

**Tired of trying EXPENSIVE  
HARD MACHINING end mills ?**

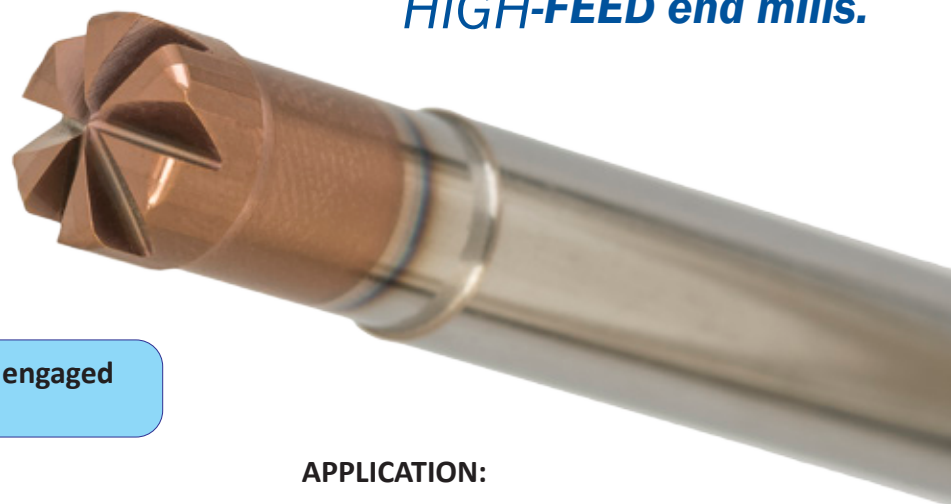
**Then, HIGH-FEED  
is right option  
for you...**



**INTRODUCING  
407 Series  
HIGH-FEED Cutters**



**Replace your ball nose in roughing or  
semi-finishing operations with  
HIGH-FEED end mills.**



**FEATURES & BENEFITS :**

**IN 3D MILLING about 60% of cutting end is engaged  
with "HIGH-FEED" cutters.**

- 50% More cutting edges with 6-Flute.
- Best end mills in market for HIGH FEED MACHINING.
- Effective in 3D machining, helical ramping, circular interpolation, and face milling.
- Time is money: Reduces hard machining time significantly.
- Special PVD Coating protects tool from high temperature.

**APPLICATION:**

- "HIGH-FEED" cutter machining process: Take very shallow depth of cuts at HIGH FEED RATES (see the table on next page)
- Best suited for machining hardened dies & mold up to 65HRc of hardness.



## SIZES AVAILABLE:

Flute Diameter	Flute Length	Overall Length	Shank Diameter
6	6	75	6
8	8	75	8
8	8	100	8
10	10	75	10
10	10	100	10
12	12	75	12
12	12	100	12

OTHER SIZES AVAILABLE ON REQUEST

# HIGH-FEED Cutters



## CUTTING PARAMETERS:

Material [Hardened Steel : P20, D2, D3, H13, or other Die / Tool Steels]	Coolant	Copy Milling Roughing			
		VC (m/min)	FZ (mm/tooth)	AP (mm)	AE (mm)
48 to 54HRc	Mist Spray	140-200	0.02D	0.10D	0.30D
54 to 60HRc	Mist Spray	100-140	0.015D	0.07D	0.025D
60 to 65HRc	Mist Spray	60-100	0.013D	0.05D	0.20D
> 65HRc	Mist Spray	40-60	0.010D	0.04D	0.15D

## CUTTING PARAMETERS:

Material [Hardened Steel : P20, D2, D3, H13, or other Die / Tool Steels]	Coolant	Copy Milling Finishing			
		VC (m/min)	FZ (mm/tooth)	AP (mm)	AE (mm)
48 to 54HRc	Mist Spray	210-350	0.013D	0.02D	0.01D
54 to 60HRc	Mist Spray	130-210	0.012D	0.02D	0.01D
60 to 65HRc	Mist Spray	90-130	0.010D	0.01D	0.01D
> 65HRc	Mist Spray	70-90	0.010D	0.01D	0.01D

Where D is the Cutting Diameter of the tool

**Our Promise**  
**Your hard die & mold machining cost and time will drop down to minimum level.**

## ROHIT INDUSTRIES GROUP PVT. LTD.

**H.O** : 20-A, Shivaji Marg, New Delhi - 110015, India

**Unit-I** : Plot No. 653-656, MIE Part-A, Bahadurgarh, Haryana-124507, India

**Phone** : +91-11-66226622 (100 Lines) | **Skype** : sales.rigpl

**Web** : www.rigpl.com

| **Email** : sales@rigpl.com

