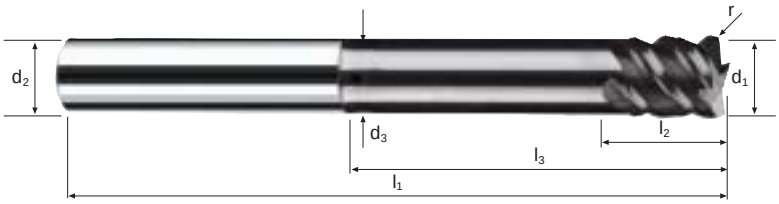
Corner radius end mills XSpeed

Finishing, long reach

HM XT	λ 55° γ-10°

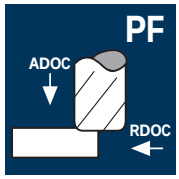


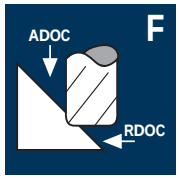
Roughing

Finishing

	HRC 24-34	HRC 34-42	HRC 42-48	HRC 48-56	HRC 56-60	HRC > 60		Ti Titanium	HSS

Order-N°	d1	d2	d3	l1	l2	l3	r	α	fl	X-AL
X7804188	1/8	1/4	0.115	4	1/8	1 1/4	0.010	3.0º	4	●
X7804196	1/8	1/4	0.115	4	1/8	1 1/4	0.020	3.0º	4	●
X7804252	3/16	1/4	0.175	4	3/16	1 1/2	0.010	1.5º	4	●
X7804254	3/16	1/4	0.175	4	3/16	1 1/2	0.020	1.5º	4	●
X7804312	1/4	1/4	0.230	6	1/4	2	0.010	0.0°	4	●
X7804314	1/4	1/4	0.230	6	1/4	2	0.020	0.0°	4	●
X7804318	1/4	1/4	0.230	6	1/4	2	0.010	0.0°	6	●
X7804320	1/4	1/4	0.230	6	1/4	2	0.020	0.0°	6	●
X7804434	3/8	3/8	0.345	6	3/8	2 1/4	0.020	0.0°	4	●
X7804436	3/8	3/8	0.345	6	3/8	2 1/4	0.030	0.0°	4	●
X7804440	3/8	3/8	0.345	6	3/8	2 1/4	0.020	0.0°	6	●
X7804442	3/8	3/8	0.345	6	3/8	2 1/4	0.030	0.0°	6	●
X7804532	1/2	1/2	0.460	6	1/2	2 1/2	0.030	0.0°	4	●
X7804536	1/2	1/2	0.460	6	1/2	2 1/2	0.060	0.0°	4	●
X7804540	1/2	1/2	0.460	6	1/2	2 1/2	0.030	0.0°	6	●
X7804542	1/2	1/2	0.460	6	1/2	2 1/2	0.060	0.0°	6	●

Application	Material	d1 [in]	fl	Speed [ft/min]	FPT [in]	ADOC [in]	RDOC [in]	RPM [min-1]	Feed [in/min]
	Steel 42 - 48 HRC	1/8	4	590	0.0012	0.003	0.031	18040	86
		3/16	4	590	0.0018	0.004	0.047	12030	85
		1/4	6	590	0.0024	0.005	0.063	9020	129
		3/8	6	590	0.0035	0.008	0.094	6020	127
		1/2	6	590	0.0046	0.010	0.125	4510	124
	Hardened tool steel 48 - 52 HRC	1/8	4	490	0.0011	0.003	0.031	14980	68
		3/16	4	490	0.0017	0.004	0.047	9990	66
		1/4	6	490	0.0022	0.005	0.063	7490	101
		3/8	6	490	0.0033	0.008	0.094	4990	99
		1/2	6	490	0.0043	0.010	0.125	3750	97
	Hardened tool steel 52 - 56 HRC	1/8	4	390	0.0011	0.003	0.031	11920	51
		3/16	4	390	0.0016	0.004	0.047	7950	50
		1/4	6	390	0.0021	0.005	0.063	5960	76
		3/8	6	390	0.0031	0.008	0.094	3980	74
		1/2	6	390	0.0040	0.010	0.125	2980	73
	Hardened tool steel 56 - 60 HRC	1/8	4	260	0.0010	0.003	0.031	7950	31
		3/16	4	260	0.0014	0.004	0.047	5300	30
		1/4	6	260	0.0019	0.005	0.063	3980	46
		3/8	6	260	0.0028	0.008	0.094	2650	45
		1/2	6	260	0.0036	0.010	0.125	1990	44

Application	Material	d1 [in]	fl	Speed [ft/min]	FPT [in]	ADOC [in]	RDOC [in]	RPM [min-1]	Feed [in/min]
	Steel 42 - 48 HRC	1/8	4	1180	0.0010	0.002	0.002	36060	144
		3/16	4	1180	0.0013	0.003	0.003	24040	125
		1/4	6	1180	0.0017	0.003	0.003	18030	184
		3/8	6	1180	0.0019	0.004	0.004	12020	137
		1/2	6	1180	0.0023	0.004	0.004	9015	124
	Hardened tool steel 48 - 52 HRC	1/8	4	985	0.0010	0.002	0.002	30100	120
		3/16	4	985	0.0013	0.003	0.003	20065	104
		1/4	6	985	0.0017	0.003	0.003	15050	154
		3/8	6	985	0.0019	0.004	0.004	10035	114
		1/2	6	985	0.0023	0.004	0.004	7525	104
	Hardened tool steel 52 - 56 HRC	1/8	4	820	0.0010	0.002	0.002	25060	100
		3/16	4	820	0.0013	0.003	0.003	16705	87
		1/4	6	820	0.0017	0.003	0.003	12530	128
		3/8	6	820	0.0019	0.004	0.004	8355	95
		1/2	6	820	0.0023	0.004	0.004	6265	86
	Hardened tool steel 56 - 60 HRC	1/8	4	590	0.0008	0.002	0.002	18030	58
		3/16	4	590	0.0011	0.003	0.003	12020	53
		1/4	6	590	0.0015	0.003	0.003	9015	81
		3/8	6	590	0.0017	0.004	0.004	6010	61
		1/2	6	590	0.0019	0.004	0.004	4505	51