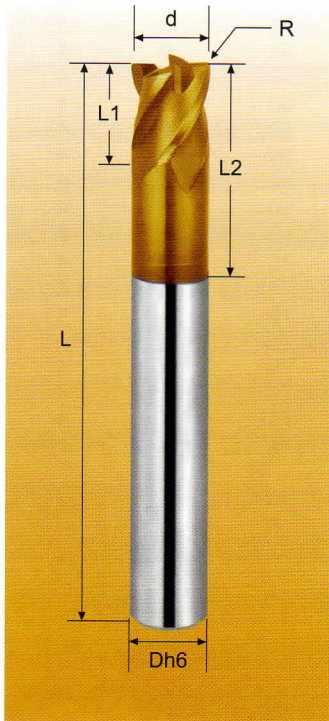


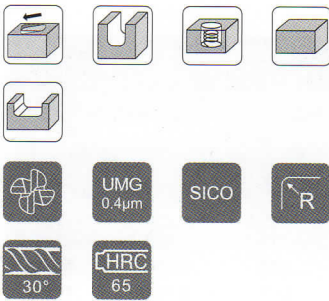
EHC-UH4

(H Type) 高硬



- Corner Radius & Short Type for Hardened Steel

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)
EHCUH403001S	3	0.1R	3	7.5	50	6	4
EHCUH403005S	3	0.5R	3	7.5	50	6	4
EHCUH404002S	4	0.2R	4	10.0	50	6	4
EHCUH404005S	4	0.5R	4	10.0	50	6	4
EHCUH405002S	5	0.2R	5	12.5	50	6	4
EHCUH405005S	5	0.5R	5	12.5	50	6	4
EHCUH406002S	6	0.2R	6	15.0	50	6	4
EHCUH406005S	6	0.5R	6	15.0	50	6	4
EHCUH406010S	6	1.0R	6	15.0	50	6	4
EHCUH408003S	8	0.3R	8	20.0	60	8	4
EHCUH408005S	8	0.5R	8	20.0	60	8	4
EHCUH408010S	8	1.0R	8	20.0	60	8	4
EHCUH408015S	8	1.5R	8	20.0	60	8	4
EHCUH410003S	10	0.3R	10	25.0	75	10	4
EHCUH410005S	10	0.5R	10	25.0	75	10	4
EHCUH410010S	10	1.0R	10	25.0	75	10	4
EHCUH410015S	10	1.5R	10	25.0	75	10	4
EHCUH410020S	10	2.0R	10	25.0	75	10	4
EHCUH412003S	12	0.3R	12	30.0	75	12	4
EHCUH412005S	12	0.5R	12	30.0	75	12	4
EHCUH412010S	12	1.0R	12	30.0	75	12	4
EHCUH412015S	12	1.5R	12	30.0	75	12	4
EHCUH412020S	12	2.0R	12	30.0	75	12	4



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

R	Tolerance
R	R ± 0.015

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

WORKING MATERIAL	HARDENED STEEL	HARDENED STEEL	HARDENED STEEL			
MATERIAL CODE	(SKT , SKD)	(SKT , SKD)	(SKT , SKD)			
HARDNESS GRADE	HRC 35-45	HRC 45-55	HRC 55-60			
Vc	110 M / min	95 M / min	79 M / min			
DIAMETER	R.P.M rev/min	FEED (mm/min)	R.P.M rev/min	FEED (mm/min)	R.P.M rev/min	FEED (mm/min)
3MM	11,800	1,150	10,000	830	8,400	500
4MM	8,800	1,070	7,600	780	6,300	460
5MM	7,000	990	6,000	730	5,000	420
6MM	5,900	910	5,000	660	4,200	400
8MM	4,400	830	3,800	610	3,200	400
10MM	3,500	830	3,000	610	2,550	400
12MM	2,900	830	2,500	610	2,100	400

Milling Amount (mm)		aa	ar
		$D < \phi 6$ $\phi 6 \leq D$	0.9D 0.9D

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