

End mill – HM series

Material group	Composition / structure / heat treatment	Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]											
				HM-2E HM-2EP HM-2ES HM-4E					HM-2EFP HM-4EL HM-4EFP						
				Shoulder milling		Shoulder milling		Shoulder milling		Shoulder milling					
				\emptyset [mm]	a_e max	\emptyset [mm]	a_e max	\emptyset [mm]	a_e max	\emptyset [mm]	a_e max				
				$0 < x \leq 20$	$0,05 \times D$			$0 < x \leq 20$	$0,05 \times D$						
				KMG555					KMG555						
				a_e / D					a_e / D						
				1/1	1/2	1/10	f-group	1/1	1/2	1/10	f-group	1/1	1/2	1/10	f-group
P Unalloyed steel	ca. 0,15 % C	annealed	125	1											
	ca. 0,45 % C	annealed	190	2											
	ca. 0,45 % C	tempered	250	3											
	ca. 0,75 % C	annealed	270	4											
	ca. 0,75 % C	tempered	300	5											
P Low-alloyed steel		annealed	180	6											
		tempered	275	7											
		tempered	300	8											
		tempered	350	9											
High-alloyed steel and high-alloyed tool steel		annealed	200	10											
		hardened and tempered	325	11											
M Stainless steel	ferritic/martensitic	annealed	200	12											
	martensitic	tempered	240	13											
	austenitic	quench hardened	180	14											
	austenitic-ferritic		230	15											
K Grey cast iron	perlitic/ferritic		180	16											
	perlitic (martensitic)		260	17											
K Cast iron with spheroidal graphite	ferritic		160	18											
	perlitic		250	19											
Malleable cast iron	ferritic		130	20											
	perlitic		230	21											
N Aluminium wrought alloys	cannot be hardened		60	22											
	hardenable	hardened	100	23											
	$\leq 12\% \text{ Si}$, cannot be hardened		75	24											
	$\leq 12\% \text{ Si}$, hardenable	hardened	90	25											
N Cast aluminium alloys	$> 12\% \text{ Si}$, cannot be hardened		130	26											
	machining steel, PB $>$ 1%		110	27											
	CuZn, CuSnZn		90	28											
S Copper and copper alloys (bronze/brass)	CuSn, Pb-free copper, electrolytic copper		100	29											
	Heat-resistant alloys	Fe-based alloys	annealed	200	30										
		hardened	280	31											
	Ni or Co bass	annealed	250	32											
hardened		350	33												
Titanium alloys	cast	320	34												
	pure titanium		R_m 400	35											
H Hardened steel	α and β alloys	hardened	R_m 1050	36											
	hardened and tempered	55 HRC	37	55	100	125	3	50	95	115	3				
H Hard cast iron	hardened and tempered	60 HRC	38	55	95	120	3	50	95	110	3				
	cast	400	39	70	125	160	3	65	120	145	3				
H Hardened cast iron	hardened and tempered	55 HRC	40	55	100	125	3	50	95	115	3				
X Non-metallic materials	Thermoplasts			41											
	Thermosetting plastics			42											
	Plastic, glass-fibre reinforced GFRP			43											
	Plastic, carbon fibre reinforced CFRP			44											
	Graphite			45											
	Wood			46											

Note: The given cutting values are guide values, which were determined under ideal conditions.
 The values have to be adapted in individual cases.
 Feed rate recommendations on page B444.
 For examples of material for cutting tool groups view page D22.

