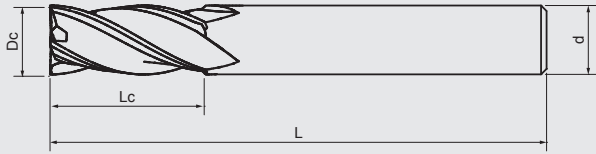


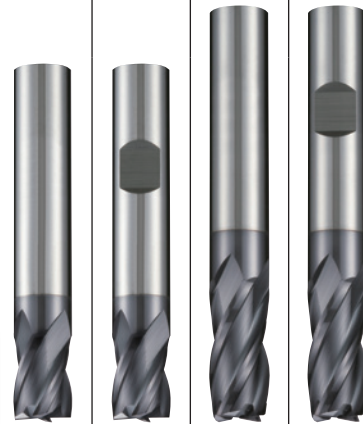
F506HX / F507HX

Finishing End Mills

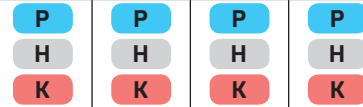
With MG carbide material is good for cutting materials < 48HRC.
Good wear resistance and lubricating effect with Nano multilayer coating.



VHM Carbide **AlTiCrN HX** 30° $\gamma 10^\circ$ $0.05-0.2$ 45° **Steel <48HRC**



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



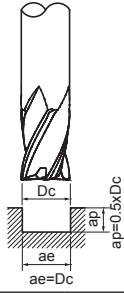
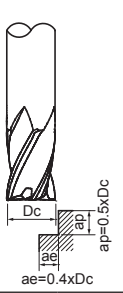
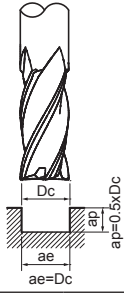
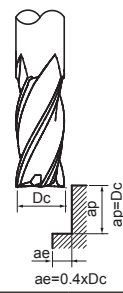
DIN 6527 Stub Length

| Dc 0 -0.02 | Lc mm | L mm | d h5 | 45° mm | F506HX HA | F506HX HB | | | | |
|------------------|----------|---------|---------|-----------|--------------|--------------|--|--|--|--|
| 2 | 4 | 50 | 6 | 0.02 | ● | ● | | | | |
| 3 | 5 | 50 | 6 | 0.03 | ● | ● | | | | |
| 4 | 8 | 54 | 6 | 0.04 | ● | ● | | | | |
| 5 | 9 | 54 | 6 | 0.05 | ● | ● | | | | |
| 6 | 10 | 54 | 6 | 0.06 | ● | ● | | | | |
| 8 | 12 | 58 | 8 | 0.08 | ● | ● | | | | |
| 10 | 14 | 66 | 10 | 0.10 | ● | ● | | | | |
| 12 | 16 | 73 | 12 | 0.12 | ● | ● | | | | |
| 14 | 18 | 75 | 14 | 0.14 | ● | ● | | | | |
| 16 | 22 | 82 | 16 | 0.16 | ● | ● | | | | |
| 18 | 24 | 84 | 18 | 0.18 | ● | ● | | | | |
| 20 | 26 | 92 | 20 | 0.20 | ● | ● | | | | |

DIN 6527 Standard Length

| Dc 0 -0.02 | Lc mm | L mm | d h5 | 45° mm | | | F507HX HA | F507HX 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 | | | ● | ● | | |
| 14 | 26 | 83 | 14 | 0.14 | | | ● | ● | | |
| 16 | 32 | 92 | 16 | 0.16 | | | ● | ● | | |
| 18 | 32 | 92 | 18 | 0.18 | | | ● | ● | | |
| 20 | 38 | 104 | 20 | 0.20 | | | ● | ● | | |

Cutting Conditions

| | F506HX | | F506HX | | F507HX | | F507HX | | |
|---------------------------------|---|---------------------------|---|---------------------------|--|---------------------------|---|---------------------------|-----------|
| |  | |  | |  | |  | | |
| | 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) | |
| Carbon Steel Materials | | | | | | | | | |
| P | GR1 Carbon Steel | 120 | 0.004xDc | 120 | 0.005xDc | 130 | 0.005xDc | 140 | 0.006xDc |
| | GR2 <24HRC Low-alloyed Steel | 120 | 0.003xDc | 120 | 0.004xDc | 130 | 0.004xDc | 140 | 0.005xDc |
| | GR3 <30HRC Hi-alloyed Steel | 80 | 0.003xDc | 80 | 0.003xDc | 90 | 0.003xDc | 100 | 0.004xDc |
| 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 |
| Cast Iron Materials | | | | | | | | | |
| 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.