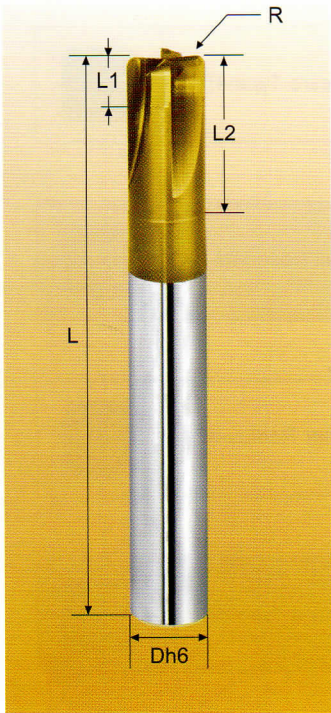
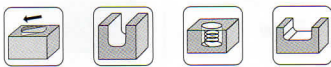


# EHC-□S4

(SH Type) 超高硬



Order No. 訂購編號	Dia. 刃徑 (d)	Corner Radius R 角 (R)	CL 刃長 (L1)	EFF-L 有效長 (L2)	OAL 全長 (L)	Shank 柄徑 (D)	Flutes 刃數 (F)
EHCPS401002S	1	0.20R	1	2.5	50	4	4
EHCPS402002S	2	0.25R	2	6.5	50	4	4
EHCUS403005S	3	0.50R	3	7.5	50	6	4
EHCUS404005S	4	0.50R	4	10.0	50	6	4
EHCUS404010S	4	1.00R	4	10.0	50	6	4
EHCUS405010S	5	1.00R	5	12.5	50	6	4
EHCUS406010S	6	1.00R	6	15.0	50	6	4
EHCUS406015S	6	1.50R	6	15.0	50	6	4
EHCUS408010S	8	1.00R	8	20.0	60	8	4
EHCUS408015S	8	1.50R	8	20.0	60	8	4
EHCUS408020S	8	2.00R	8	20.0	60	8	4
EHCUS410010S	10	1.00R	10	25.0	75	10	4
EHCUS410020S	10	2.00R	10	25.0	75	10	4
EHCUS412010S	12	1.00R	12	30.0	75	12	4
EHCUS412020S	12	2.00R	12	30.0	75	12	4
EHCUS412030S	12	3.00R	12	30.0	75	12	4

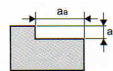


d	Tolerance
$\varnothing \leq 12$	0 ~ -0.02
$\varnothing > 12$	0 ~ -0.03

R	Tolerance
R	$R \pm 0.015$

Finishing (精銼)	◎
Semi-Finishing (中銼)	◎
Roughing (粗銼)	○

WORKING MATERIAL	HARDENED STEEL		HARDENED STEEL		HARDENED STEEL	
MATERIAL CODE	SKT,SKD		SKT,SKD		SKT,SKD	
HARDNESS GRADE	HRC 45~55		HRC 55~60		HRC 60~70	
Vc	50 M / min		30 M / min		20 M / min	
DIAMETER	R.P.M	FEED (mm / min.)	R.P.M	FEED (mm / min.)	R.P.M	FEED (mm / min.)
1MM	15,900	2,150	9,500	980	6,370	500
2MM	7,950	2,145	4,750	980	3,180	500
3MM	5,300	2,150	3,200	990	2,120	500
4MM	4,000	2,160	2,400	990	1,590	500
6MM	2,650	2,150	1,600	990	1,060	500
8MM	2,000	2,160	1,200	990	795	500
10MM	1,600	2,160	955	980	635	500
12MM	1,350	2,190	795	980	530	500



Milling Amount (mm)

	aa	ap
$R \leq 2$	0.2 x R	0.5D
$R > 2$	0.4mm	0.5D

	aa	ap
$R \leq 2$	0.1 x R	0.5D
$R > 2$	0.2mm	0.5D

	aa	ap
$R \leq 2$	0.1 x R	0.5D
$R > 2$	0.2mm	0.5D

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