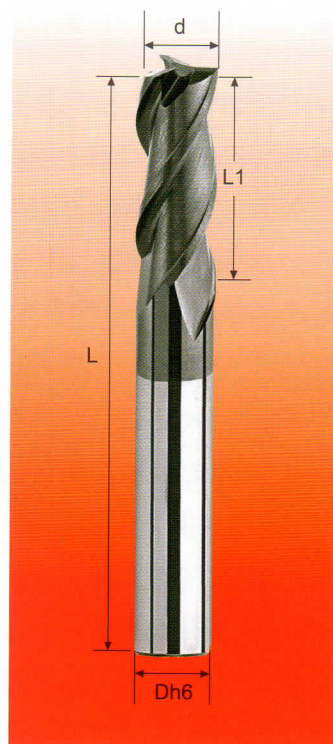
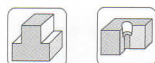


ESS□A3



Order No. 訂單編號	Dia. 刀徑 (d)	CL 刃長 (L1)	OAL 全長 (L)	Shank 柄徑 (D)	Flutes 刃數 (F)
ESSFA303000A	3	8	50	4	3
ESSFA304000A	4	10	50	4	3
ESSSA304000A	4	10	50	6	3
ESSSA305000A	5	13	50	6	3
ESSSA306000A	6	15	50	6	3
ESSSA308000A	8	20	60	8	3
ESSSA310000A	10	25	75	10	3
ESSSA312000A	12	30	75	12	3
ESSSA314000A	14	30	75	14	3
ESSSA316000A	16	35	100	16	3

ESSOA303000A	3	3	50	4	3
ESSOA304000A	4	4	50	4	3
ESSHA304000A	4	4	50	6	3
ESSHA305000A	5	5	50	6	3
ESSHA306000A	6	7	50	6	3
ESSHA308000A	8	9	60	8	3
ESSHA310000A	10	11	75	10	3
ESSHA312000A	12	13	75	12	3
ESSHA314000A	14	15	75	14	3
ESSHA316000A	16	17	100	16	3



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

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

WORKING MATERIAL	STAINLESS 304		Moderately Difficults SUS		STAINLESS 316 L		TITANIUM (ALLOYS)		SOFT STEEL		SG CAST IRON		High Temperature ALLOYS	
Vc	72~90 M/min		56~70 M/min		48~60 M/min		40~56 M/min		120~160M/min		96~120M/min		20~25 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	R.P.M rev/min	FEED mm/min	R.P.M rev/min	FEED mm/min	R.P.M rev/min	FEED mm/min	R.P.M rev/min	FEED mm/min
4	5,732	458	4,459	286	3,822	183	3,185	122	9,554	764	7,643	611	1,592	56
5	4,586	440	3,567	286	3,057	245	2,548	122	7,643	734	6,115	587	1,274	45
6	3,822	489	2,972	333	2,548	245	2,123	136	6,369	815	5,096	652	1,062	58
8	2,866	458	2,229	321	1,911	245	1,592	153	4,777	917	3,822	734	796	69
10	2,293	440	1,783	286	1,529	220	1,274	124	3,822	734	3,057	587	637	55
12	1,911	398	1,486	262	1,274	204	1,062	136	3,185	714	2,548	570	531	65
14	1,638	351	1,274	232	1,092	185	910	126	2,730	637	2,184	510	455	65
16	1,433	321	1,115	214	955	168	796	114	2,389	574	1,911	458	398	62

Milling Amount
(mm)

	aa	ar
$D < \varnothing 6$	1.0D	0.02D
$\varnothing 6 \leq D$	1.0D	0.05D



	aa	ar
$D < \varnothing 6$	1.0D	0.01D
$\varnothing 6 \leq D$	1.0D	0.02D

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