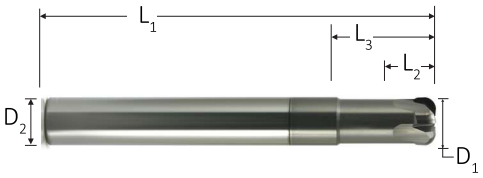
SERIES: HXMG2 & HXMG4

MATERIAL		AXIAL DEPTH MAX & 75% CUTTING WIDTH 1/8	1/4	3/8	1/2	5/8	SFM	CUTTING DIAMETER 1/8"	1/4"	3/8"	1/2"	5/8"
STAINLESS STEELS	**ISO-M**	**CONDITION**						**CHIP PER TOOTH**				
Precipitation <35 HRc												
13-8, 15-5, 17-4PH		0.007	0.011	0.018	0.022	0.026	600-900	.005-.008	.006-.012	.010-.018	.012-.024	.014-.026
Precipitation >35 HRc												
13-8, 15-5, 17-4PH		0.006	0.009	0.014	0.017	0.022	325-650	.003-.007	.006-.012	.010-.018	.012-.024	.012-.024
Austenitic < 28 HRc												
302, 303, 304L, 316L		0.007	0.010	0.015	0.022	0.026	275-400	.005-.009	.006-.014	.010-.019	.012-.026	.012-.026
STEELS	**ISO-P**											
High Strength Steels												
4140, 4340, 52100		0.007	0.011	0.018	0.022	0.026	600-1250	.005-.008	.006-.013	.010-.020	.012-.025	.014-.028
High Alloy Steels - Mold & Die <50 HRc												
A-2, P20, 01, 02, D2, H-13		0.007	0.010	0.017	0.020	0.022	600-1200	.005-.008	.006-.012	.010-.018	.012-.022	.014-.024
High Alloy Steels - Mold & Die >50 HRc												
A-2, P20, 01, 02, D2, H-13		0.006	0.009	0.013	0.018	0.020	275-675	.004-.006	.006-.012	.010-.018	.012-.022	.014-.024
Medium Alloy Steels												
200, 250, 300		0.008	0.012	0.019	0.025	0.028	800-1475	.005-.009	.006-.014	.010-.021	.012-.026	.014-.028
CAST IRONS	**ISO-K**											
Cast Iron <40 HRc		0.006	0.010	0.016	0.020	0.022	1000-3000	.003-.006	.006-.011	.009-.016	.012-.022	.012-.024
Cast Iron >40 HRc		0.006	0.010	0.016	0.020	0.022	800-1200	.003-.006	.006-.011	.009-.016	.012-.022	.012-.024
TITANIUM	**ISO-S**											
Titanium Alloys												
6AL-4V, ASTM 1, 2, 3, 6AL-2S		0.006	0.010	0.016	0.020	0.022	400-600	.003-.006	.006-.011	.009-.016	.012-.022	.012-.024

