



Ball nose end mill with shorter overall length

WXL-HS-EBD

Volume 1



FEATURES : WXL-HS-EBD



1 For general contour finishing applications up to 55 HRC.

2 Short, compact geometry for excellent tool rigidity enables

- Higher feed rates
- Minimal vibration
- Longer tool life
- Excellent surface finish

3 Shorter overall length especially suitable for 5-axis machine applications.

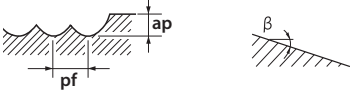
CUTTING CONDITIONS

Milling | Endmills | Cutting conditions

WXL-HS-EBD

R	Copper • Copper Alloy				Mild Steel • Carbon Steel FC250 • SS400 • S55C ~32HRC				Hardened Steel • Prehardened Steel • Stainless Steel SKT • SKD61 • NAK55 • NAK80 • HPM1 • DH* • SUS304							
									33~41HRC				42~50HRC			
	S (min ⁻¹)	F (mm/min)	Depth of cut		S (min ⁻¹)	F (mm/min)	Depth of cut		S (min ⁻¹)	F (mm/min)	Depth of cut		S (min ⁻¹)	F (mm/min)	Depth of cut	
		ap	pf			ap	pf			ap	pf			ap	pf	
0.1	50.000	540	0,01	0,02	50.000	540	0,01	0,02	50.000	540	0,01	0,02	50.000	440	0,01	0,02
0.2	50.000	880	0,02	0,04	50.000	750	0,02	0,04	50.000	750	0,02	0,04	50.000	680	0,02	0,04
0.3	50.000	1.840	0,02	0,04	50.000	910	0,02	0,04	50.000	910	0,02	0,04	50.000	840	0,02	0,04
0.4	50.000	2.210	0,02	0,05	50.000	1.850	0,02	0,05	50.000	1.850	0,02	0,05	50.000	1.250	0,02	0,05
0.5	50.000	3.350	0,02	0,05	50.000	2.800	0,02	0,05	50.000	2.500	0,02	0,05	47.500	2.250	0,02	0,05
1	31.500	3.350	0,04	0,10	25.000	2.800	0,04	0,10	24.500	2.500	0,04	0,10	23.500	2.250	0,04	0,10
1.5	21.000	3.350	0,06	0,15	16.500	2.800	0,06	0,15	16.000	2.500	0,06	0,15	15.500	2.250	0,06	0,15
2	15.500	4.080	0,08	0,20	15.500	3.400	0,08	0,20	15.000	2.750	0,08	0,20	13.500	2.450	0,08	0,20
3	10.500	5.160	0,12	0,30	13.500	4.300	0,30	0,60	11.500	2.750	0,30	0,60	9.500	2.250	0,12	0,30
4	7.900	3.840	0,16	0,40	10.000	3.200	0,40	0,80	8.950	2.100	0,40	0,80	7.150	1.700	0,16	0,40
5	6.300	3.120	0,20	0,50	8.250	2.600	0,50	1,00	7.150	1.700	0,50	1,00	5.700	1.350	0,20	0,50
6	5.250	2.580	0,24	0,60	6.850	2.150	0,50	2,40	5.950	1.400	0,50	2,40	4.750	1.100	0,24	0,60

Depth of cut



1. The indicated speeds and feeds are for high speed light milling with high speed/high precision machining centers.
2. Because tools can cause sparks, do not use flammable fluids.
3. Use an air blow or a suitable cutting fluid with high smoke retardant properties.
4. Refer to the table above to set the milling conditions in accordance with the actual situation.

*If your machine tool does not attain the indicated speed, operate it at the highest possible speed.



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