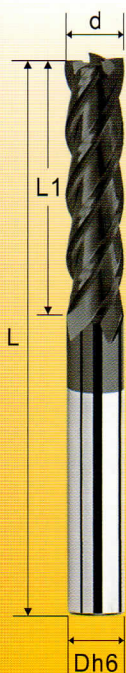


MICRO GRAIN CARBIDE END MILLS - Square Type & Long Flute - 4F

鎢鋼平銑刀-長刃型

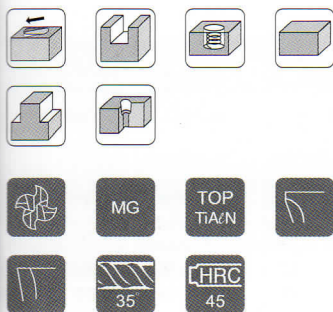
EPS-CA4



Order No. 訂購編號	Dia. 刀徑 (d)	CL 刃長 (L1)	OAL 全長 (L)	Shank 柄徑 (D)	Flutes 刃數 (F)
EPSCA403000T	3.0	15	60	6	4
EPSCA404000T	4.0	20	60	6	4
EPSCA405000T	5.0	25	75	6	4
EPSCA406000T	6.0	30	75	6	4
EPSCA408000T	8.0	35	100	8	4
EPSCA410000T	10.0	45	100	10	4
EPSCA412000T	12.0	45	100	12	4
EPSCA414000T	14.0	70	150	14	4
EPSCA416000T	16.0	70	150	16	4
EPSCA420000T	20.0	75	150	20	4
EPSCA425000T	25.0	75	150	25	4

INCH SIZE

Order No.	Dia.	CL	OAL	Shank	Flutes
EPSCA403X00T	1/8	3/4	2-1/4	1/8	4
EPSCA404X00T	3/16	3/4	2-1/2	3/16	4
EPSCA406X00T	1/4	1-1/8	3	1/4	4
EPSCA409X00T	3/8	1-1/8	3	3/8	4
EPSCA412X00T	1/2	2	4-1/2	1/2	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/FCD	
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)
3MM	7,560	455	5,760	295	4,680	195	3,020	90	5,760	345	8,640	520
4MM	5,400	430	4,320	295	3,600	200	2,160	85	4,320	345	6,480	520
5MM	4,500	450	3,420	290	2,880	200	1,800	90	3,420	345	5,040	505
6MM	3,600	430	2,880	295	2,340	195	1,440	85	2,880	345	4,320	520
8MM	2,700	430	2,160	295	1,800	200	1,080	85	2,160	345	3,240	520
10MM	2,160	430	1,710	290	1,440	200	860	85	1,710	340	2,520	505
12MM	1,800	430	1,440	295	1,200	200	720	85	1,440	345	2,160	520
14MM	1,800	500	1,360	325	1,140	225	720	100	1,360	380	2,000	560
16MM	1,560	500	1,200	325	1,000	225	620	100	1,200	385	1,800	575
18MM	1,400	455	1,060	290	880	200	560	90	1,060	345	1,600	520
20MM	1,200	430	960	295	800	200	480	85	960	345	1,400	505

d (刀徑)	Tolerance (公差)
Ø < 3	0 ~ -0.03
3 ≤ Ø ≤ 10	0 ~ -0.04
Ø > 10	0 ~ -0.05

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

Milling Amount (mm) AD=1.5D, RD<=0.1D



AD=1.5D
RD<=0.05D

AD=1.5D, RD<=0.1D

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