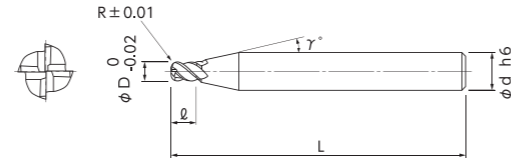
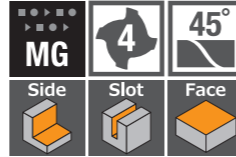


MUGEN COATING PREMIUM 4-Flute Corner Radius End Mill for Hardened Steel Total 6 sizes

Recommended Milling Conditions

4-flute high helix angle corner radius end mill for hardened steels up to 65HRC



- Realized stably long tool life against high hardened steels (48~65HRC).
- Corner radius to prevent flute chipping, and high helix angle for cutting sharpness.

Unit : mm

Code No.	Dia. (D)	Corner Radius (R)	Length of Cut (L)	Neck Taper Angle (γ)	Shank Dia. (d)	Overall Length (L)
08-00437-03002	3	R0.2	6	12°	6	60
08-00437-03003		R0.3	6	12°	6	60
08-00437-03005		R0.5	6	12°	6	60
08-00437-04002	4	R0.2	8	12°	6	60
08-00437-04003		R0.3	8	12°	6	60
08-00437-04005		R0.5	8	12°	6	60

**How to Order** When you order, indicate MHDH445R (D)×(R). ※(γ) is reference value.

Work Material	Hardened Steels HPM38·STAVAX·SKD61 (~55HRC)				Hardened Steels SKD11 (~62HRC)				High Speed Steels SKH (~65HRC)			
	Side Milling		Slotting		Side Milling		Slotting		Side Milling		Slotting	
	Spindle Speed	Feed	Spindle Speed	Feed	Spindle Speed	Feed	Spindle Speed	Feed	Spindle Speed	Feed	Spindle Speed	Feed
	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min
3	10,000	1,000	8,000	580	8,000	700	7,500	500	7,000	560	6,000	280
4	8,500	1,200	7,500	620	7,000	800	6,000	540	6,000	600	5,000	300
Depth of Cut (D: Dia.)	Side Milling: 1.5D, 0.03D		Slotting: D, 0.02D		Side Milling: 1.5D, 0.02D		Slotting: D, 0.01D		Side Milling: 1.5D, 0.02D		Slotting: D, 0.01D	
Notes	※1 Use a rigid and precise machine and chuck holder. ※2 Adjust milling conditions according to the volume of Depth of Cut and rigidity of the machine. ※3 Adjust both spindle speed and feed at the same rate. ※4 Use oilmist coolant.											