



## Roughing and Finishing Radius End Mill

- Variable pitch & helix / • Center Cutting / • 4 Flutes



**Ideal for machining**

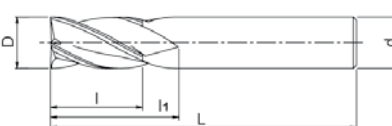
- **Stainless Steels** ■ **Titanium**

# HYP-HI-EMS

## Roughing and Finishing End Mill

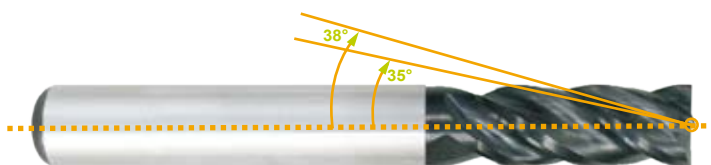
HYP-HI-EMS

**NEW**



	EDP	D	L	l	l1	d	£
<b>NEW</b>	48320040	4	57	11	-	-	£25.36
<b>NEW</b>	48320050	5	57	13	-	-	£25.36
<b>NEW</b>	48320060	6	57	13	20	5,8	£31.67
<b>NEW</b>	48320080	8	63	19	25	7,8	£33.92
<b>NEW</b>	48320100	10	72	22	30	9,8	£49.44
<b>NEW</b>	48320120	12	83	26	38	11,8	£67.20
<b>NEW</b>	48320160	16	92	32	45	15,8	£99.08
<b>NEW</b>	48320200	20	104	38	60	19,8	£146.16

Vc (m/min)	Low carbon - Alloy - Tool Steel									GG-GGG-GTW			Stainless steel			Aluminium - Mg			Ti - Alloys		
	HB150-250			HRC 20 - 30			HRC 30 - 40			>HB 180			HRC20			Non - alloyed			HRC40 - 50		
	500-800 N/mm <sup>2</sup>			800-1000 N/mm <sup>2</sup>			1000-1300 N/mm <sup>2</sup>			Non - alloyed			400 - 700 N/mm <sup>2</sup>			Non - alloyed			Exotic material		
	160			120			100			140			50			180			65		
d	fz	S=n	F=Vf	fz	S=n	F=Vf	fz	S=n	F=Vf	fz	S=n	F=Vf	fz	S=n	F=Vf	fz	S=n	F=Vf	fz	S=n	F=Vf
4.0	0.035	12,730	1,790	0.030	9,550	1,150	0.030	7,960	960	0.035	11,150	1,570	0.030	3,980	480	0.035	14,330	2,010	0.025	5,180	520
6.0	0.040	8,490	1,360	0.035	6,370	900	0.035	5,310	750	0.040	7,430	1,190	0.035	2,660	380	0.040	9,550	1,530	0.027	3,450	380
8.0	0.070	6,370	1,790	0.065	4,780	1,250	0.065	3,980	1,040	0.070	5,580	1,570	0.065	1,990	520	0.070	7,170	2,010	0.031	2,590	330
10.0	0.100	5,090	2,040	0.080	3,820	1,230	0.080	3,190	1,030	0.100	4,460	1,790	0.080	1,600	520	0.100	5,730	2,300	0.038	2,070	320
12.0	0.120	4,240	2,040	0.100	3,190	1,280	0.100	2,660	1,070	0.120	3,720	1,790	0.100	1,330	540	0.120	4,780	2,300	0.045	1,730	320
16.0	0.130	3,180	1,660	0.120	2,390	1,150	0.120	1,990	960	0.130	2,790	1,460	0.120	1,000	480	0.130	3,590	1,870	0.052	1,300	280
20.0	0.150	2,550	1,530	0.120	1,910	920	0.120	1,600	770	0.150	2,230	1,340	0.120	800	390	0.150	2,870	1,730	0.059	1,040	250



- Carbide End Mills with better balance due to Variable Helix and Uneven Flute Spacing
- New TiAlN multi layered coating
- Excellent surface finish
- Increased Tool Life

ap x d	ap	Fakt.	ap	Fakt.	ap	Fakt.
with F(fz)	0.5	1.0	0.5	1.2	0.5	1.3
Correction	1.0	0.7	1.0	1.0	1.0	1.2
	1.5	0.5	1.5	0.7	1.5	1.0
	2.0	0.3	2.0	0.5	2.0	0.8

ae = 1 x d      ae = 0,5 x d      ae = 0,2 x d

The above stated application data is as per RED marked parameters.

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