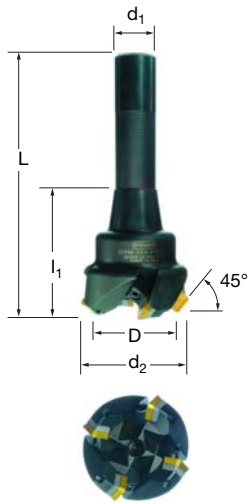
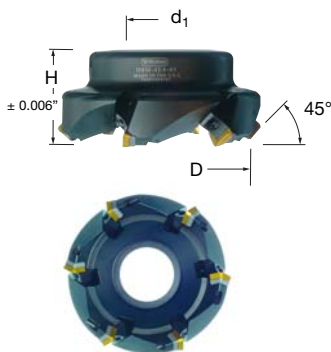


Weldon Shank



R8 Shank



Shell Mill Fixation



Depth of Cut (a)

HSM Weldon Shank

EDP #	Part Number	Dimensions (inch)						No. of Inserts
		D	L/H	l ₁	d ₁	d ₂	a _{max.}	
010828	HSM2E445W .75	2.00	4.03	2.00	0.75	2.4	0.24	4

HSM R8 Shank

010829	HSM2E445R8	2.00	5.94	2.00	R8	2.4	0.24	4
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HSM Shell Mill Fixation

012989	HSM2E445	2.00	1.80	-	0.75	2.4	0.24	4
009784	HSM3E445	3.00	2.00	-	1.00	3.4	0.24	6
009785	HSM4E445	4.00	2.00	-	1.50	4.4	0.24	6
009786	HSM5E445	5.00	2.50	-	1.50	5.4	0.24	7
009787	HSM6E445	6.00	2.50	-	2.00	6.4	0.24	7
010827	HSM8E445	8.00	2.50	-	2.50	8.4	0.24	8

HSM Shell Mill Fixation

	Wedge	Wedge Screw	Seat	Seat Screw
Part Number	HSMW4	STC11	FSS42E	SN120T
EDP #	010630	003686	009782	009783



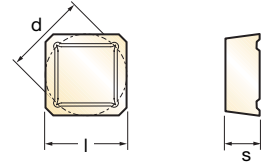
HSM Technical Advice

Milling Cutter Order Example: **HSM2E445R8**
 Milling Insert Order Example: **SEKN1203AFEN MP91M**
 For complete cutting conditions refer to page: **208**

Feedrate compensation: For 45° cutting, divide the h_m value by the sine of the approach angle (the sine of 45° = 0.707)

$$\text{ie: } \frac{h_m}{0.707} \quad \text{or} \quad \frac{0.004''}{0.707} = 0.0056 \text{ in. programmed feed rate}$$

Inserts for HSM



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
025979	SEKN1203AFEN	CN35				0.500	0.500	0.125	Facet	0.0047
010832	SEKN1203AFEN	MP91M	◆◆◆	◆◆◆	◆	0.500	0.500	0.125	Facet	0.0047
009252	SEKN1203AFEN	PFZ	◆◆	◆◆		0.500	0.500	0.125	Facet	0.0047
009247	SEKN1203AFEN	SF30				0.500	0.500	0.125	Facet	0.0047
017862	SEKN1203AFFN	GH1	◆	◆		0.500	0.500	0.125	Facet	0.0047



010833	SEKR1203AFEN	MP91M			◆◆	0.500	0.500	0.125	Facet	0.0047
009781	SEKR1203AFEN	PFZ	◆	◆	◆◆◆	0.500	0.500	0.125	Facet	0.0047
017863	SEKR1203AFFN	GH1			◆	0.500	0.500	0.125	Facet	0.0047



Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V _C (feet/min)	Feed h _m (inch)	D.O.C. a _p (inch)	Speed V _C (feet/min)	Feed h _m (inch)	D.O.C. a _p (inch)	Speed V _C (feet/min)	Feed h _m (inch)	D.O.C. a _p (inch)
◆ Unalloyed Steels	600 - 720	0.008 - 0.018	0.12 - 0.24	730 - 850	0.006 - 0.012	0.04 - 0.12	730 - 980	0.006 - 0.007	0.01 - 0.04
◆ Alloyed Steels	230 - 360	0.008 - 0.014	0.12 - 0.24	330 - 490	0.006 - 0.01	0.04 - 0.12	330 - 630	0.006 - 0.007	0.01 - 0.04
◆ Stainless Steels	400 - 450	0.006 - 0.012	0.12 - 0.24	460 - 590	0.006 - 0.01	0.04 - 0.12	600 - 750	0.006 - 0.007	0.01 - 0.04
◆ PH Stainless	190 - 220	0.006 - 0.010	0.08 - 0.16	230 - 270	0.006 - 0.008	0.04 - 0.08	270 - 320	0.002 - 0.004	0.01 - 0.04
◆ Cast Irons	460 - 910	0.006 - 0.012	0.12 - 0.24	600 - 980	0.004 - 0.009	0.04 - 0.12	660 - 1140	0.002 - 0.006	0.01 - 0.04
◆ Aluminium & Alloys	910 - 1470	0.006 - 0.012	0.12 - 0.24	1320 - 2460	0.004 - 0.009	0.04 - 0.12	2300 - 3280	0.002 - 0.006	0.01 - 0.04
◆ High Temp. Alloys	90 - 130	0.006 - 0.010	0.08 - 0.16	120 - 160	0.006 - 0.008	0.04 - 0.08	150 - 190	0.002 - 0.004	0.01 - 0.04
◆ Hard Steels (52-56 HRC)	-	-	-	-	-	-	-	-	-

h_m = average chip thickness

Star Guide Key to Recommended Tools

Material Designations							
	◆ P	Unalloyed Steels	◆ M	Stainless Steels	◆ K	Cast Irons	
	◆ P	Alloyed Steels	◆ M	PH Stainless	◆ N	Aluminum & Alloys	
				◆ S	High Temp. Alloys	◆ H	Hard Materials