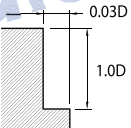
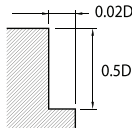


4HHE / 6&8HHE					Cutting Condition			
Material	Heat-treated Steels / Hardened Steels SKD11 / SKD61				Heat-treated Steels / Hardened Steels YXR7 / SKH51			
Hardness	55 ~ 62HRC				62 ~ 70HRC			
Outside Dia	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 1	32,000	800	0.500	0.020	28,000	500	0.50	0.02
Ø 1.5	30,000	900	0.750	0.030	25,000	550	0.75	0.03
Ø 2	24,000	1000	1.000	0.040	16,000	600	1.00	0.04
Ø 3	38,400	1600	1.500	0.060	19,200	1140	1.50	0.06
Ø 4	28,800	1850	2.000	0.080	14,400	1320	2.00	0.08
Ø 5	24,000	2100	2.500	0.100	12,000	1500	2.50	0.10
Ø 6	19,200	2430	3.000	0.120	9,600	1740	3.00	0.12
Ø 8	14,400	2430	4.000	0.160	7,200	1740	4.00	0.16
Ø 10	11,520	2430	5.000	0.200	5,760	1740	5.00	0.20
Ø 12	9,600	2010	6.000	0.240	4,800	1440	6.00	0.24
Ø 16	7,200	1500	8.000	0.320	3,600	1080	8.00	0.32
Ø 20	5,760	1200	10.000	0.400	2,880	850	10.00	0.40
Depth of Cut	 							

- When milling workpiece HRC below 55(Alloy steel, tool steel), Raise up 20% RPM and feed compared to the same diameter.
- For 6-8 flutes of 4HHE, keep the RPM and raise up the feed up to 50% in the stable milling condition.
- Note that 4HHE series performs better in side milling rather than groove milling.
- Use the table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine or found red heat on the material, adjust RPM and feed in the same proportion.
- Use suitable cutting oil for material and machining geometry.