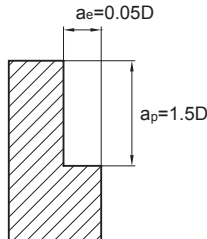
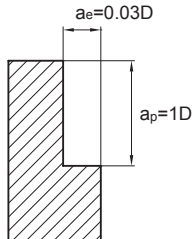
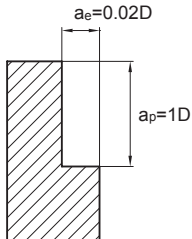


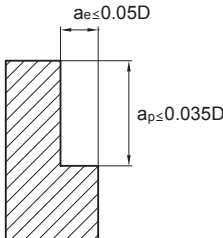
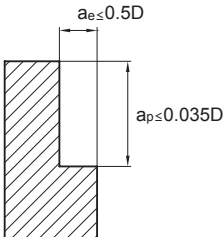


HMX-4R★HMX-4RBL/M/X★HMX-4RP★HMX-4RF

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 ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)
3	32000	1225	16000	610	11000	420
4	24000	1500	12000	745	8000	500
5	19000	1630	9500	815	6400	550
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	648
16	6000	1440	3000	720	2000	480
Maximum cutting depth	 <p>Maximum $a_e = 1.0\text{mm}$</p>		 <p>Maximum $a_e = 0.5\text{mm}$</p>		 <p>Maximum $a_e = 0.3\text{mm}$</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-6R-MAX

Workpiece material	Pre-hardened steel, Hardened steel 40~50HRC		Hardened steel 50~60HRC	
Cutting speed	100m/min		80m/min	
Diameter (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)
6	5300	3200	4200	2600
8	4000	3200	3200	2600
10	3200	3200	2600	2600
12	2600	3200	2200	2600
16	2000	3600	1600	2800
20	1600	3600	1300	2800
Maximum cutting depth				

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. Make overhang of tool as short as possible in conditions of non-interference.