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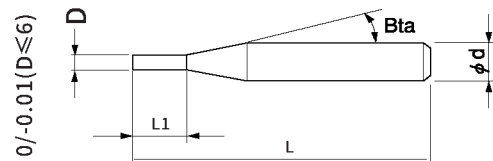
HG
CoatingSD
0-0.003

Highly recommend ★ ○ ○
/Recommend/Suggest

Specialty

*2 Flutes Square End Mills for Mold Steels.;

*The flute shape is specifically designed for outstanding chip evacuation, excellent milling performance, broad application range from Copper to Hardened Steels up to HRC60.



DIE STEEL	Grade
Carbon steels (S45C/S55C)	○
Alloy steels (SK/SCM/SUS)	○
Prehardened steels (NAK/HPM)	○
Hardened steels (~55/~60/~70HRC)	○
SPECIAL MATERIAL	
Aluminum alloys	
Graphite	
Copper	○
Plastics	
Carbon fiber	
Titanium alloys	○
Heat resistant alloys	
Cemented carbide	
Hard brittle (non-metallic) material	

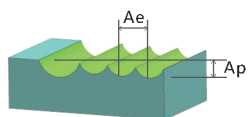
Total 15 models

Unit (mm)

Model Number	D Outside Diameter	L1 Length Of Cut	L2 Effective Length	BTa Shank Taper Angle	L Overall Length	T Number Of Flutes	d Shank Diameter	In Stock
SHGS2-0020040	0.2	0.4	-	12°	50	2	4	○
SHGS2-0030060	0.3	0.6	-	12°	50	2	4	○
SHGS2-0040080	0.4	0.8	-	12°	50	2	4	○
SHGS2-0050100	0.5	1	-	12°	50	2	4	○
SHGS2-0060120	0.6	1.2	-	12°	50	2	4	○
SHGS2-0070140	0.7	1.4	-	12°	50	2	4	○
SHGS2-0080160	0.8	1.6	-	12°	50	2	4	○
SHGS2-0100300	1.0	3	-	12°	50	2	4	○
SHGS2-0150400	1.5	4	-	12°	50	2	4	○
SHGS2-0200500	2.0	5	-	12°	50	2	4	○
SHGS2-0250600	2.5	6	-	12°	50	2	4	○
SHGS2-0300800-4	3	8	-	12°	50	2	4	○
SHGS2-0401000-4	4	10	-	-	50	2	4	○
SHGS2-0401000-6	4	10	-	12°	60	2	6	○
SHGS2-0601500	6	15	-	-	60	2	6	○

*New size added from this series.

○ Stocked items.



側面切削 (Side Milling)

Work Material	HRC30-45 Prehardened Steels		HRC45-55 Hardened Steels		HRC55-65 Hardened Steels	
(mm) Diameter	(min-1) Speed	(mm/min) Feed	(min-1) Speed	(mm/min) Feed	(min-1) Speed	(mm/min) Feed
D1.0	10000	100	8000	60	7000	40
D1.5	8000	120	6000	60	5000	50
D2.0	7000	120	5000	60	4000	55
D2.5	6000	120	4500	60	3500	55
D3	5000	150	4000	80	3000	60
D4	4000	150	4000	100	2200	100
D4	4000	150	4000	100	2200	120
D6	3500	250	3000	200	2000	150

2 Flutes

Square

Milling Amount for Side Milling(mm)

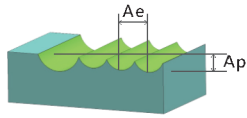
Length of Cut Work Material	2.5D (Length of Cut=Diameter*2.5)	4D (Length of Cut=Diameter*4)
Below 45HRC	$a_e=0.07D$ $a_p=2D$	$a_e=0.07D$ $a_p=2D$
Above 45HRC	$a_e=0.03D$ $a_p=1.5D$	$a_e=0.03D$ $a_p=1.5D$

D: Diameter(mm)

 a_p : Axial Depth (mm) a_e : Radial Depth (mm)

Note:

- *Decrease both spindle speed and feed rate proportionally when the milling parameters exceed the machine's maximum spindle speed;
- *Recommend oil coolant for Stainless Steels and Heat Resistance Alloys;
- *Recommend using a non-contact measuring device to avoid damaging the precision tip point;
- *Decrease both spindle speed and feed rate proportionally in case of chattering.



Contour Milling

Work Material	HRC30-45 Prehardened Steels		HRC45-55 Hardened Steels		HRC55-65 Hardened Steels	
	(mm) Diameter	(min-1) Speed	(mm/min) Feed	(min-1) Speed	(mm/min) Feed	(min-1) Speed
2 Flutes	D0.2	30000	120	30000	120	20000
	D0.3	30000	150	30000	150	16000
	D0.4	30000	200	30000	200	16000
	D0.5	26000	200	26000	200	14000
	D0.6	24000	300	24000	300	14000
	D0.7	20000	500	20000	500	12000
	D0.8	16000	800	16000	800	10000
	D1.0	13000	1000	13000	1000	8000
	D1.5	13000	1200	13000	1200	8000
	D2.0	12000	1500	12000	1500	8000
	D2.5	12000	1500	12000	1500	8000
	D3	11000	1800	11000	1800	8000
	D4	10000	2200	10000	2200	7500
	D4	10000	2200	10000	2200	7500
	D6	9000	2500	9000	2500	7000
	D6	9000	2500	9000	2500	1400

Note:

- *Decrease both spindle speed and feed rate proportionally when the milling parameters exceed the machine's maximum spindle speed;
- *Recommend oil coolant for Stainless Steels and Heat Resistance Alloys;
- *Recommend using a non-contact measuring device to avoid damaging the precision tip point;
- *Decrease both spindle speed and feed rate proportionally in case of chattering.