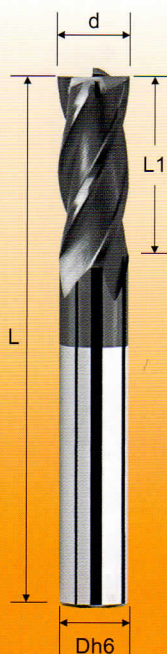


MICRO GRAIN CARBIDE END MILLS - Unequal Square Type - 4F

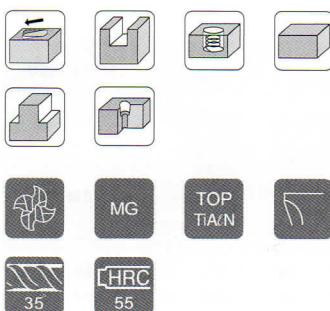
不等分割刃平刀

EPSFD4

EPSSD4



Order No. 訂單編號	Dia. 刃徑 (d)	CL 刃長 (L1)	OAL 全長 (L)	Shank 柄徑 (D)	Flutes 刃數 (F)
EPSFD404000T	4	10	50	4	4
EPSSD405000T	5	13	50	6	4
EPSSD406000T	6	13	50	6	4
EPSSD408000T	8	16	60	8	4
EPSSD410000T	10	20	75	10	4
EPSSD412000T	12	24	75	12	4
EPSSD414000T	14	28	75	14	4
EPSSD416000T	16	30	100	16	4



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 Difficult 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	573	4,459	357	3,822	229	3,185	153	9,554	955	7,643	764	1,592	70
5	4,586	550	3,567	357	3,057	306	2,548	153	7,643	917	6,115	734	1,274	56
6	3,822	611	2,972	416	2,548	306	2,123	170	6,369	1,019	5,096	815	1,062	72
8	2,866	573	2,229	401	1,911	306	1,592	191	4,777	1,146	3,822	917	796	86
10	2,293	550	1,783	357	1,529	275	1,274	155	3,822	917	3,057	734	637	69
12	1,911	497	1,486	327	1,274	255	1,062	170	3,185	892	2,548	713	531	81
14	1,638	439	1,274	290	1,092	231	910	157	2,730	797	2,184	638	455	82
16	1,433	401	1,115	268	955	210	796	143	2,389	717	1,911	573	398	78

Milling Amount (mm)	aa = 1.0D ar = 0.5D		aa = 1.0D ar = 0.2D
	ad = 1.0D		ad = 0.3D

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