MATERIAL		AXIAL DEPTH MAX & 75% CUTTING WIDTH 3mm	6mm	8mm	10mm	12mm	M/MIN	CUTTING DIAMETER-METRIC 3mm	6mm	8mm	10mm	12mm
STAINLESS STEELS	**ISO-M**	**CONDITION**						**CHIP PER TOOTH**				
Precipitation <35 HRc												
13-8, 15-5, 17-4PH		0.170	0.260	0.370	0.480	0.530	180-275	.13-.20	.15-.30	.20-.46	.25-.46	.30-.61
Precipitation >35 HRc												
13-8, 15-5, 17-4PH		0.140	0.210	0.290	0.370	0.410	100-200	.08-.18	.15-.30	.20-.46	.25-.46	.30-.61
Austenitic < 28 HRc												
302, 303, 304L, 316L		0.170	0.240	0.320	0.400	0.530	85-120	.13-.23	.15-.36	.20-.50	.25-.48	.30-.63
STEELS	**ISO-P**											
High Strength Steels												
4140, 4340, 52100		0.170	0.260	0.370	0.480	0.530	185-380	.13-.20	.15-.33	.20-.48	.25-.50	.30-.63
High Alloy Steels - Mold & Die <50 HRc												
A-2, P20, 01, 02, D2, H-13		0.190	0.290	0.400	0.510	0.600	245-450	.13-.23	.15-.36	.20-.50	.25-.53	.30-.64
High Alloy Steels - Mold & Die >50 HRc												
A-2, P20, 01, 02, D2, H-13		0.170	0.240	0.350	0.450	0.480	185-360	.13-.20	.15-.30	.20-.43	.25-.46	.30-.56
Medium Alloy Steels												
200, 250, 300		0.140	0.210	0.280	0.350	0.430	85-205	.10-.15	.15-.30	.20-.43	.25-.46	.30-.56
CAST IRONS	**ISO-K**											
Cast Iron <40 HRc		0.140	0.240	0.330	0.430	0.480	300-900	.08-.15	.15-.25	.19-.41	.23-.41	.30-.56
Cast Iron >40 HRc		0.140	0.240	0.330	0.430	0.480	245-365	.08-.15	.15-.25	.19-.41	.23-.41	.30-.56
TITANIUM	**ISO-S**											
Titanium Alloys												
6AL-4V, ASTM 1, 2, 3, 6AL-2S		0.140	0.240	0.330	0.430	0.480	120-180	.08-.15	.15-.25	.19-.41	.23-.41	.30-.56

Note: All technical data provided are suggested starting points. They may be increase or decreased depending on machine condition, depth of cut, finish required, coolant, etc. Call our TECHNICAL SERVICE Team with questions



4 FLUTE • HIGH FEED CARBIDE END MILL

Carbide | 4 | Center Cutting | variable | nACRo | +.000 -.002 | Radius | HRc <56 | P K M S

- Designed for use in High Feed milling processes that reduce total machining time by 3-4 times over conventional methods.
- Enables high feed per tooth with shallow depth of cut for highest metal removal rates
- Cutting forces are directed at the machine spindle in the axial direction which means less vibration and greater tool life.
- Especially suited for small molds and medical work

SERIES: HXMG4

DIA D_1	SHK D_2	LOC L_2	LBS L_3	OAL L_1	CORNER	FLUTE	PART NAME	nACRo EDP
3/32	1/4	0.090	0.500	3	0.023	4	HXMG4-803	14550
1/8	1/4	0.095	0.650	3	0.031	4	HXMG4-804	14551
3/16	1/4	0.125	0.750	3	0.047	4	HXMG4-806	14552
1/4	1/4	0.150	1.000	3	0.062	4	HXMG4-808	14546
5/16	5/16	0.155	1.187	3	0.078	4	HXMG4-1010	14554
3/8	3/8	0.175	1.250	4	0.094	4	HXMG4-1212	14548
1/2	1/2	0.200	1.500	4	0.125	4	HXMG4-1616	14549
5/8	5/8	0.250	1.500	4	0.156	4	HXMG4-2020	14852

Speed & Feed: page 163

4 FLUTE • HIGH FEED CARBIDE END MILL

Carbide | 4 | Center Cutting | variable | nACRo | +.000mm -.050mm | Radius | HRc <56 | P K M S

SERIES: HXMG4-M_M_ (metric)

DIA D_1	SHK D_2	LOC L_2	LBS L_3	OAL L_1	CORNER	FLUTE	PART NAME	nACRo EDP
2mm	6mm	2mm	12mm	75mm	0.5mm	4	HXMG4-M6M2	14843
3mm	6mm	2.8mm	16mm	75mm	0.75mm	4	HXMG4-M6M3	14844
4mm	6mm	3.5mm	20mm	75mm	1mm	4	HXMG4-M6M4	14845
5mm	6mm	3.5mm	20mm	75mm	1.25mm	4	HXMG4-M6M5	14846
6mm	6mm	3.8mm	25mm	75mm	1.5mm	4	HXMG4-M6M6	14847
8mm	8mm	4mm	30mm	75mm	2mm	4	HXMG4-M8M8	14848
10mm	10mm	4.3mm	33mm	100mm	2.5mm	4	HXMG4-M10M10	14849
12mm	12mm	4.6mm	38mm	100mm	3mm	4	HXMG4-M12M12	14850

Speed & Feed: page 163