth	<p>Maximum <math>a_e=1.0\text{mm}</math></p>		<p>Maximum <math>a_e=0.5\text{mm}</math></p>		<p>Maximum <math>a_e=0.3\text{mm}</math></p>	

1. Please select high-precision and rigidity machine and tool holder.
2. When the machine rigidity and workpiece fixture stability is low, vibration and abnormal noise may be generated. Please reduce the rotating speed and feed speed stated above correspondingly.
3. Please use air blow or MQL (minimum oil mist cooling).
4. Down milling is recommended in the case of side milling.
5. Make overhang of tool as short as possible in conditions of non-interference.

## HMX-6EL

Workpiece material	Pre-hardened steel, Hardened steel 40~50HRC		Hardened steel 50~60HRC		Hardened steel 60~68HRC	
cutting speed	300m/min		150m/min		100m/min	
Diameter (mm)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)
6	16000	1300	8000	650	5300	430
8	12000	1300	6000	650	4000	430
10	9600	1300	4800	650	3200	430
12	8000	1350	4000	670	2700	460
14	6800	1150	3400	570	2300	380
16	6000	1000	3000	500	2000	340
18	5300	890	2700	450	1800	300
20	4800	800	2400	400	1600	270
Maximum cutting depth	 <p>Maximum <math>a_e = 0.3\text{mm}</math></p>					

1. Please select high-precision and rigidity machine and tool holder.
2. When the machine rigidity and workpiece fixture stability is low, vibration and abnormal noise may be generated. Please reduce the rotating speed and feed speed stated above correspondingly.
3. Please use air blow or MQL (minimum oil mist cooling).
4. Down milling is recommended in the case of side milling.
5. Make overhang of tool as short as possible in conditions of non-interference.