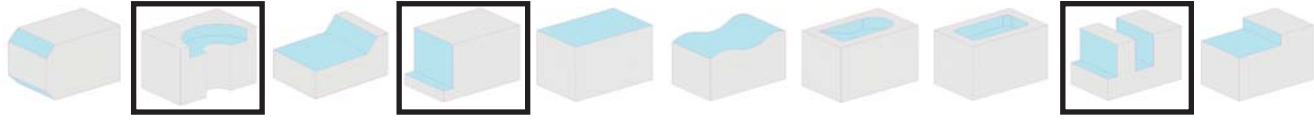
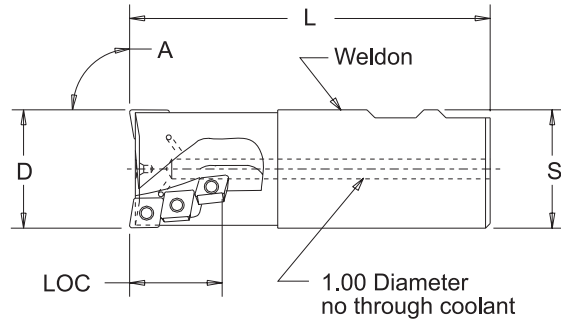


HPSM Series



Slab Mills





Neg Axial Neg Axial 90° Shldr -to 1.50 dia
 Neg Axial Pos Radial 90° Shldr -over 1.50 dia



• **General Purpose**

HPSM Series - Dimensional Specifications

Product Number	D	OD	S	L	A	LOC	Insert	Teeth	Eff. Flutes	Weight
1.00-1.00HPSMRW4	1.00	1.00	1.00	4.16	90°	1.31	CPEH-32.52-4W CPEH-322.52-4W	5 1	2	1.00
1.25-1.00HPSMRW5	1.25	1.25	1.25	4.16	90°	1.31	CPEH-32.52-4W CPEH-322.52-4W	5 1	2	1.50
1.25-2.00HPSMRW5	1.25	1.25	1.25	5.03	90°	2.25	CPEH-32.52-4W CPEH-322.52-4W	9 1	2	1.75
1.50-1.00HPSMRW6	1.50	1.50	1.50	4.50	90°	1.31	CPEH-32.52-4W CPEH-322.52-4W	7 2	3	2.25
1.50-2.50HPSMRW6	1.50	1.50	1.50	5.81	90°	2.62	CPEH-32.52-4W CPEH-322.52-4W	19 2	3	3.00
2.00-2.50HPSMRW8	2.00	2.00	2.00	6.37	90°	2.62	CPEH-32.52-4W CPEH-322.52-4W	22 2	4	5.50
2.00-4.00HPSMRW8	2.00	2.00	2.00	7.68	90°	4.00	CPEH-32.52-4W CPEH-322.52-4W	34 2	4	6.75

Insert I.C. x Thickness				
	Insert Pg. 31	Insert Pg. 31	Insert Screw	Insert Screw Wrench
.375 x .156	CPEH-322.52-4W	CPEH-32.52-4W	3605-0001-0021	1557-TX10

Machining Parameters

Material	SFPM	FPT	Primary	Secondary
Tool Steel D2	250-350	.003-.012	GR 606jRm	GR LT-50
Medium Alloy Steel	300-700	.003-.012	GR 606jRm	GR LTC-14
Tool Steel P20	300-700	.003-.012	GR 606jRm	GR LTC-14
Soft Alloy Steel	400-800	.003-.012	GR 606jRm	GR LTC-14
Tool Steel, D2 Cutting Slots	250-350	.003-.012	GR 606jRm	GR LT-50
Medium Alloy Steel Cutting Slots	300-700	.003-.012	GR 606jRm	GR LTC-14
Tool Steel, P20 Cutting Slots	300-700	.003-.012	GR 606jRm	GR LTC-14

- Through Coolant Capability (only on 1.25 diameter and up)
- Reverse helical flutes stabilize the HPSM during severe machining conditions
- Helical flutes ensure smooth cutting action and excellent chip evacuation
- Excellent overall length to diameter ratio ensures necessary rigidity and stiffness
- CPEH-32.52 type inserts provide 4 indexes for greater economy
- Inserts available in NEW PVD TiAlN coated grades 586XRm and 606jRm