

HGESW SERIES

HGESW-Mold Base Milling

- Perpendicularity maintained within 0.01mm;
- Surface roughness controlled under Ra 1.6 μ m;
- No visible chatter marks during extra-long edge machining.





HGESW 4-flutes Long Flute End Mill



φ D	D Tol. (mm)
8<D≤10	0~-0.015
10<D≤18	0~-0.018
D>18	0~-0.020

Unit : mm

Type No.	Dia.	Length of Cut	Overall Length	Shank Dia.
	φD	ℓ	L	φd
HGESW4080-40 08100	8	40	100	8
HGESW4100-45 10100	10	45	100	10
HGESW4100-55 10100	10	55	100	10
HGESW4120-50 12100	12	50	100	12
HGESW4120-55 12100	12	55	100	12
HGESW4160-70 16150	16	70	150	16
HGESW4200-75 20150	20	75	150	20

Cutting Parameter

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Workpiece	Carbon Steels、Alloy Steels (≤35HRC)				Pre-Hardened Steels (35-45HRC)			
	n min ⁻¹	Vf mm/min	ap mm	ae mm	n min ⁻¹	Vf mm/min	ap mm	ae mm
HGESW4060-25 0675	4000	2500	20	0.1	4000	2000	20	0.1
HGESW4080-32 0875	3500	2500	30	0.1	3000	2000	30	0.1
HGESW4080-40 08100	3500	1500	35	0.1	3000	1200	35	0.1
HGESW4100-45 10100	3000	1500	40	0.1	2750	1200	40	0.1
HGESW4120-55 12100	2500	1200	50	0.1	1800	1000	50	0.1
HGESW4160-70 16150	2000	1000	65	0.1	1500	800	65	0.1
HGESW4200-75 20150	1800	1000	70	0.1	1500	600	70	0.1

