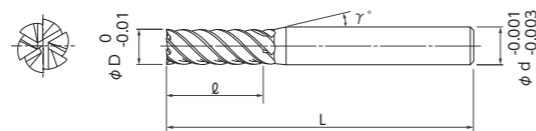
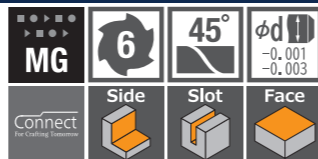


MUGEN COATING PREMIUM Plus 6-Flute Square End Mill for Hardened Steel Total 4 sizes

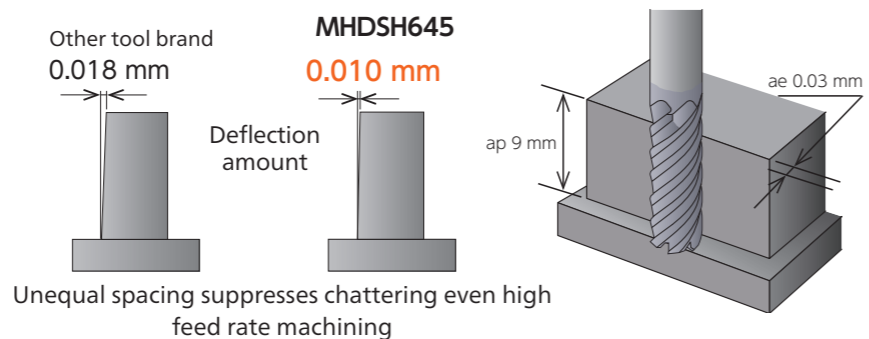
Recommended Milling Conditions

High rigidity tool design suppresses deflection and realizes long tool life on machining 70HRC hardened steel



Leaflet

- 6-flute is lineup of length of cut expands 2D and 3D.
- MUGEN COATING PREMIUM Plus realizes long tool life even for hardened steel up to 70HRC.
- High rigidity tool design improves machining accuracy.



Unequal spacing suppresses chattering even high feed rate machining

Unit : mm

Code No.	Dia. (D)	Length of Cut (l)	Neck Taper Angle (γ)	Shank Dia. (d)	Overall Length (L)
08-00430-00502	5	10	12°	6	60
08-00430-00503		15	12°	6	65
08-00430-00602	6	12	-	6	60
08-00430-00603		18	-	6	65

How to Order When you order, indicate MHDSH645(D)x(l). ※(γ) is reference value.

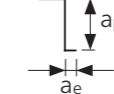
Machining case S-016

Work Material	High Speed Steels / Hardened Steels SKH51・SKD11 (~62HRC)						High Speed Steels SKH55・HAP40 (~66HRC)				High Speed Steels SKH57・HAP72 (~70HRC)			
	Dia.	Length of Cut	Spindle Speed	Feed	Depth of Cut		Spindle Speed	Feed	Depth of Cut		Spindle Speed	Feed	Depth of Cut	
			min ⁻¹	mm/min	ap mm	ae mm	min ⁻¹	mm/min	ap mm	ae mm	min ⁻¹	mm/min	ap mm	ae mm
Side milling	5	10	6,200	1,200	7.5	0.1	5,300	800	7.5	0.1	4,600	560	7.5	0.1
		15	5,600	1,000	7.5	0.1	4,800	600	7.5	0.1	4,200	480	7.5	0.1
	6	12	5,300	1,200	9	0.12	4,600	800	9	0.12	4,000	560	9	0.12
		18	4,800	1,000	9	0.12	4,200	600	9	0.12	3,600	480	9	0.12
Slotting	5	10	5,600	600	0.1	-	4,800	350	0.05	-	4,000	200	0.05	-
		15	5,000	400	0.1	-	4,200	200	0.05	-	3,600	120	0.05	-
	6	12	4,800	600	0.12	-	4,200	350	0.06	-	3,600	200	0.06	-
		18	4,200	400	0.12	-	3,600	200	0.06	-	3,200	120	0.06	-

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.

Side Milling



Slotting

