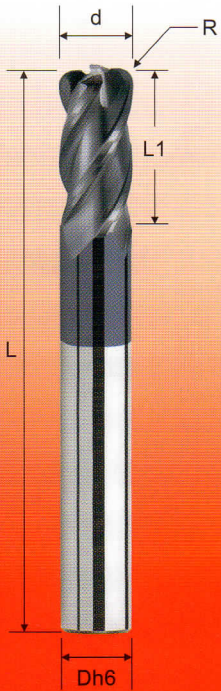
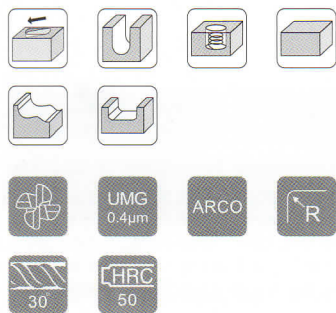


ESCSA4



Order No. 訂單編號	Dia. 刃徑 (d)	Corner Radius R 角 (R)	CL 刃長 (L1)	OAL 全長 (L)	Shank 柄徑 (D)	Flutes 刃數 (F)
ESCSA403003A	3	0.3R	6	50	6	4
ESCSA403005A	3	0.5R	6	50	6	4
ESCSA403010A	3	1.0R	6	50	6	4
ESCSA404003A	4	0.3R	8	50	6	4
ESCSA404005A	4	0.5R	8	50	6	4
ESCSA404010A	4	1.0R	8	50	6	4
ESCSA405003A	5	0.3R	10	50	6	4
ESCSA405005A	5	0.5R	10	50	6	4
ESCSA406003A	6	0.3R	12	50	6	4
ESCSA406005A	6	0.5R	12	50	6	4
ESCSA406010A	6	1.0R	12	50	6	4
ESCSA408005A	8	0.5R	16	60	8	4
ESCSA408010A	8	1.0R	16	60	8	4
ESCSA408015A	8	1.5R	16	60	8	4
ESCSA410005A	10	0.5R	20	75	10	4
ESCSA410010A	10	1.0R	20	75	10	4
ESCSA410015A	10	1.5R	20	75	10	4
ESCSA410020A	10	2.0R	20	75	10	4
ESCSA412005A	12	0.5R	24	75	12	4
ESCSA412010A	12	1.0R	24	75	12	4
ESCSA412015A	12	1.5R	24	75	12	4
ESCSA412020A	12	2.0R	24	75	12	4
ESCSA412030A	12	3.0R	24	75	12	4



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	68M/min	54M/min	45M/min	27M/min	54M/min	79M/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)
1MM	20,000	190	17,100	140	14,400	100	8,000	40	17,100	165	25,200	240
2MM	10,800	235	8,640	160	7,200	110	4,320	45	8,640	185	12,600	270
3MM	7,560	270	5,760	175	4,680	120	3,000	55	5,760	205	8,640	310
4MM	5,400	260	4,320	175	3,600	120	2,160	50	4,320	205	6,480	310
5MM	4,500	270	3,420	175	2,880	120	1,800	55	3,420	205	5,040	300
6MM	3,600	260	2,880	175	2,340	120	1,440	50	2,880	205	4,320	310
8MM	2,700	260	2,160	175	1,800	120	1,080	50	2,160	205	3,240	310
10MM	2,160	260	1,710	175	1,440	120	870	50	1,710	205	2,520	300
12MM	1,800	260	1,440	175	1,200	120	720	50	1,440	205	2,160	310
14MM	1,800	300	1,360	195	1,140	135	720	60	1,360	230	2,000	335
16MM	1,560	300	2,100	345	1,000	135	630	60	2,100	400	1,800	345
18MM	1,560	305	1,060	175	880	120	630	60	1,060	205	1,600	310
20MM	1,200	260	960	175	800	120	480	50	960	205	1,400	300

d	Tolerance
∅ ≤ 12	0 ~ -0.02
∅ > 12	0 ~ -0.03

R	Tolerance
R	R ± 0.015

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

Milling Amount (mm)	aa	ar
D < ∅ 6	1.0D	0.02D
∅ 6 ≤ D	1.0D	0.05D

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