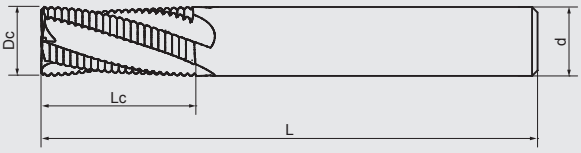
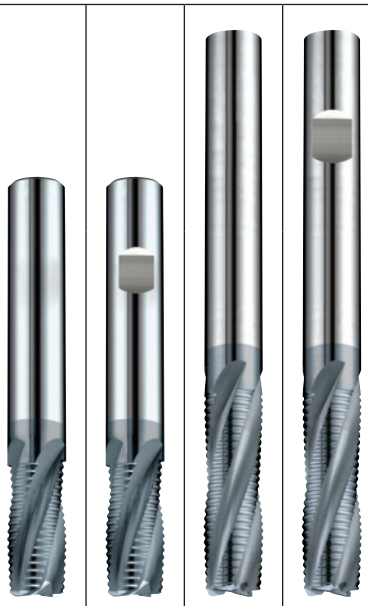
F608HX / F609HX

Roughing End Mills

Fine tooth staggered chip breaker design on cutting flutes are good for chip breaking.

Good wear resistance and lubricating effect with Nano multilayer coating.





Suitable for cutting different steel below 48HRC as well as cast iron.

Application for roughing cutting process.

P H K | P H K | P H K | P H K

DIN 6527 Standard Length

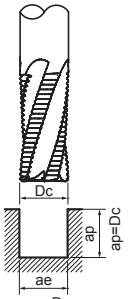
Dc h10	Lc mm	L mm	d h5	Z T	45° mm	F608HX HA	F608HX HB				
3	8	57	6	3	0.3	●	●				
4	11	57	6	3	0.3	●	●				
5	13	57	6	3	0.4	●	●				
6	13	57	6	3	0.4	●	●				
8	19	63	8	3	0.4	●	●				
10	22	72	10	4	0.5	●	●				
12	26	83	12	4	0.5	●	●				
14	26	83	14	4	0.5	●	●				
16	32	92	16	4	0.5	●	●				
18	32	92	18	4	0.5	●	●				
20	38	104	20	4	0.5	●	●				

Long Length

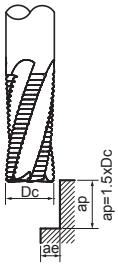
Dc h10	Lc mm	L mm	d h5	Z T	45° mm			F609HX HA	F609HX HB		
6	19	63	6	3	0.4			●	●		
8	28	72	8	3	0.4			●	●		
10	34	84	10	4	0.5			●	●		
12	40	97	12	4	0.5			●	●		
16	48	108	16	4	0.5			●	●		
20	56	122	20	4	0.5			●	●		

Cutting Conditions

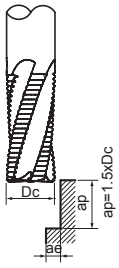
F608HX
F609HX



ae=Dc



ae=0.4xDc



ae=0.2xDc

		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)
		Carbon Steel Materials					
P	GR1 Carbon Steel	60	0.006xDc	70	0.006xDc	80	0.006xDc
P	GR2 <24HRC Low-alloyed Steel	60	0.005xDc	70	0.005xDc	80	0.005xDc
P	GR3 <30HRC Hi-alloyed Steel	50	0.005xDc	60	0.005xDc	70	0.005xDc
		Hardened Steel Materials					
H	GR4 30~38HRC Hardened Steel	45	0.003xDc	65	0.003xDc	70	0.003xDc
H	GR5 38~48HRC Hardened Steel	40	0.003xDc	60	0.003xDc	65	0.003xDc
		Cast Lron Materials					
K	GR9-1 Grey cast iron	60	0.006xDc	70	0.006xDc	80	0.006xDc
K	GR9-2 Nodular cast iron	60	0.006xDc	70	0.006xDc	80	0.006xDc

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.