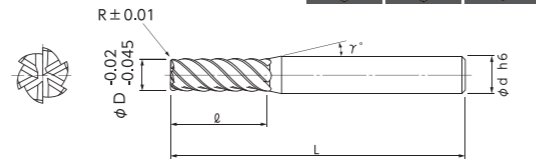
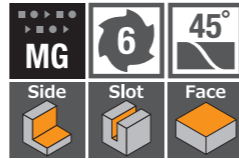


MUGEN COATING PREMIUM 6-Flute Corner Radius End Mill for Hardened Steel Total 21 sizes

Recommended Milling Conditions

6-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)
08-00438-05002	5	R0.2	10	12°	6	60
08-00438-05003		R0.3	10	12°	6	60
08-00438-05005		R0.5	10	12°	6	60
08-00438-05010		R1	10	12°	6	60
08-00438-06002	6	R0.2	12	—	6	60
08-00438-06003		R0.3	12	—	6	60
08-00438-06005		R0.5	12	—	6	60
08-00438-06010		R1	12	—	6	60
08-00438-08003	8	R0.3	16	—	8	65
08-00438-08005		R0.5	16	—	8	65
08-00438-08010		R1	16	—	8	65
08-00438-08015		R1.5	16	—	8	65
08-00438-10003	10	R0.3	20	—	10	75
08-00438-10005		R0.5	20	—	10	75
08-00438-10010		R1	20	—	10	75
08-00438-10015		R1.5	20	—	10	75
08-00438-10020	12	R2	20	—	10	75
08-00438-12005		R0.5	24	—	12	80
08-00438-12010		R1	24	—	12	80
08-00438-12015		R1.5	24	—	12	80
08-00438-12020	R2	24	—	12	80	

**How to Order**

When you order, indicate MHDH645R (D)×(R). ※(γ) is reference value.

Work Material	Hardened Steels HPM38·STAVAX·SKD61 (~55HRC)				Hardened Steels SKD11 (~62HRC)				High Speed Tool 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
Dia.	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
5	7,600	1,600	6,800	900	6,200	1,200	5,600	600	5,300	800	4,800	350
6	6,400	1,800	5,800	950	5,300	1,200	4,800	600	4,600	800	4,200	350
8	4,800	2,000	4,300	1,000	4,000	1,400	3,600	700	3,400	1,000	3,000	400
10	3,800	2,000	3,400	1,000	3,200	1,600	2,800	800	2,600	1,000	2,300	500
12	3,200	2,000	2,800	1,000	2,600	1,600	2,300	800	2,200	1,000	2,000	500
Depth of Cut (D: Dia.)	Side Milling 		Slotting 		Side Milling 		Slotting 		Side Milling 		Slotting 	
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 oil mist coolant.											