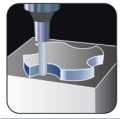


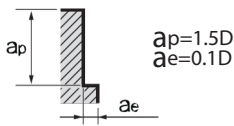
High performance 4 flute carbide roughing end mill

PROFILING

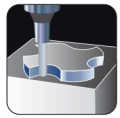


		HYP-HP-WRESF									
		Cast Iron		Mild Steels Carbon Steels		Pre-hardened Steels / Die & Alloy Steels				Hardened Steels / SUS 304	
				< 180 HB		< 30 HRC		< 38 HRC		< 45 HRC	
Vc		80 m/min		80 m/min		70 m/min		55 m/min		m/min	
Ø	Speed (min- ¹)	Feed (mm/min.)	Speed (min- ¹)	Feed (mm/min.)	Speed (min- ¹)	Feed (mm/min.)	Speed (min- ¹)	Feed (mm/min.)	Speed (min- ¹)	Feed (mm/min.)	
6	4,200	585	4,200	585	3,700	370	2,900	230	2,650	210	
8	3,150	565	3,150	565	2,750	350	2,150	230	1,950	210	
10	2,500	500	2,500	500	2,200	350	1,750	230	1,550	210	
12	2,100	500	2,100	500	1,850	330	1,450	230	1,300	210	
16	1,550	400	1,550	400	1,350	320	1,050	230	995	210	
20	1,250	375	1,250	375	1,100	320	875	240	795	220	
25	870	300	870	300	830	295	640	220	575	200	

Maximum depth of cut



SLOTTING



		HYP-HP-WRESF									
		Cast Iron		Mild Steels Carbon Steels		Pre-hardened Steels / Die & Alloy Steels				Hardened Steels / SUS 304	
				< 180 HB		< 30 HRC		< 38 HRC		< 45 HRC	
Vc		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	3,150	315	3,150	315	2,650	265	2,300	180	2,100	165	
8	2,350	300	2,350	300	1,950	250	1,750	175	1,550	155	
10	1,900	300	1,900	300	1,550	245	1,400	165	1,250	150	
12	1,550	280	1,550	280	1,300	235	1,150	160	1,050	145	
16	1,150	280	1,150	280	995	235	875	140	795	125	
20	955	280	955	280	795	235	700	140	635	125	
25	700	245	700	245	640	225	510	125	460	115	

Maximum depth of cut

