MG | HG Coating | 30 | SD 0-0.003

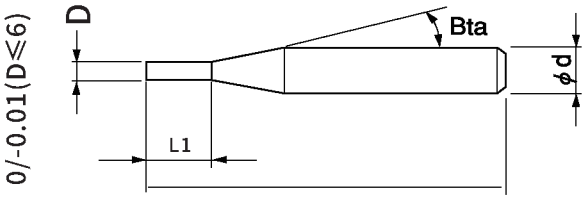
★ ◎ ○

Highly recommend/Recommend/Suggest

DIE STEEL	Grade
Carbon steels (S45C/S55C)	
Alloy steels (SK/SCM/SUS)	
Prehardened steels (NAK/HPM)	
Hardened steels (~55/~60/~70HRC)	★
SPECIAL MATERIAL	
Aluminum alloys	
Graphite	
Copper	
Plastics	
Carbon fiber	
Titanium alloys	
Heat resistant alloys	
Cemented carbide	
Hard brittle (non-metallic)material	

Specialty

*Special coating + bar for high hard hardened materials;
*Very good finish on flat surfaces and side cuts;
*Long processing life in high hardness HRC48-65 degree materials.



2 Flutes

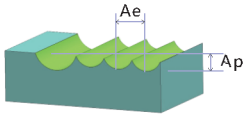
Square

Total 8 models

Unit (mm)

Model Number	D Outside Diameter	L1 Length Of Cut	L2 Effective Length	Bta Shank Taper Angle	L Overall Length	T Number Of Flutes	D Shank Diameter	In Stock
SHHS2-0010020	0.1	0.2	–	12°	50	2	4	○
SHHS2-0020040	0.2	0.4	–	12°	50	2	4	○
SHHS2-0030060	0.3	0.6	–	12°	50	2	4	○
SHHS2-0040080	0.4	0.8	–	12°	50	2	4	○
SHHS2-0050100	0.5	1	–	12°	50	2	4	○
SHHS2-0060120	0.6	1.2	–	12°	50	2	4	○
SHHS2-0070140	0.7	1.4	–	12°	50	2	4	○
SHHS2-0080160	0.8	1.6		12°	50	2	4	○

*New size added from this series. ○ Stocked items.



Cutting Parameter

2 Flutes

Work Material	HRC48-55Hardened steels		HRC56-62Hardened steels		HRC63-70Hardened steels	
Diameter	Speed	(mm/min) Feed	(min-1) Speed	(mm/min) Feed	(min-1) Speed	(mm/min) Feed
0.1	40000	120	40000	100	40000	50
0.2	30000	150	30000	120	30000	80
0.3	30000	260	30000	200	26000	100
0.4	30000	400	30000	300	26000	120
0.5	26000	500	23000	400	20000	200
0.6	26000	500	23000	500	20000	300
0.7	26000	600	23000	500	18000	300
0.8	24000	700	20000	600	18000	300

Square

Milling Amount for Side Milling(mm)

Length of Cut / Work Material	2.5D (Length of Cut=Diameter*2.5)	4D (Length of Cut=Diameter*4)
Below 45HRC	ae=0.07D ap=2D	ae=0.07D ap=2D
Above 45HRC	ae=0.03D ap=1.5D	ae=0.03D ap=1.5D

D：Diameter（mm）
ap：Axial Depth（mm）
ae：Radial Depth（mm）

Note:
*Decrease both spindle speed and feed rate proportionally when the milling parameters exceed the machine's maximum spindle speed;
*Recommend oil coolant for Stainless Steels and Heat Resistance Alloys;
*Recommend using a non-contact measuring device to avoid damaging the precision tip point;
*Decrease both spindle speed and feed rate proportionally in case of chattering;
*When the material hardness is greater than HRC58 degrees, it is recommended to use air blow cooling for roughing and oil mist or air blow cooling for finishing.