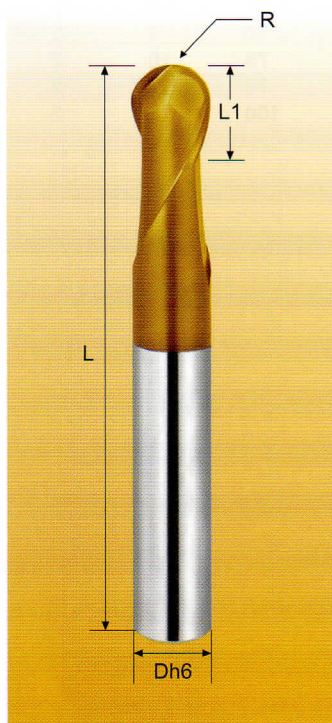


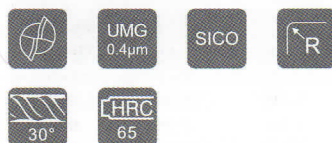
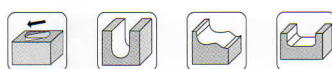
EHB-□H2

(H Type) 高硬



- Ball Nosed for Hardened Steel

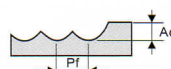
Order No.	Radius	Dia.	CL	OAL	Shank	Flutes
訂購編號	半徑 (R)	刃徑 (d)	刃長 (L1)	全長 (L)	柄徑 (D)	刃數 (F)
EHBFH202000S	1.0R	2	4	50	4	2
EHBFH203000S	1.5R	3	6	50	4	2
EHBFH204000S	2.0R	4	8	50	4	2
EHBSH205000S	2.5R	5	10	50	6	2
EHBSH206000S	3.0R	6	12	50	6	2
EHBSH208000S	4.0R	8	16	60	8	2
EHBSH210000S	5.0R	10	20	75	10	2
EHBSH212000S	6.0R	12	24	75	12	2
EHBSH216000S	8.0R	16	32	100	16	2



d	Tolerance
$\varnothing \leq 12$	$R \pm 0.01$
$\varnothing > 12$	$R \pm 0.015$

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	200 M / min		150 M / min		99 M / min	
DIAMETER	R.P.M	FEED (mm / min)	R.P.M	FEED (mm / min)	R.P.M	FEED (mm / min)
1.0R	32,000	1,920	24,000	1,440	16,000	960
2.0R	16,000	1,920	12,000	1,440	7,950	955
3.0R	10,500	1,890	7,950	1,430	5,300	955
4.0R	7,950	1,910	5,950	1,430	4,000	960
5.0R	6,350	1,905	4,800	1,440	3,200	960
6.0R	5,300	1,910	4,000	1,440	2,650	955
8.0R	4,000	1,920	3,000	1,440	2,000	960
10.0R	3,200	1,920	2,400	1,440	1,600	960



Milling Amount (mm)

Ad	Pf
0.05D	0.1D
apMax=0.6mm以下	

Ad	Pf
0.03D	0.1D
apMax=0.5mm以下	

Ad	Pf
0.02D	0.05D
apMax=0.3mm以下	

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