

## F625TX / F626TX

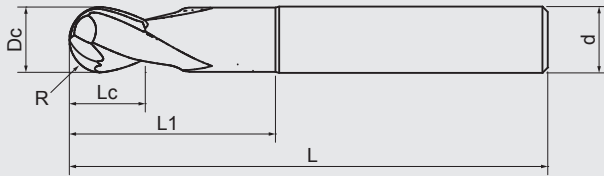
## Ball Nose End Mills

Designed with S-style ball nose geometry.

Reduce surface cutting resistance.

Good wear resistance and lubricating effect with Nano multilayer coating

With SMG carbide material is good for cutting hardened materials < 70HRC.

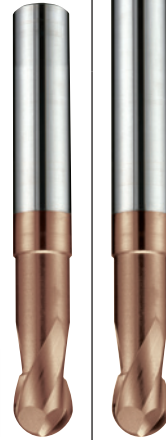


**VHM**  
Carbide

**AlTiSiN**  
TX



**Steel**  
40-70  
HRC



With stronger strength of cutting edge is suitable for hardened steels from 40-70HRC.

Application for finishing profile cutting.

H

H

## DIN 6527 Standard Length

Dc 0 -0.02	R ±0.005	Lc mm	L mm	d h5	L1 mm	D1 mm	F625TX AlTiSiN					
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		F626TX AlTiSiN				
3	1.5R	4	70	6	9	2.8		●				
4	2R	5	70	6	12	3.7		●				
5	2.5R	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

F625TX F626TX	F625TX				F626TX				
	cutting speed $V_c$ (m/min)	feed per tooth $f_z$ (mm)	$a_e$	$a_p$	cutting speed $V_c$ (m/min)	feed per tooth $f_z$ (mm)	$a_e$	$a_p$	
Hardened Steel Materials									
H	GR5 38-48HRC Hardened Steel	65	$0.015 \times D_c$	$0.02 \times D_c$	$0.02 \times D_c$	65	$0.015 \times D_c$	$0.02 \times D_c$	$0.02 \times D_c$
	GR6 48-56HRC Hardened Steel	60	$0.012 \times D_c$	$0.02 \times D_c$	$0.02 \times D_c$	60	$0.012 \times D_c$	$0.02 \times D_c$	$0.02 \times D_c$
	GR7 56-68HRC Hardened Steel	55	$0.011 \times D_c$	$0.02 \times D_c$	$0.02 \times D_c$	55	$0.011 \times D_c$	$0.02 \times D_c$	$0.02 \times D_c$

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 ( $f_z$ ) and RPM should be reduced by the same proportion.
5. If vibration occurs during cutting, please reduce cutting parameter.