HT Series: AT coated 6 or 8 flute Square & Radius

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 SmoothCoat AlTiN
• Includes SmoothEdge 1 edge prep • Maximum tool life and performance in HSM applications

HT6SAT

∅ Diam	LOC	OAL	Shank	Flutes	Square w/AT HT6 or HT8SAT EDP#	Square w/AT HT6 or HT8SAT Price	Radius	Radius w/ AT HT6 or HT8RAT EDP#	Radius w/ AT HT6 or HT8RAT Price
1/8	1/2	1-1/2	1/8	6	23900	$21.50	.010	23918	$23.00
3/16	5/8	2″	3/16	6	23902	$25.00	.010	23920	$27.00
1/4	3/4	2-1/2	1/4	6	23904	$31.00	.010	23922	$34.00
5/16	13/16	2-1/2	5/16	6	23906	$38.00	.010	23924	$42.00
3/8	1″	2-1/2	3/8	6	23908	$49.00	.030	23926	$54.00
1/2	1″	3″	1/2	6	23910	$75.00	.030	23928	$82.00
5/8	1-1/4	3-1/2	5/8	8	23912	$136.00	.030	23930	$144.00
3/4	1-1/2	4″	3/4	8	23914	$180.00	.030	23932	$190.00
1″	1-1/2	4″	1″	8	23916	$280.00	.030	23934	$290.00

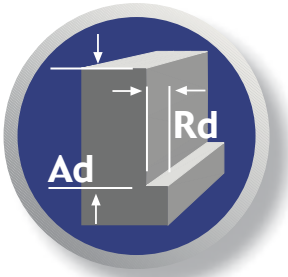
Specs (fractional end mills cut diameter ≥ 1/8″):
Cutting Diam +.0000 / -.0015
Shank Diam +.0000 / -.00025
Radius ± .00075
SFR = Shrink Fit Ready

∅ Diam	LOC	OAL	Shank	Flutes	Metric Square HT6 or HT8SAT EDP#	Metric Square HT6 or HT8SAT Price	Radius	Metric Radius HT6 or HT8RAT EDP#	Metric Radius HT6 or HT8RAT Price
3.0mm	12	38	3.0	6	23960	$21.50	0.3	23978	$23.00
4.0	14	50	4.0	6	23962	$24.00	0.3	23980	$26.00
5.0	16	50	5.0	6	23964	$25.00	0.3	23982	$27.00
6.0	19	63	6.0	6	23966	$31.00	0.3	23984	$34.00
8.0	20	63	8.0	6	23968	$38.00	0.3	23986	$42.00
10.0	25	70	10.0	6	23970	$62.00	0.3	23988	$67.00
12.0	30	74	12.0	6	23972	$75.00	0.3	23990	$82.00
16.0	32	89	16.0	8	23974	$136.00	0.3	23992	$144.00
20.0	38	100	20.0	8	23976	$200.00	0.3	23994	$210.00

Specs (MM end mills cutting diameter ≥ 3.0mm):
Cutting Diam +0.000 / -0.038mm
Shank Diam +0.000 / -0.0064mm
Radius ± 0.019mm
SFR = Shrink Fit Ready

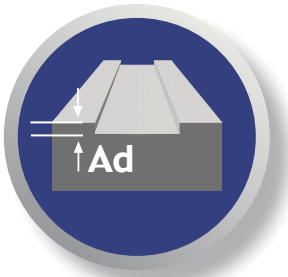
• Axial depth (Ad) and Radial depth (Rd) are expressed in % of cutter diameter.

• 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