

Dimensions

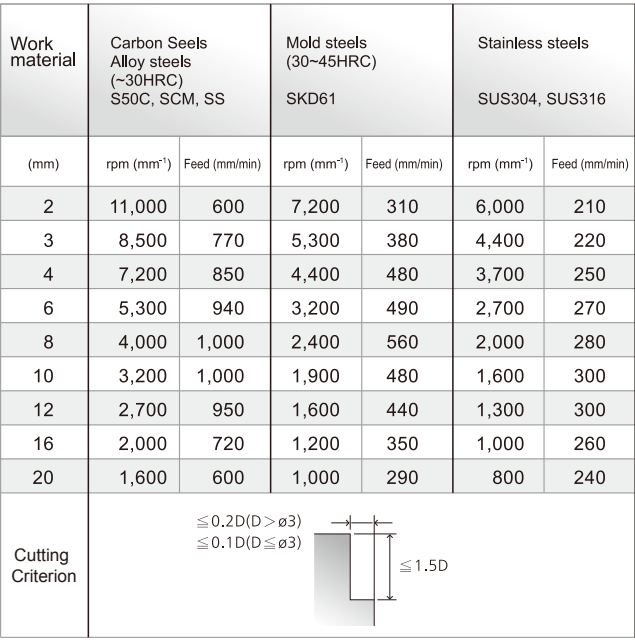


MODE	d	ℓ	L	D	Z
HPSS 0200	2	4	50	6	3
HPSS 0250	2.5	5	50	6	3
HPSS 0300	3	6	50	6	3
HPSS 0350	3.5	8	50	6	3
HPSS 0400	4	8	50	6	3
HPSS 0450	4.5	10	50	6	3
HPSS 0500	5	10	50	6	3
HPSS 0550	5.5	13	50	6	3
HPSS 0600	6	13	60	6	3
HPSS 0650	6.5	16	60	8	3
HPSS 0700	7	16	60	8	3
HPSS 0750	7.5	16	60	8	3
HPSS 0800	8	19	60	8	3
HPSS 0850	8.5	19	75	10	3
HPSS 0900	9	19	75	10	3
HPSS 0950	9.5	19	75	10	3
HPSS 1000	10	22	75	10	3
HPSS 1100	11	22	75	12	3
HPSS 1200	12	26	100	12	3
HPSS 1300	13	26	100	14	3
HPSS 1400	14	26	100	14	3
HPSS 1500	15	26	100	16	3
HPSS 1600	16	30	100	16	3
HPSS 2000	20	32	100	20	3

- The tool exhibits its power to various materials from mild steel to pre-hardened steel (45 HRC class)
- Especially for carbon steel cutting, this tool shows incomparably longer life than with the tool of conventional type (4 times or more longer than of a general TiAlN material)
- AlTiCrN Highly accurate finish cutting is possible

Recommended milling conditions

| Side mill |



Plung mill

Work material	Carbon Steels Alloy steels (~30HRC) S50C, SCM, SS		Mold steels (30~45HRC) SKD61		Stainless steels SUS304, SUS316	
	(mm)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)
2	11,000	500	7,200	260	6,000	130
3	8,500	640	5,300	320	4,200	130
4	7,200	650	4,400	370	3,400	140
6	5,300	720	3,200	380	2,200	140
8	4,000	780	2,400	430	1,600	140
10	3,200	770	1,900	370	1,300	150
12	2,700	730	1,600	340	1,100	150
16	2,000	600	1,200	290	800	130
20	1,600	500	1,000	240	640	120

Cutting Criterion

Diagram illustrating the cutting criterion for a square end mill. The width is labeled D, and the height is labeled ≤ 1D.

Diagram illustrating the cutting criterion for a square end mill. The width is labeled D, and the height is labeled ≤ 0.5D.

Work material	Carbon Steels Alloy steels (~30HRC) S50C, SCM, SS		Mold steels (30~45HRC) SKD61		Stainless steels SUS304, SUS316	
	(mm)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)
2	11,000	200	7,200	140	6,000	30
3	8,500	250	5,300	180	4,400	50
4	7,200	300	4,400	210	3,700	60
6	5,300	300	3,200	210	2,700	70
8	4,000	320	2,400	220	2,000	80
10	3,200	340	1,900	240	1,600	70
12	2,700	320	1,600	220	1,300	70
16	2,000	250	1,200	180	1,000	55
20	1,600	200	1,000	140	800	55
Cutting Criterion	