

HSXEG 6-Flute Hard Milling End Mill



∅D	D Tol. (mm)
6<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
HSXEG6060 0660	6	18	60	6
HSXEG6060 0675	6	24	75	6
HSXEG6080 0860	8	20	60	8
HSXEG6080 0875	8	32	75	8
HSXEG6100 1075	10	30	75	10
HSXEG6100 10100	10	40	100	10
HSXEG6120 1275	12	32	75	12
HSXEG6120 12100	12	45	100	12
HSXEG6160 16100	16	40	100	16
HSXEG6160 16150	16	64	150	16
HSXEG6200 20100	20	45	100	20
HSXEG6200 20150	20	75	150	20

TABLE OF RECOMMENDED MILLING MATERIALS

○ Very suitable ○ Suitable

CARBON STEELS	ALLOY STEELS	PREHARDENED STEELS, HARDENED STEELS				STAINLESS STEELS	CAST IRON	COPPER ALLOYS	ALUMINUM ALLOY	GRAPHITE	TITANIUM ALLOY	HEAT RESISTANT ALLOYS	PLASTIC
PREHARDENED STEELS	TOOL STEELS						DUCTILE CAST IRON						
~40HRC		~45HRC	~55HRC	~60HRC	~65HRC	~35HRC	~350HB						
○		○	○	○	○	○	○	○			○	○	

Cutting Parameter

HSXEG 6-Flute Hard Milling End Mill Side Milling

Workpiece	Pre-Hardened Steels (35-45HRC)				Hardened Steels (45-55HRC)				Hardened Steels (55-65HRC)			
	n min ⁻¹	Vf mm/min	ap mm	ae mm	n min ⁻¹	Vf mm/min	ap mm	ae mm	n min ⁻¹	Vf mm/min	ap mm	ae mm
HSXEG6060	4500	2420	15	0.2	4000	870	15	0.1	3200	700	15	0.05
HSXEG6080	4000	2400	18	0.2	3500	900	18	0.1	2800	700	18	0.05
HSXEG6100	3500	2300	25	0.2	2800	850	25	0.1	2240	680	25	0.05
HSXEG6120	3000	2000	30	0.2	2500	800	30	0.1	2000	650	30	0.05
HSXEG6160	2400	2000	35	0.2	2200	750	35	0.1	1760	650	35	0.05
HSXEG6200	2200	1800	40	0.2	2000	700	40	0.1	1600	600	40	0.05