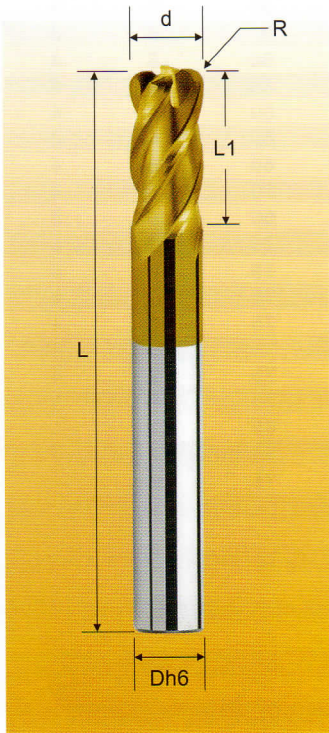


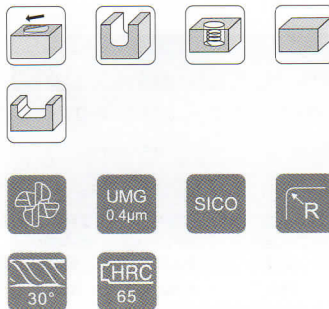
EHC-□H4

(H Type) 高硬

- Corner Radius for Hardened Steel



Order No. 訂購編號	Dia. 刃徑 (d)	Corner Radius R 角 (R)	CL 刃長 (L1)	OAL 全長 (L)	Shank 柄徑 (D)	Flutes 刃數 (F)
EHC FH404003S	4	0.3R	8	50	4	4
EHC FH404005S	4	0.5R	8	50	4	4
EHC FH404010S	4	1.0R	8	50	4	4
EHC SH404003S	4	0.3R	8	50	6	4
EHC SH404005S	4	0.5R	8	50	6	4
EHC SH404010S	4	1.0R	8	50	6	4
EHC SH405005S	5	0.5R	10	50	6	4
EHC SH405010S	5	1.0R	10	50	6	4
EHC SH406003S	6	0.3R	12	50	6	4
EHC SH406005S	6	0.5R	12	50	6	4
EHC SH406010S	6	1.0R	12	50	6	4
EHC SH408005S	8	0.5R	16	60	8	4
EHC SH408010S	8	1.0R	16	60	8	4
EHC SH408015S	8	1.5R	16	60	8	4
EHC SH410005S	10	0.5R	20	75	10	4
EHC SH410010S	10	1.0R	20	75	10	4
EHC SH410015S	10	1.5R	20	75	10	4
EHC SH410020S	10	2.0R	20	75	10	4
EHC SH412005S	12	0.5R	20	75	12	4
EHC SH412010S	12	1.0R	20	75	12	4
EHC SH412015S	12	1.5R	20	75	12	4
EHC SH412020S	12	2.0R	20	75	12	4



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

R	Tolerance
R	R ± 0.015

Finishing (精銼)	◎
Semi-Finishing (中銼)	◎
Roughing (粗銼)	○

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)



	a _a	a _r
D < ∅ 6	0.9D	0.01D
∅ 6 ≤ D	0.9D	0.02D

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