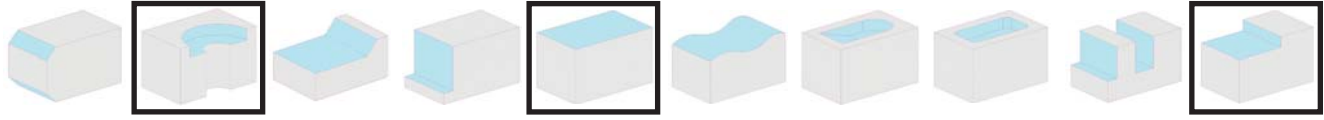


HPEM Series

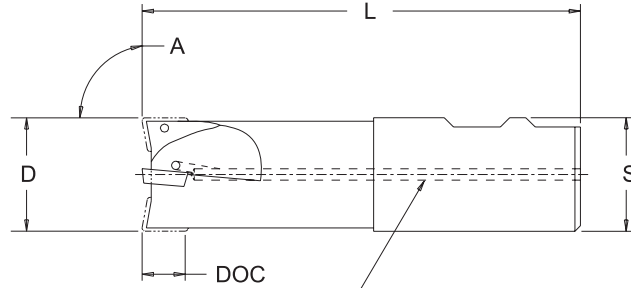


End Mills

5° Pos Axial Pos Radial 90° Shoulder






• 90° Shoulder



Through coolant
Except .750 Diameter

HPEM Series - Dimensional Specifications

Product Number	D	S	L	A	DOC	Insert	Screw	Teeth	Weight
0.75HPEMRW3	.75	.75	4.08	90°	.47	CPEH-322.52-4W	3605-0001-0022	1	.75
1.00HPEMRW4	1.00	1.00	4.13	90°	.47	CPEH-322.52-4W	3605-0001-0021	2	1.05
1.25HPEMRW4	1.25	1.00	4.63	90°	.47	CPEH-322.52-4W	3605-0001-0021	3	1.55
1.50HPEMRW5	1.50	1.25	4.63	90°	.47	CPEH-322.52-4W	3605-0001-0021	3	2.25
2.00HPEMRW5	2.00	1.25	4.63	90°	.47	CPEH-322.52-4W	3605-0001-0022	5	2.75

Insert I.C. x Thickness	 Insert Pg. 31	 Insert Screw	 Insert Screw Wrench
.375 x .156	CPEH-322.52-4W	3605-0001-0021 3605-0001-0022	1557-TX15

Machining Parameters

Material	SFPM	FPT	Primary	Secondary
Tool Steel D2	250-350	.003-.012	CPEH-322.52-4WB GR LT-50	CPEH-322.52-4WB GR LTC-14
Medium Alloy Steel	300-700	.003-.012	CPEH-322.52-4W GR 606jRm	CPEH-322.52-4W GR LTC-14
Soft Alloy Steel	400-800	.003-.012	CPEH-322.52-4W GR 606jRm	CPEH-322.52-4W GR LTC-14

- Through Coolant Capability (only on 1.00 diameter and up)
- Double positive geometry accommodates a broad range of workpiece materials
- Engineered in a coarse pitch insert count to accommodate heavy feed rates
- Standard CPEH-322.52 inserts provide excellent DOC to diameter ratios
- Insert compatibility makes the HPEM an ideal companion tool to the HPSM series

