



MG

HG
Coating

30

SD
0-0.003

Highly recommend/Recommend/Suggest

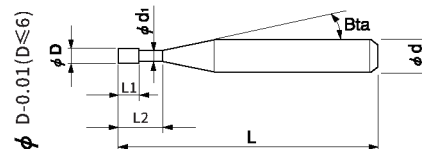
DIE STEEL	Grade
Carbon steels (S45C/S55C)	
Alloy steels (SK/SCM/SUS)	
Prehardened steels (NAK/HPM)	
Hardened steels (~55/~60/~70HRC)	★
SPECIAL MATERIAL	
Aluminum alloys	
Graphite	
Copper	
Plastics	
Carbon fiber	
Titanium alloys	
Heat resistant alloys	
Cemented carbide	
Hard brittle (non-metallic) material	

Specialty

*Special coating + bar for high hard hardened materials;

*The large arc at the clearance avoids cutter damage;

*Long life in cutting high hardness material of HRC48-65.



The shank taper angle shown is not an exact value and to avoid contact with the workpiece, we recommend the user controls the precise value of this angle. Shank taper angle should not make contact with the workpiece.

2 Flutes

Long Neck
Square

Total 23 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
SHHLS2-002005	0.2	0.3	0.5	12°	50	2	4	○
SHHLS2-002010	0.2	0.3	1	12°	50	2	4	○
SHHLS2-002015	0.2	0.3	1.5	12°	50	2	4	○
SHHLS2-003010	0.3	0.5	1	12°	50	2	4	○
SHHLS2-003015	0.3	0.5	1.5	12°	50	2	4	○
SHHLS2-003020	0.3	0.5	2	12°	50	2	4	○
SHHLS2-003030	0.3	0.5	3	12°	50	2	4	○
SHHLS2-004010	0.4	0.6	1	12°	50	2	4	○
SHHLS2-004020	0.4	0.6	2	12°	50	2	4	○
SHHLS2-004030	0.4	0.6	3	12°	50	2	4	○
SHHLS2-004040	0.4	0.6	4	12°	50	2	4	○
SHHLS2-005010	0.5	0.75	1	12°	50	2	4	○
SHHLS2-005020	0.5	0.75	2	12°	50	2	4	○
SHHLS2-005040	0.5	0.75	4	12°	50	2	4	○
SHHLS2-005060	0.5	0.75	6	12°	50	2	4	○
SHHLS2-006020	0.6	0.9	2	12°	50	2	4	○
SHHLS2-006040	0.6	0.9	4	12°	50	2	4	○
SHHLS2-006060	0.6	0.9	6	12°	50	2	4	○
SHHLS2-006080	0.6	0.9	8	12°	50	2	4	○

Next page →

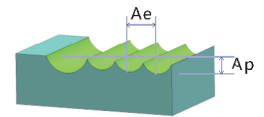
Model Number	D Outside Diameter	L1 Length Of Cut	L2 Effective Length	Bta Shank Taper Angle	L Overall Length	T Number Of Flutes	D Shank Diameter	In Stock
SHHLS2-008020	0.8	1.2	2	12°	50	2	4	○
SHHLS2-008040	0.8	1.2	4	12°	50	2	4	○
SHHLS2-008060	0.8	1.2	6	12°	50	2	4	○
SHHLS2-008080	0.8	1.2	8	12°	50	2	4	○

*New size added from this series.

Stocked items.

2 Flutes

Long Neck
Square



Cutting Parameter

Work Material		HRC48-55 hardened steel				HRC56-62 hardened steel				HRC63-70 hardened steel			
Diameter	Effective Length(mm)	(min-1) Speed	(mm/min) Feed	(mm) Axial depth	(mm) Radidl depth	(min-1) Speed	(mm/min) Feed	(mm) Axial depth	(mm) Radidl depth	(min-1) Speed	(mm/min) Feed	(mm) Axial depth	(mm) Radidl depth
0.2	0.5	30000	200	0.003	0.1	30000	160	0.003	0.08	30000	120	0.003	0.06
0.2	1	30000	150	0.003	0.1	30000	120	0.003	0.08	30000	80	0.003	0.06
0.2	1.5	30000	100	0.002	0.1	30000	80	0.002	0.08	30000	60	0.002	0.06
0.3	1	30000	300	0.003	0.15	30000	250	0.003	0.12	30000	200	0.003	0.09
0.3	1.5	30000	200	0.003	0.15	30000	160	0.003	0.12	30000	120	0.003	0.09
0.3	2	30000	150	0.003	0.15	30000	120	0.003	0.12	25000	100	0.003	0.09
0.3	3	25000	50	0.002	0.15	25000	40	0.002	0.12	25000	30	0.002	0.09
0.4	1	30000	400	0.005	0.2	30000	350	0.005	0.16	25000	300	0.005	0.12
0.4	2	30000	320	0.005	0.2	25000	280	0.005	0.16	25000	220	0.005	0.12
0.4	3	25000	360	0.004	0.2	20000	220	0.003	0.16	18000	180	0.003	0.12
0.4	4	25000	200	0.003	0.2	20000	160	0.002	0.16	18000	120	0.002	0.12
0.5	1	25000	500	0.01	0.25	23000	450	0.007	0.2	20000	400	0.005	0.15
0.5	2	25000	420	0.01	0.25	23000	380	0.007	0.2	20000	320	0.005	0.15
0.5	4	25000	280	0.005	0.25	23000	240	0.003	0.2	20000	200	0.002	0.15
0.5	6	20000	200	0.003	0.25	18000	150	0.002	0.2	16000	100	0.002	0.15
0.6	2	25000	500	0.01	0.3	23000	400	0.007	0.25	18000	350	0.005	0.18
0.6	4	25000	400	0.005	0.3	23000	300	0.003	0.25	18000	250	0.002	0.18
0.6	6	20000	300	0.002	0.3	18000	200	0.002	0.25	16000	150	0.001	0.18
0.6	8	20000	300	0.002	0.3	18000	200	0.002	0.25	16000	150	0.001	0.18
0.8	2	25000	780	0.03	0.4	23000	650	0.02	0.32	20000	550	0.012	0.24
0.8	4	25000	700	0.025	0.4	23000	600	0.015	0.32	20000	500	0.007	0.24
0.8	6	20000	550	0.02	0.4	18000	450	0.01	0.32	16000	350	0.005	0.24
0.8	8	16000	400	0.007	0.4	14000	300	0.005	0.32	12000	200	0.003	0.24

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;
- *When the material hardness is higher than HRC58, it is recommended to use air blow cooling for roughing and oil mist or air blow cooling for finishing.