HT Series: Coated 6-Flute Square + Tech Data

High strength, heavy core solid carbide end mills for high-speed machining of heat-treated & hardened materials up to 70HRc.

- Designed for peripheral milling (or toroidal slotting)
- Proprietary cemented carbide grade and coating
- Maximum tool life and performance in HSM applications

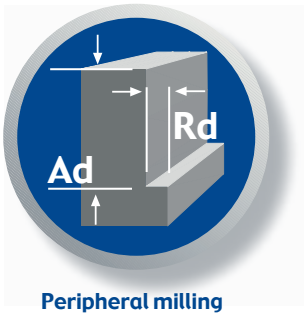
HT6SI-AT

Diam	Shank	LOC	OAL	Square end 6-flt AT Coated EDP#	List
1/8	1/8	1/2	1-1/2	23900	**$21.50**
3/16	3/16	5/8	2″	23902	**$24.50**
1/4	1/4	3/4	2-1/2	23904	**$28.50**
5/16	5/16	13/16	2-1/2	23906	**$36.00**
3/8	3/8	1″	2-1/2	23908	**$48.50**
1/2	1/2	1″	3″	23910	**$72.50**
Metric Sizes (HT6SM-AT)					
3.0	3.0	12.0	38.0	23960	**$21.50**
4.0	4.0	14.0	50.0	23962	**$24.00**
5.0	5.0	16.0	50.0	23964	**$24.50**
6.0	6.0	19.0	63.0	23966	**$28.50**
8.0	8.0	20.0	63.0	23968	**$36.00**
10.0	10.0	25.0	70.0	23970	**$60.00**
12.0	12.0	30.0	76.0	23972	**$72.50**

SFR HT Series End Mill Specs:
Cutting Diam +.000/-.002
Shank Diam -.0000/-.0002

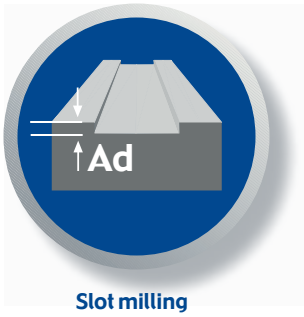
SFR HT Metric End Mill Specs:
Cutting Diam +0.00/-0.05mm
Shank Diam -0.000/-0.005mm

- Axial depth (Ad) and Radial depth (Rd) are expressed in % of cutter diameter.
- If recommended speed is higher than machine tool's capacity, run at maximum RPM and reduce feed appropriately.



Peripheral milling

Material Hardness	35 - 45 HRc		45 - 55 HRc		55 - 65 HRc		65 - 70 HRc	
Depth of cut Peripheral:	Ad = 1.5xD Rd=.1xD		Ad = 1.0xD Rd=.05xD		Ad = 1.0xD Rd=.03xD		Ad = 1.0xD Rd=.02xD	
Depth of cut Slotting:	Ad = .1xD		Ad = .1xD		Ad = .05xD		Ad = .02xD	
	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
Fractional Mill Diameter	RPM	in/min	RPM	in/min	RPM	in/min	RPM	in/min
1/8"	18,000	85	13,500	48	11,000	33	7,600	21
3/16"	12,000	86	9,000	54	7,500	36	5,000	21
1/4"	9,200	100	7,500	72	5,600	40	3,800	20
5/16"	7,000	05	5,600	74	4,200	50	3,000	27
3/8"	5,600	105	4,300	76	3,500	50	2,500	27
1/2"	3,800	90	3,000	55	2,500	30	1,500	15



Slot milling

Material Hardness	35 - 45 HRc		45 - 55 HRc		55 - 65 HRc		65 - 70 HRc	
Depth of cut Peripheral:	Ad = 1.5xD Rd=.1xD		Ad = 1.0xD Rd=.05xD		Ad = 1.0xD Rd=.03xD		Ad = 1.0xD Rd=.02xD	
Depth of cut Slotting:	Ad = .1xD		Ad = .1xD		Ad = .05xD		Ad = .02xD	
	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
Metric Mill Diameter	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
3.0 mm	19,500	2,300	14,000	1,280	11,900	900	8,050	600
4.0	14,000	2,600	11,000	1,670	9,000	1,050	6,000	600
5.0	10,750	2,600	7,300	1,550	5,550	1,100	4,400	510
6.0	9,700	2,500	7,600	1,850	6,000	1,280	3,700	510
8.0	7,000	2,700	5,600	1,900	4,200	1,280	2,800	640
10.0	5,600	2,765	4,400	2,000	3,600	1,450	2,250	685
12.0	4,650	2,750	3,700	1,790	3,000	1,150	1,900	500