

## HSSCo8 & HSS, 4FLUTE MINIATURE LONG LENGTH DOUBLE

► Suitable for finishing of precision components such as watch, camera electronic apparatus molds, etc.



HSS Co8
HSS
4
39°
30°
PLAIN
P.886

~03/32    Ø7/64~

Unit : Inch

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
8% COBALT (M42)	HSS (M2)				
54256	54006	1/16	3/16	7/32	2-1/2
54258	54008	5/64	3/16	1/4	2-1/2
54260	54010	3/32	3/16	9/32	2-5/8
54262	54012	7/64	3/16	9/32	2-5/8
54264	54014	1/8	3/16	3/4	3-1/8
54266	54016	9/64	3/16	3/4	3-1/8
54268	54018	5/32	3/16	7/8	3-1/4
54270	54020	11/64	3/16	7/8	3-1/4
54272	54022	3/16	3/16	1	3-3/8

- The TiN coated, TiCN coated or TiAlN coated is available on your request.
- Coating Codes for Cobalt  
Uncoated EDP NO. + CN(TiN), CC(TiCN), CF(TiAlN F), CE(TiAlN E), CH(Hardslick)
- Coating Codes for HSS  
Uncoated EDP NO. + HN(TiN), HC(TiCN), HF(TiAlN F), HE(TiAlN E), HH(Hardslick)
- Coated Price Shown in Price List. Call for Availability.

Mill Dia. Tolerance (inch)	
0~+.0010	* * 0~- .0020

\*\*The shank of end mills is the same diameter as the cutting portion.

◎ : Excellent    ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HRc20	HRc20~30	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
◎	◎	○				○			○			

CBN  
END MILL

i-Xmill  
END MILL

X5070  
END MILLS

4G MILLS  
END MILLS

X-SPEED  
ROUGHER  
END MILLS

X-POWER  
END MILLS

JET-POWER  
END MILLS

V7 Mill STEEL  
END MILLS

V7 Mill INOX  
END MILLS

ALU-POWER  
END MILLS

D-POWER  
END MILLS

STANDARD  
CARBIDE  
END MILLS

TANK-POWER  
END MILLS

STANDARD  
COBALT  
& HSS  
END MILLS

TECHNICAL  
DATA

HSSCo8 & HSS, MULTI FLUTE ROUGHING & FINISHING - SIDE CUTTING

CBN END MILL

i-Xmill END MILL

X5070 END MILLS

4G MILLS END MILLS

X-SPEED ROUGHER END MILLS

X-POWER END MILLS

JET-POWER END MILLS

V7 Mill STEEL END MILLS

V7 Mill INOX END MILLS

ALU-POWER END MILLS

D-POWER END MILLS

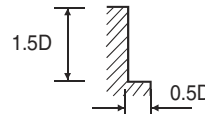
STANDARD CARBIDE END MILLS

TANK-POWER END MILLS

STANDARD COBALT & HSS END MILLS

TECHNICAL DATA

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		ALUMINUM ALUMINUM ALLOYS	
	~ 500N/mm <sup>2</sup>		500~800N/mm <sup>2</sup>		800~1000N/mm <sup>2</sup>		1000~1300N/mm <sup>2</sup>			
HARDNESS			~HRc20		HRc20~HRc30		HRc30~HRc40			
STRENGTH										
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/4	1800	2.5	1300	2.0	1200	1.8	800	1.0	4500	6.3
5/16	1400	3.4	1100	2.4	900	2.2	560	1.2	3100	7.3
3/8	1100	4.7	900	3.7	800	3.5	450	2.0	2500	11.0
1/2	900	5.7	800	4.3	630	3.5	400	2.2	2000	12.6
5/8	700	5.7	560	4.3	450	3.5	280	2.2	1600	14.2
11/16	630	5.7	500	4.3	400	3.5	250	2.2	1400	15.0
7/8	500	6.9	450	5.3	350	4.3	220	2.8	1100	15.0
1	450	6.9	400	5.3	310	4.3	180	2.8	1000	14.2
1-1/4	350	6.7	280	5.1	220	4.1	140	2.8	800	15.8
1-3/8	310	6.7	250	5.1	200	4.1	120	2.8	700	15.0
2	240	5.4	190	4.0	150	3.4	110	2.6	500	11.2



※ The Feed, in long & extra long types, should be reduced by around 50%.

RPM = rev./min.  
FEED = inch/min.

HSSCo8 & HSS, MINIATURE

MATERIAL	HIGH TENSILE STEELS MEDIUM STRENGTH STAINLESS STEELS MEDIUM STRENGTH TITANIUM SLOOYS		MEDIUM TENSILE STEELS UNALLOYED TITANIUM TOOL STEELS HEAT RESISTANT FERRITIC LOW ALLOYS		VILD STEEL FORGING HARD BRASS & BRONZE COPPER		ALUMINUM ALUMINUM ALLOYS PLASTIC WOODS		ALUMINUM ALUMINUM ALLOYS		
	DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/4	6600~8800	0.3	11000 up	0.5	11000 up	0.8	11000 up	1.2	11000 up	1.5	
1/32	3300~4400	0.5	5500~5600	0.6	7700~9900	1.6	11000 up	1.6	11000 up	2.5	
3/64	2200~2935	0.6	3665~4400	0.6	5135~6600	2.5	7335~8800	2.0	11000 up	2.6	
1/16	1650~2260	0.6	2750~3300	1.0	3350~4950	3.3	5500~6600	2.6	11000 up	4.2	
5/64	1320~1760	0.6	2200~2640	1.0	3850~3960	3.3	4400~5820	2.6	8500 up	4.2	
3/32	1100~1285	0.6	1835~2200	1.0	2565~3300	3.3	3665~4400	2.6	7330up	4.2	
7/64	345~1255	0.6	1570~1885	1.0	2200~2830	3.3	3140~3770	2.6	5625 up	4.3	
1/8	825~1100	0.6	1375~1650	1.0	1925~2475	3.3	2750~3300	2.8	5500 up	4.5	
9/64	735~980	0.6	1220~1465	1.0	1710~2200	3.4	2445~3770	2.8	4890~9780	4.5	
5/32	560~880	0.8	1100~1320	1.1	1540~1980	3.6	2205~2640	2.9	4400~8800	4.5	
11/64	600~800	0.9	1000~1200	1.2	1400~1800	3.7	2000~2400	3.0	4000~3000	4.6	
3/16	550~735	1.0	915~1100	1.4	1285~1650	3.3	1535~2200	3.3	3685~7335	4.7	

NOTES :

- (1) The cutting conditions in this table are given for reference, which should be varied depending on the machine, tooling, depth of cut, cutting fluid and other conditons.
- (2) Use a holder of strong gripping force and machine of high stiffness

RPM = rev./min.  
FEED = inch/min.