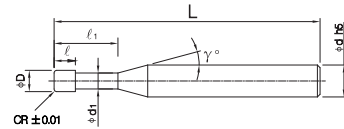


HSXRT 4 Flutes Power Corner Radius End Mill



∅ D	D Tol. [mm]
2 < D < 8	0 ~ -0.02
8 < D < 12	0 ~ -0.022

Unit : mm

Type No.	Dia.	Corner Radius	Length of Cut	Under Neck Length	Neck Dia.	Neck Taper Angle	Overall Length	Shank Dia.
	∅D	CR	ℓ	ℓ ₁	∅d ₁	γ/°	L	∅d
HSXRT4020R0.5 0650	2	R0.5	0.8	6	1.9	20	50	6
HSXRT4020R0.5-10 0650	2	R0.5	0.8	10	1.9	20	50	6
HSXRT4030R0.5 0650	3	R0.5	1.2	9	2.9	20	50	6
HSXRT4030R1.0 0650	3	R1.0	1.2	9	2.9	20	50	6
HSXRT4030R1.0-15 0660	3	R1.0	1.2	15	2.9	20	60	6
HSXRT4040R0.5 0650	4	R0.5	1.6	12	3.8	20	50	6
HSXRT4040R1.0 0650	4	R1.0	1.6	12	3.8	20	50	6
HSXRT4040R1.0-20 0660	4	R1.0	1.6	20	3.8	20	60	6
HSXRT4050R1.0 0660	5	R1.0	2	15	4.7	20	60	6
HSXRT4050R1.0-25 0675	5	R1.0	2	25	4.7	20	75	6
HSXRT4060R1.0 0660	6	R1.0	2.5	18	5.6	-	60	6
HSXRT4060R1.5 0660	6	R1.5	2.5	18	5.6	-	60	6
HSXRT4060R1.5-30 0675	6	R1.5	2.5	30	5.6	-	75	6
HSXRT4080R1.0 0875	8	R1.0	3.5	24	7.6	-	75	8
HSXRT4080R1.0 08100	8	R1.0	3.5	24	7.6	-	100	8
HSXRT4080R2.0 0875	8	R2.0	3.5	24	7.6	-	75	8
HSXRT4080R2.0 08100	8	R2.0	3.5	24	7.6	-	100	8
HSXRT4080R2.0-40 08100	8	R2.0	3.5	40	7.6	-	100	8
HSXRT4100R1.0 1075	10	R1.0	4	30	9.5	-	75	10
HSXRT4100R1.0 10100	10	R1.0	4	30	9.5	-	100	10
HSXRT4100R2.0 1075	10	R2.0	4	30	9.5	-	75	10
HSXRT4100R2.0 10100	10	R2.0	4	30	9.5	-	100	10
HSXRT4100R2.0-50 10100	10	R2.0	4	50	9.5	-	100	10
HSXRT4120R2.0 12100	12	R2.0	5	36	11.5	-	100	12
HSXRT4120R3.0 12100	12	R3.0	5	36	11.5	-	100	12
HSXRT4120R2.0-60 12125	12	R2.0	5	60	11.5	-	125	12

Cutting Parameter

HSXRT 4 Flutes Power Corner Radius End Mill Face Milling Roughing

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
HSXRT4020R0.5 0650	12600	2200	0.1	0.5	11520	2000	0.08	0.5	8000	1000	0.05	0.5
HSXRT4030R1.0 0650	11056	2500	0.1	0.8	9828	2500	0.1	0.8	7200	1200	0.1	0.8
HSXRT4040R1.0 0650	8712	2800	0.15	1.5	7744	2800	0.1	1.5	6000	1400	0.1	1.5
HSXRT4050R1.0 0660	7200	3500	0.2	2	6400	3000	0.1	2	5600	1500	0.1	2
HSXRT4060R1.5 0660	6543	4000	0.2	2	5808	3200	0.2	2	4500	1800	0.1	2
HSXRT4080R2.0 0875	5445	4500	0.2	2.7	5000	3500	0.2	2.7	3500	1600	0.1	2.7
HSXRT4100R2.0 1075	4900	4200	0.3	4	4500	3500	0.2	4	2860	1600	0.1	4
HSXRT4120R2.0 12100	4356	4000	0.3	5	4000	3200	0.2	5	2200	1500	0.1	5

● For Z-level and face milling, the recommended axial depth of cut (ap) is 0.3 × CR.

TABLE OF RECOMMENDED MILLING MATERIALS

○ Very suitable ○ Suitable

CARBON STEELS	ALLOY STEELS	PRE-HARDENED STEELS	HARDENED STEELS				CAST IRON DUCTILE CAST IRON	COPPER ALLOYS	ALUMINUM ALLOY	GRAPHITE	TITANIUM ALLOY	HEAT RESISTANT ALLOYS	PLASTIC
			~55HRC	~60HRC	~65HRC	~70HRC							
		○	○	○	○	○	○						