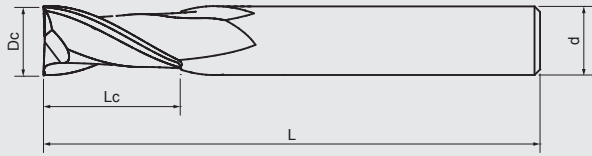


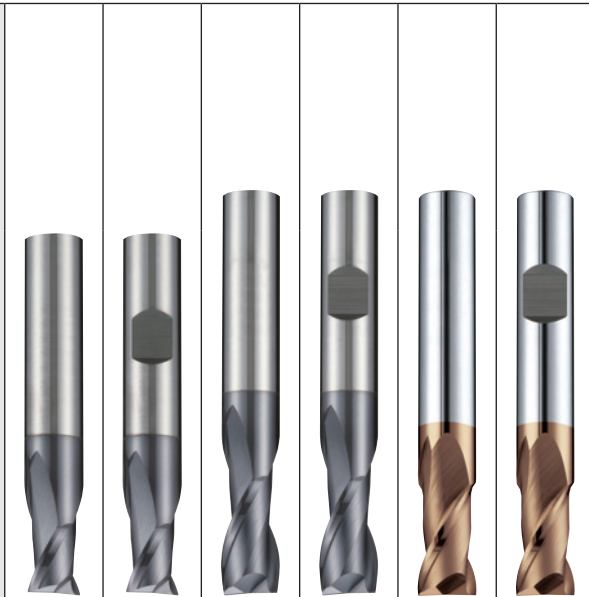
F500HX / F501HX / F602TX

Universal End Mills

F500HX / F501HX With MG carbide material is good for cutting materials < 48HRC.  
 F602TX With UMG carbide material is good for cutting hardened materials < 62HRC.  
 Good wear resistance and lubricating effect with Nano multilayer coating.



VHM Carbide  
 AlTiCrN HX  
 AlTiSiN TX  
 30°  
 2  
 N  
 0.05-0.2  
 45°



F500HX / F501HX With sharp cutting edge is good for cutting different steels below 48HRC as well as cast iron.  
 F602TX With stronger Strength of cutting edge is suitable for steels below 62HRC.  
 Various application for general cutting.

P H K	P H K	P H K	P H K	P H	P H
AlTiCrN <48HRC	AlTiCrN <48HRC	AlTiCrN <48HRC	AlTiCrN <48HRC	AlTiSiN <62HRC	AlTiSiN <62HRC

DIN 6527 Stub Length

Dc 0 -0.02	Lc mm	L mm	d h5	45° mm	F500HX HA	F500HX HB				
2	3	50	6	0.02	●	●				
3	4	50	6	0.03	●	●				
4	5	54	6	0.04	●	●				
5	6	54	6	0.05	●	●				
6	7	54	6	0.06	●	●				
8	9	58	8	0.08	●	●				
10	11	66	10	0.10	●	●				
12	12	73	12	0.12	●	●				
14	14	75	14	0.14	●	●				
16	16	82	16	0.16	●	●				
18	18	84	18	0.18	●	●				
20	20	92	20	0.20	●	●				

DIN 6527 Standard Length

Dc 0 -0.02	Lc mm	L mm	d h5	45° mm			F501HX HA	F501HX HB		
3	7	57	6	0.03			●	●		
4	8	57	6	0.04			●	●		
5	10	57	6	0.05			●	●		
6	10	57	6	0.06			●	●		
8	16	63	8	0.08			●	●		
10	19	72	10	0.10			●	●		
12	22	83	12	0.12			●	●		
14	22	83	14	0.14			●	●		
16	26	92	16	0.16			●	●		
18	26	92	18	0.18			●	●		
20	32	104	20	0.20			●	●		

DIN 6527 Standard Length

Dc 0 -0.02	Lc mm	L mm	d h5	45° mm					F602TX HA	F602TX HB
3	7	57	6	0.03					●	●
4	8	57	6	0.04					●	●
5	10	57	6	0.05					●	●
6	10	57	6	0.06					●	●
8	16	63	8	0.08					●	●
10	19	72	10	0.10					●	●
12	22	83	12	0.12					●	●
16	26	92	16	0.16					●	●
20	32	104	20	0.20					●	●

## Cutting Conditions

F500HX F501HX F602TX		F500HX		F500HX		F501HX		F501HX		F602TX		F602TX		F602TX	
		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)	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)
<b>Carbon Steel Materials</b>															
P	GR1 Carbon Steel	120	0.004xDc	120	0.005xDc	130	0.005xDc	140	0.006xDc	120	0.004xDc	120	0.005xDc	130	0.005xDc
	GR2 <24HRC Low-alloyed Steel	120	0.003xDc	120	0.004xDc	130	0.004xDc	140	0.005xDc	120	0.003xDc	120	0.004xDc	130	0.004xDc
	GR3 <30HRC Hi-alloyed Steel	80	0.003xDc	80	0.003xDc	90	0.003xDc	100	0.004xDc	80	0.003xDc	80	0.003xDc	90	0.003xDc
<b>Hardened Steel Materials</b>															
H	GR4 30-38HRC Hardened Steel	65	0.002xDc	65	0.002xDc	65	0.002xDc	70	0.002xDc	65	0.002xDc	65	0.002xDc	65	0.002xDc
	GR5 38-48HRC Hardened Steel	60	0.0018xDc	60	0.0018xDc	60	0.0018xDc	65	0.0018xDc	60	0.0018xDc	60	0.0018xDc	60	0.0018xDc
	GR6 48-56HRC Hardened Steel									55	0.0015xDc	55	0.0015xDc	55	0.0015xDc
<b>Cast Iron Materials</b>															
K	GR9-1 Grey cast iron	120	0.004xDc	120	0.005xDc	130	0.005xDc	140	0.006xDc						
	GR9-2 Nodular cast iron	120	0.004xDc	120	0.005xDc	130	0.005xDc	140	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.