

## FH200-H Exclusive Use for High Feed Machining Hardened Steels

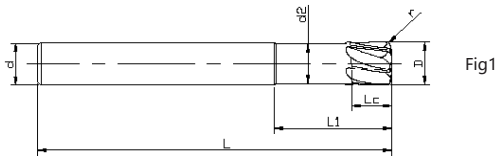
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- Dedicated to high feed rough machining of 35~65HRC high hardness material.
- Special-purpose tool type design, Perfect implementation thin cutting effect, realize high feed rough machining, Significantly improve the processing efficiency.
- Use Newly Super Fine Carbide matrix, and match with new generation hard coating, that enables high wear-resistant as well as high thermal stability for various working condition.



# FH200-R6-H

6 Flute, Complex Corner Radius



Ordering Code	D Mill dia	Lc Flute length	r Coner radius	d2 Neck dia	L1 Under neck length	L Overall length	d Shank dia.	Figure No.	Stock
FH200-R6-06004-H	6	5	0.375	5.5	18	60	6	1	○
FH200-R6-08005-H	8	7	0.5	7.5	24	75	8	1	●
FH200-R6-10006-H	10	8	0.625	9.5	30	90	10	1	●
FH200-R6-12008-H	12	10	0.75	11.5	36	100	12	1	●
FH200-R6-16010-H	16	14	1	15.5	48	110	16	1	○
FH200-R6-20013-H	20	18	1.25	19.5	60	125	20	1	○

- Stock
- Available upon order

D	Tolerance
D ≤ 20	-0.014 -0.038

unit (mm)

Workpiece Material				
P		H		
1	2	3	4	5
Carbon Steels	Alloy Steels	Hardened Steel	Hardened Steel	Hardened Steel
( < 35HRC)	(35-48 HRC)	( < 55HRC)	(55-60HRC)	(□60HRC)
	○	○	○	○

○ Most Suitable ○ Suitable

## FH200-RH6-H

6 Flute Complex Corner Radius with long shank length

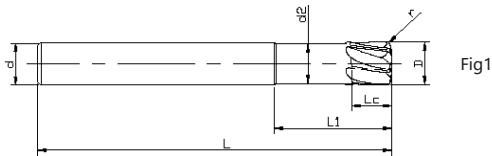
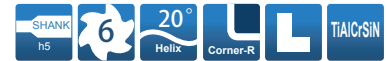


Fig1



Ordering Code	D Mill dia	Lc Flute length	r Coner radius	d2 Neck dia	L1 Under neck length	L Overall length	d Shank dia.	Figure No.	Stock
FH200-RH6-06004-H	6	5	0.375	5.5	18	100	6	1	○
FH200-RH6-08005-H	8	7	0.5	7.5	24	100	8	1	○
FH200-RH6-10006-H	10	8	0.625	9.5	30	120	10	1	○
FH200-RH6-12008-H	12	10	0.75	11.5	36	120	12	1	○
FH200-RH6-16010-H	16	14	1	15.5	48	150	16	1	○
FH200-RH6-20013-H	20	18	1.25	19.5	60	150	20	1	○

- Stock
- Available upon order

D	Tolerance
D ≤ 20	-0.014 -0.038

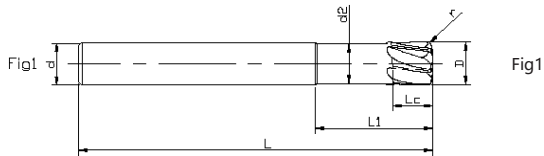
unit (mm)

Workpiece Material				
P		H		
1 2 3 4	5	1 2	3	4
Carbon Steels Alloy Steels	Alloy Steels	Hardened Steel	Hardened Steel	Hardened Steel
(< 35HRC)	(35-48 HRC)	(< 55HRC)	(55-60HRC)	(> 60HRC)
	○	○	○	○

○ Most Suitable ○ Suitable

# FH200-RN6-H

6 Flute Complex Corner Radius with reduced neck diameter



Ordering Code	D Mill dia	Lc Flute length	r Coner radius	d2 Neck dia	L1 Under neck length	L Overall length	d Shank dia.	Figure No.	Stock
FH200-RN6-06004-H	6	5	0.375	5.5	24	100	6	1	○
FH200-RN6-08005-H	8	7	0.5	7.5	32	100	8	1	○
FH200-RN6-10006-H	10	8	0.625	9.5	40	120	10	1	○
FH200-RN6-12008-H	12	10	0.75	11.5	48	120	12	1	○
FH200-RN6-16010-H	16	14	1	15.5	64	150	16	1	○
FH200-RN6-20013-H	20	18	1.25	19.5	80	150	20	1	○

- Stock
- Available upon order

D	Tolerance
D ≤ 20	-0.014 -0.038

unit (mm)

Workpiece Material				
P		H		
1 2 3 4	5	1 2	3	4
Carbon Steels Alloy Steels	Alloy Steels	Hardened Steel	Hardened Steel	Hardened Steel
(< 35HRC)	(35-48 HRC)	(< 55HRC)	(55-60HRC)	(> 60HRC)
	○	○	○	○

○ Most Suitable ○ Suitable

## FH200-H

For Alloy Steel, Hardened Steel—— Face milling



Workpiece Material		D ( mm )	Vc ( m/min )	( min <sup>-1</sup> )	Vf ( mm/min )	ap ( mm )	ae ( mm )
<b>H</b>	( 35~65HRC )	6	60-90	3200-4800	1920-2880	≤0.2	3
		8		2400-3600	1950-2920	≤0.3	4
		10		1900-2900	1950-2950	≤0.35	5
		12		1600-2400	1920-2880	≤0.4	6
		16		1200-1800	2160-3240	≤0.6	8
		20		950-1450	2280-3480	≤0.7	10

**Note:**

1. Turning red is a normal phenomenon in the process of processing, as long as the machine does not have obvious vibration or cutting tool without obvious damage, you can continue to use.
2. Tool bottom edge center without cutting edge, vertical knife is not allowed, should be from the edge of the workpiece into the knife, or into the oblique knife.
3. The knife type is not suitable for large depth and side milling.