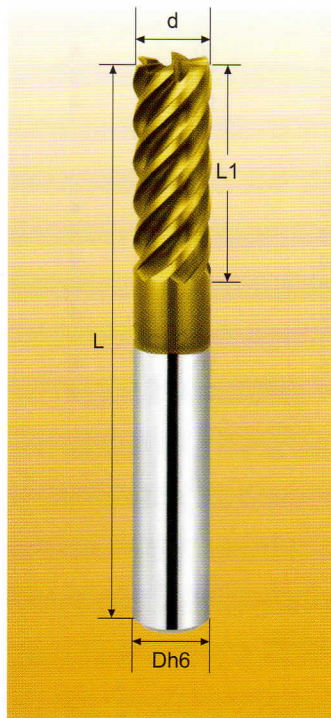


EHS-SS6

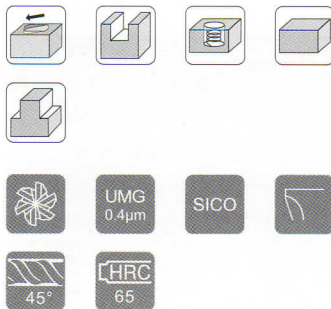
(SH Type) 超高硬

- Square Type for Super Hardened Steel



Order No. 訂購編號	Dia. 刃徑 (d)	CL 刃長 (L1)	OAL 全長 (L)	Shank 柄徑 (D)	Flutes 刃數 (F)
EHSSS606000S	6	15	50	6	6
EHSSS608000S	8	20	60	8	6
EHSSS610000S	10	25	75	10	6
EHSSS612000S	12	30	75	12	6
EHSSS614000S	14	30	75	14	6
EHSSS816000S	16	40	100	16	8
EHSSS818000S	18	40	100	18	8
EHSSS820000S	20	45	100	20	8

INCH SIZE					
EHSSS606X00S	1/4	3/4	2-1/2	1/4	6
EHSSS609X00S	5/16	13/16	2-1/2	5/16	6
EHSSS612X00S	1/2	1	3	1/2	6
EHSSS815X00S	5/8	1-1/4	3-1/2	5/8	8
EHSSS819X00S	3/4	1-1/2	4	3/4	8



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

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 45~55		HRC 55~60		HRC 60~70	
Vc	99 M / min		75 M / min		50 M / min	
DIAMETER	R.P.M	FEED (mm / min)	R.P.M	FEED (mm / min)	R.P.M	FEED (mm / min)
6MM	5,300	1,900	4,000	1,000	2,650	505
8MM	4,000	1,900	3,000	1,000	2,000	505
10MM	3,200	1,900	2,400	1,000	1,600	505
12MM	2,650	1,900	2,000	1,000	1,350	505
14MM	2,250	1,800	1,700	1,000	1,100	505
16MM	1,950	1,700	1,550	930	995	505
18MM	1,750	1,600	1,450	895	885	505
20MM	1,550	1,500	1,150	845	800	505
25MM	1,250	1,500	955	915	635	505



Milling Amount (mm)

ap	ae
1.5D	0.05D
aeMax=1.0mm以下	

ap	ae
1.5D	0.03D
aeMax=0.5mm以下	

ap	ae
1.0D	0.02D
aeMax=0.5mm以下	

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