

F623HX / F624HX

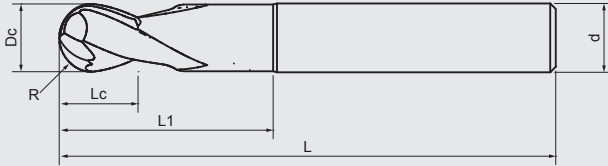
Ball Nose End Mills

Designed with S-style ball nose geometry.

Reduce surface cutting resistance.

Good wear resistance and lubricating effect with Nano multilayer coating

With MG carbide material is good for cutting materials < 48HRC.

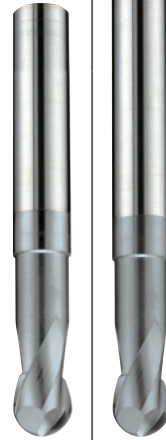


VHM
Carbide

AlTiCrN
HX



Steel
<48HRC



With sharp cutting edge is good for cutting different steels below 48HRC as well as cast iron.
Application for finishing profile cutting.



DIN 6527 Standard Length

Dc 0 -0.02	R ±0.005	Lc mm	L mm	d h5	L1 mm	D1 mm	F623HX AlTiCrN					
1	0.5R	1	50	6	3	0.95	●					
1.5	0.75R	2	50	6	4	1.4	●					
2	1R	3	57	6	6	1.9	●					
3	1.5R	4	57	6	9	2.8	●					
4	2R	5	57	6	12	3.7	●					
5	2.5R	6	57	6	15	4.6	●					
6	3R	7	57	6	20	5.5	●					
8	4R	9	63	8	26	7.4	●					
10	5R	11	72	10	31	9.2	●					
12	6R	13	83	12	37	11	●					

Long Length

Dc 0 -0.02	R ±0.005	Lc mm	L mm	d h5	L1 mm	D1 mm		F624HX AlTiCrN				
3	1.5R	4	70	6	9	2.8		●				
4	2R	5	70	6	12	3.7		●				
5	2R	6	80	6	15	4.6		●				
6	3R	7	80	6	20	5.5		●				
8	4R	9	100	8	26	7.4		●				
10	5R	11	100	10	31	9.2		●				
12	6R	13	110	12	37	11		●				

Cutting Conditions

	F623HX				F624HX				
	cutting speed Vc (m/min)	feed per tooth fz(mm)	ae	ap	cutting speed Vc (m/min)	feed per tooth fz(mm)	ae	ap	
P	Carbon Steel Materials								
	GR1 Carbon Steel	120	0.02xDc	0.2xDc	0.1xDc	120	0.023xDc	0.2xDc	0.1xDc
	GR2 <24HRC Low-alloyed Steel	110	0.02xDc	0.2xDc	0.1xDc	110	0.022xDc	0.2xDc	0.1xDc
	GR3 <30HRC Hi-alloyed Steel	100	0.018xDc	0.2xDc	0.1xDc	100	0.021xDc	0.2xDc	0.1xDc
H	Hardened Steel Materials								
	GR4 30-38HRC Hardened Steel	60	0.015xDc	0.02xDc	0.02xDc	60	0.015xDc	0.02xDc	0.02xDc
	GR5 38-48HRC Hardened Steel	55	0.012xDc	0.02xDc	0.02xDc	55	0.012xDc	0.02xDc	0.02xDc
K	Cast Iron Materials								
	GR9-1 Grey cast iron	120	0.02xDc	0.2xDc	0.1xDc	120	0.023xDc	0.2xDc	0.1xDc
	GR9-2 Nodular cast iron	120	0.02xDc	0.2xDc	0.1xDc	120	0.023xDc	0.2xDc	0.1xDc

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.