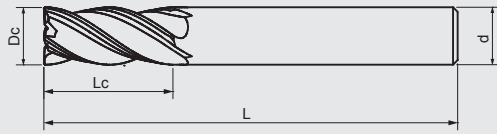


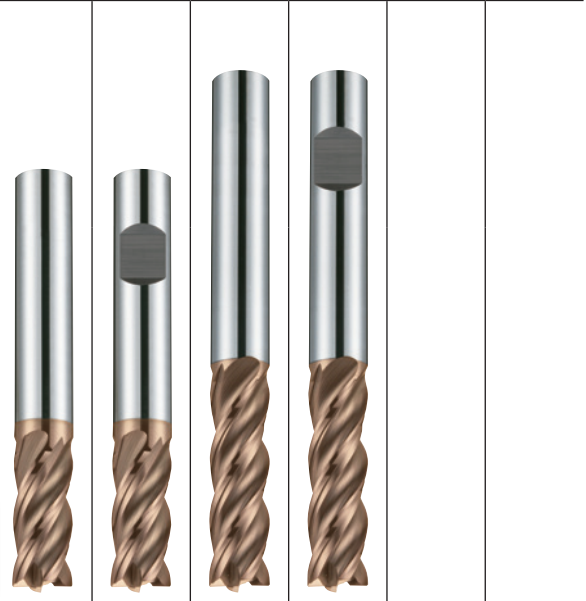
F604TX / F606TX

Finishing End Mills

With UMG carbide material is good for cutting hardened materials < 62HRC.
 Good wear resistance and lubricating effect with Nano multilayer coating.



VHM Carbide
AlTiSiN TX
35°
4
75°
0.05-0.2
45°
Steel <62HRC



With stronger strength of cutting edge is suitable for steels below 62HRC.
 Various application for finishing cutting

P H	P H	P H	P H
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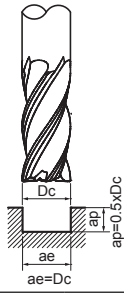
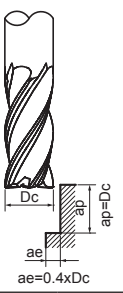
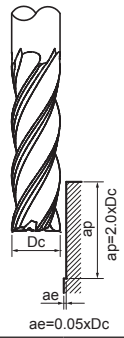
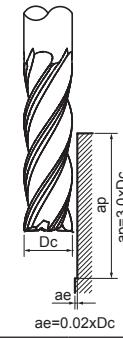
DIN 6527 Standard Length

Dc 0 -0.02	Lc mm	L mm	d h5	45° mm	F604TX HA	F604TX HB				
3	8	57	6	0.03	●	●				
4	11	57	6	0.04	●	●				
5	13	57	6	0.05	●	●				
6	13	57	6	0.06	●	●				
8	19	63	8	0.08	●	●				
10	22	72	10	0.10	●	●				
12	26	83	12	0.12	●	●				
16	32	92	16	0.16	●	●				
20	38	104	20	0.20	●	●				

Long Length

Dc 0 -0.02	Lc mm	L mm	d h5	45° mm			F606TX HA	F606TX HB		
3	12	63	6	0.03			●	●		
4	17	63	6	0.04			●	●		
5	19	63	6	0.05			●	●		
6	19	63	6	0.06			●	●		
8	28	72	8	0.08			●	●		
10	34	84	10	0.10			●	●		
12	40	97	12	0.12			●	●		
16	48	108	16	0.16			●	●		
20	56	122	20	0.20			●	●		

Cutting Conditions

	F504TX		F504TX		F506TX		F506TX		
	cutting speed Vc (m/min)	feed per tooth fz (mm)	cutting speed Vc (m/min)	feed per tooth fz (mm)	cutting speed Vc (m/min)	feed per tooth fz (mm)	cutting speed Vc (m/min)	feed per tooth fz (mm)	
F604TX F606TX									
Carbon Steel Materials									
P	GR1 Carbon Steel	120	0.004xDc	120	0.005xDc	130	0.005xDc	140	0.004xDc
	GR2 <24HRC Low-alloyed Steel	120	0.003xDc	120	0.004xDc	130	0.004xDc	140	0.003xDc
	GR3 <30HRC Hi-alloyed Steel	80	0.003xDc	80	0.003xDc	90	0.003xDc	100	0.003xDc
Hardened Steel Materials									
H	GR4 30-38HRC Hardened Steel	65	0.002xDc	65	0.002xDc	65	0.002xDc	70	0.002xDc
	GR5 38-48HRC Hardened Steel	60	0.0018xDc	60	0.0018xDc	60	0.0018xDc	65	0.0018xDc
	GR6 48-56HRC Hardened Steel	55	0.0015xDc	55	0.0015xDc	55	0.0015xDc	60	0.0015xDc

All cutting data serve for orientation only and should be adapted individually to the technical conditions on location

1. Please work with good rigidity / high precision facilities and collet chuck.
2. Please choose proper cutting fluid.
3. The cutting data is reference value only. Please adjust it according to your real working conditions.
4. If RPM is lower the reference value, the Feed rate [fz] and RPM should be reduced by the same proportion.
5. If vibration occurs during cutting, please reduce cutting parameter.