



# A Brand AE-ML-H

Advanced Performance Carbide End Mills with Long LOC for Hardened Steels

## List 8442, 8542: Multi-Flute, Long Length, Square

### Side Milling

Hardness	Up to 45 HRC		45-55 HRC		55-62 HRC		62-66 HRC		66-70 HRC			
Work Material	Tool Steels Hardened Steels Alloy Steels		Hardened Steels									
Cutting Speed (SFM)	195 SFM		145 SFM		100 SFM		65 SFM		50 SFM			
Depth of Cut												
Mill Dia.		Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	
Inch	mm											
-	3	6,370	25.6	4,780	14.6	3,180	6.7	2,120	3.9	1,590	2.4	
1/8	-	5,954	25.3	4,427	14.4	3,053	6.9	1,985	3.9	1,527	2.4	
-	4	4,780	25.6	3,580	14.6	2,390	6.7	1,590	3.9	1,190	2.4	
3/16	-	3,969	25.3	2,952	14.4	2,036	6.9	1,323	3.9	1,018	2.4	
-	5	3,820	25.6	2,870	14.6	1,910	6.7	1,270	3.9	960	2.4	
-	6	3,180	38.2	2,390	22.0	1,590	10.2	1,060	5.9	800	3.5	
1/4	-	2,977	38.0	2,214	21.6	1,527	10.3	992	5.8	763	3.5	
5/16	-	2,382	38.0	1,771	21.6	1,221	10.3	794	5.8	611	3.5	
-	8	2,390	38.2	1,790	22.0	1,190	10.2	800	5.9	600	3.5	
3/8	-	1,985	38.0	1,476	21.6	1,018	10.3	662	5.8	509	3.5	
-	10	1,910	38.2	1,430	22.0	960	10.2	640	5.9	480	3.5	
-	12	1,590	38.2	1,190	22.0	800	10.2	530	5.9	400	3.5	
1/2	-	1,489	38.0	1,107	21.6	763	10.3	496	5.8	382	3.5	

1. Use a rigid and precise machine and holder.
2. When chattering occurs, reduce the speed and feed simultaneously.
3. Use an air blow or a suitable cutting fluid with high smoke retardant properties.

ABOUT OSG

DRILLING

THREADING

MILLING

HOLDERS

INDEX

