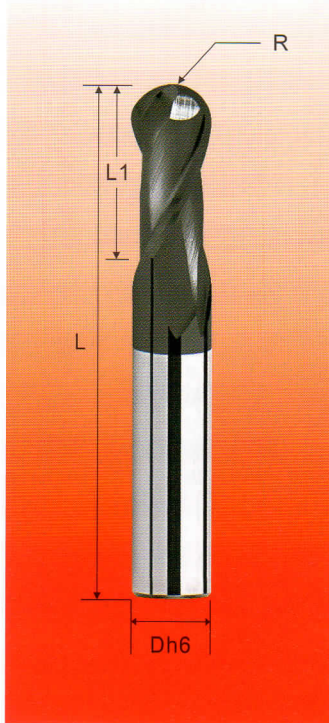
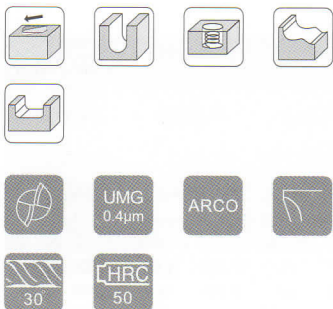


ESB□A2



Order No. 訂單編號	Radius 半徑 (R)	Dia. 刃徑 (d)	CL 刃長 (L1)	OAL 全長 (L)	Shank 柄徑 (D)	Flutes 刃數 (F)
ESBFA202000A	1.0R	2	4	50	4	2
ESBFA203000A	1.5R	3	6	50	4	2
ESBFA204000A	2.0R	4	8	50	4	2
ESBSA204000A	2.0R	4	8	50	6	2
ESBSA205000A	2.5R	5	10	50	6	2
ESBSA206000A	3.0R	6	12	50	6	2
ESBSA208000A	4.0R	8	16	60	8	2
ESBSA210000A	5.0R	10	20	75	10	2
ESBSA212000A	6.0R	12	24	75	12	2
ESBSA214000A	7.0R	14	28	75	14	2
ESBSA216000A	8.0R	16	32	100	16	2
ESBOA202000A	1.0R	2	2	50	4	2
ESBOA203000A	1.5R	3	3	50	4	2
ESBOA204000A	2.0R	4	4	50	4	2
ESBHA204000A	2.0R	4	4	50	6	2
ESBHA205000A	2.5R	5	5	50	6	2
ESBHA206000A	3.0R	6	6	50	6	2
ESBHA208000A	4.0R	8	8	60	8	2
ESBHA210000A	5.0R	10	10	75	10	2
ESBHA212000A	6.0R	12	12	75	12	2
ESBHA214000A	7.0R	14	14	75	14	2
ESBHA216000A	8.0R	16	16	100	16	2



d	R Tol.
$\varnothing \leq 12$	R \pm 0.01
$\varnothing > 12$	R \pm 0.015

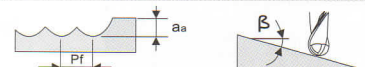
WORKING MATERIAL	ALLOY STEEL /TOOL STEEL	ALLOY STEEL /TOOL STEEL	ALLOY STEEL /TOOL STEEL	HARDENED STEEL	STAINLESS STEEL	CAST IRON						
MATERIAL CODE	45C,S50C,SCM	SCM,SKT,SKD	SCM,SKT,SKD	SKT,SKD	SUS304	FC/PCD						
HARDNESS GRADE	HRC <20	HRC 20~30	HRC 30~40	HRC 45~55	—	—						
Vc	72M/min	54M/min	34M/min	29M/min	54M/min	72M/min						
DIAMETER	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)
0.5R	36,000	545	32,400	420	21,600	230	14,400	110	32,400	490	45,000	685
1.0R	20,520	700	16,200	470	11,700	280	8,200	140	16,200	555	22,860	780
2.0R	11,520	875	8,640	560	6,300	335	4,600	175	8,640	655	11,520	875
3.0R	7,560	860	5,760	560	3,780	300	3,020	170	5,760	655	7,560	860
4.0R	5,760	875	4,320	560	2,880	305	2,300	175	4,320	655	5,760	875
5.0R	4,590	870	3,420	550	2,160	285	1,830	175	3,420	650	4,590	870
6.0R	3,780	860	2,880	560	1,800	285	1,520	175	2,880	655	3,780	860
8.0R	3,200	970	2,400	620	1,560	330	1,280	195	2,400	730	3,200	970
10.0R	2,600	890	1,920	560	1,300	310	1,040	175	1,920	655	2,600	890

Bright Finishing (超精銑)	○
Finishing (精銑)	◎
Semi-Finishing (中銑)	◎
Roughing (粗銑)	○

When β is less than 15° milling speed and feed speed in the table can be increased 1.0~1.2 times.

Milling Amount (mm)

$a_a = 0.02D$
 $Pf = 0.05D$



The Feed & RPM may be changed depending on the M/C Conditions, Lubricating & Cooling systems.