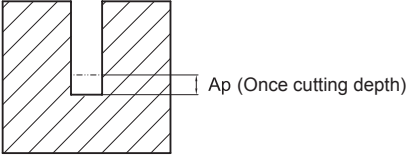


HMX-2EP

Workpiece material		Pre-hardened steel, Hardened steel 40~50HRC			Hardened steel 50~60HRC		
Diameter (mm)	Effective length (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)
0.5	4	21000	100	0.009	17000	50	0.009
	6	20000	75	0.006	15000	35	0.007
	8	20000	50	0.002	15000	20	0.003
0.8	4	20000	200	0.022	14000	100	0.011
	6	18000	150	0.014	14000	75	0.009
	8	18000	100	0.01	14000	50	0.006
	10	18000	75	0.007	14000	30	0.004
1.0	4	17000	400	0.035	12000	100	0.016
	6	17000	400	0.03	12000	100	0.014
	8	15000	300	0.02	10000	75	0.01
	10	15000	250	0.015	10000	50	0.008
	12	12000	150	0.01	10000	50	0.006
	14	12000	100	0.007	10000	30	0.004
1.2	6	14000	400	0.03	10000	100	0.017
	8	12000	300	0.03	10000	100	0.014
	10	12000	300	0.02	10000	75	0.01
	12	10000	200	0.01	10000	50	0.00
1.5	6	12000	400	0.06	8000	200	0.028
	8	10000	300	0.04	7000	150	0.021
	10	10000	300	0.03	7000	150	0.017
	12	10000	300	0.025	7000	100	0.01
	14	10000	250	0.02	7000	75	0.005
2.0	6	9000	400	0.13	6000	300	0.07
	8	9000	400	0.11	6000	300	0.06
	10	7000	300	0.10	6000	200	0.05
	12	7000	300	0.06	6000	200	0.03
	14	7000	250	0.04	6000	150	0.015
	16	7000	200	0.02	6000	100	0.008

Maximum cutting depth



Indexable milling tools

Solid carbide end mills

Cutting parameters for HMX series end mills

HMX-2EP

Workpiece material		Pre-hardened steel, Hardened steel 40~50HRC			Hardened steel 50~60HRC		
Diameter (mm)	Effective length (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	a _p (mm)
2.5	8	8000	400	0.16	5000	300	0.08
	10	8000	400	0.14	5000	300	0.07
	12	8000	400	0.09	5000	300	0.05
	14	6000	300	0.07	5000	200	0.03
	16	6000	300	0.05	5000	200	0.025
	18	6000	300	0.04	5000	150	0.02
	20	6000	300	0.02	5000	100	0.01
3.0	6	7000	400	0.18	5000	300	0.10
	8	7000	400	0.15	5000	300	0.08
	10	7000	400	0.12	5000	300	0.06
	12	7000	400	0.10	5000	300	0.05
	14	6000	300	0.08	5000	200	0.04
	16	6000	300	0.06	5000	200	0.03
	18	6000	300	0.05	5000	200	0.025
	20	6000	250	0.04	5000	150	0.01
4.0	12	4500	400	0.16	4000	300	0.08
	16	4500	400	0.14	4000	300	0.06
	20	4500	300	0.10	4000	300	0.04
	25	4500	300	0.08	4000	300	0.03
5.0	16	4000	400	0.19	3000	300	0.09
	25	4000	400	0.15	3000	300	0.06
Maximum cutting depth							

Indexable milling tools

Solid carbide end mills

Cutting parameters for HMX series end mills

1. Please select high-precision machine and tool holder.
2. Please use air blow or cutting liquid with high mist retardant property.
3. Make overhang of tool as short as possible in conditions of non-interference.
4. Reduce feed speed correspondingly when rotating speed is low.