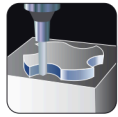


High feed side milling carbide end mill

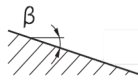
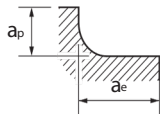
HIGH FEED SIDE MILLING

HYP-HS-CRE



Vc	Cast Iron		SKT / SKD NAK55 / HPM1		SUS30 / SKD NAK80 / HPM50		Hardened Steels			
			< 38 HRC		< 45 HRC		< 55 HRC		< 60HRC	
	m/min		m/min		m/min		m/min		m/min	
Ø	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)
6 X R 1,50	5,300	6,300	4,250	4,600	3,700	4,000	2,650	2,600	1,600	1,050
8 X R 2,00	4,000	6,300	3,200	4,600	2,800	4,000	2,000	2,600	1,200	1,050
10 X R 2,00	3,200	6,300	2,550	4,600	2,250	4,000	1,600	2,600	955	1,050
12 X R 3,00	2,650	6,300	2,100	4,600	1,850	4,000	1,350	2,600	795	1,050

Maximum depth of cut



ap	ae
0.1 x R	0.3D

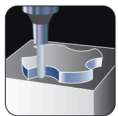
Dia	ap	ae
R < 2	0.1 x R	0.3D
2 < R	0.2 mm	0.3D

Dia	ap	ae
R < 2	0.05 x R	0.3D
2 < R	0.1 mm	0.3D

2 flute ball nose carbide end mill (low torque / better surface finish / longer life)

PROFILING

HYP-SB-EBD



Vc	Copper Alloy				Pre Hardened / Hardened Steels											
					< 35 HRC				< 42 HRC				< 55 HRC			
	300 m/min				280 m/min				260 m/min				240 m/min			
Ø	Speed (min-1)	Feed (mm/min.)	ap (mm)	pf (mm)	Speed (min-1)	Feed (mm/min.)	ap (mm)	pf (mm)	Speed (min-1)	Feed (mm/min.)	ap (mm)	pf (mm)	Speed (min-1)	Feed (mm/min.)	ap (mm)	pf (mm)
3	31,847	2,866	0.15	0.60	29,724	2,675	0.15	0.60	27,601	2,484	0.15	0.60	25,478	2,293	0.15	0.60
4	23,885	2,866	0.20	0.80	22,293	2,675	0.20	0.80	20,701	2,484	0.20	0.80	19,108	2,293	0.20	0.80
5	19,108	2,866	0.25	1.00	17,834	2,675	0.25	1.00	16,561	2,484	0.25	1.00	15,287	2,293	0.25	1.00
6	15,924	2,866	0.30	1.20	14,862	2,675	0.30	1.20	13,800	2,484	0.30	1.20	12,739	2,293	0.30	1.20
8	11,943	2,866	0.40	1.60	11,146	2,675	0.40	1.60	10,350	2,484	0.40	1.60	9,554	2,293	0.40	1.60
10	9,664	2,866	0.50	2.00	8,917	2,675	0.50	2.00	8,280	2,484	0.50	2.00	7,643	2,293	0.50	2.00
12	7,962	2,866	0.60	2.40	7,431	2,675	0.60	2.40	6,900	2,484	0.60	2.40	6,369	2,293	0.60	2.40

Maximum depth of cut

