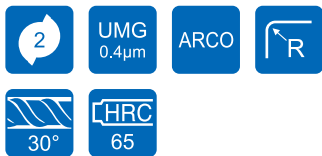
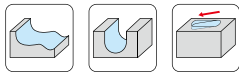
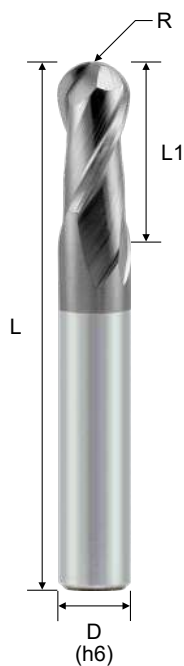


H650 - Ball Nose · 2F

- ARCO coating provides a superior wear resistance.
- Suitable for HRC 50 and over HRC 50 Hardened Steel, also maximum up to HRC 65.
- Due to short cutting length provides an excellent face milling surface roughness of the work pieces.
- New tool geometry increases wear resistance and cutting force is decreased.
- The coating can change to SICO.

EHBSH



R Tolerance	
R ≤ 3	±0.010
R > 3	±0.015

Order No.	Radius (R)	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EHBSH240200A	0.10R	0.2	0.4	50	4	2
* EHBSH240300A	0.15R	0.3	0.6	50	4	2
* EHBSH240400A	0.20R	0.4	0.8	50	4	2
* EHBSH240500A	0.25R	0.5	1	50	4	2
* EHBSH240600A	0.30R	0.6	1.2	50	4	2
* EHBSH240700A	0.35R	0.7	1.4	50	4	2
* EHBSH240800A	0.40R	0.8	1.6	50	4	2
* EHBSH240900A	0.45R	0.9	1.8	50	4	2
* EHBSH241000A	0.50R	1.0	2	50	4	2
* EHBSH241500A	0.75R	1.5	3	50	4	2
* EHBSH242000A	1.00R	2.0	4	50	4	2
* EHBSH233000A	1.50R	3.0	6	50	3	2
* EHBSH243000A	1.50R	3.0	6	50	4	2
* EHBSH244000A	2.00R	4.0	8	50	4	2
EHBSH205000A	2.50R	5.0	10	50	6	2
EHBSH206000A	3.00R	6.0	12	50	6	2
EHBSH208000A	4.00R	8.0	16	60	8	2
EHBSH210000A	5.00R	10.0	20	75	10	2
EHBSH212000A	6.00R	12.0	24	75	12	2
EHBSH216000A	8.00R	16.0	32	100	16	2

Cutting conditions : Table 010

- * **A** is ARCO Coating
S is SICO Coating

Recommended Cutting Conditions

Table 010

H650 Seires EHBSH2

Material	PREHARDENED STEELS NAK80 CENA1				HARDENED STEELS SKD61,SKD11				Hardened Steel SKD11,SKH51			
Hardness	HRC 35~45				HRC 40~55				HRC 55~65			
Vc	145 (m/min)				125 (m/min)				105 (m/min)			
Radius	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)
1R	45270	1130	0.14	0.2	39030	975	0.14	0.2	32780	820	0.14	0.2
2R	22636	1358	0.28	0.4	19500	1170	0.28	0.4	16400	984	0.28	0.4
3R	15090	1130	0.42	0.6	13000	975	0.42	0.6	10930	820	0.42	0.6
4R	11320	905	0.56	0.8	9750	780	0.56	0.8	8195	655	0.56	0.8
5R	9055	770	0.7	1	7800	663	0.7	1	6555	557	0.7	1
6R	7545	680	0.84	1.2	6500	585	0.84	1.2	5460	491	0.84	1.2

Table 011

H650 Seires EHBLH2

Material	PREHARDENED STEELS NAK80 CENA1				HARDENED STEELS SKD61,SKD11				Hardened Steel SKD11,SKH51			
Hardness	HRC 35~45				HRC 40~55				HRC 55~65			
Vc	145 (m/min)				125 (m/min)				105 (m/min)			
Radius	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)
1R	36200	904	0.14	0.2	31200	780	0.14	0.2	26200	656	0.14	0.2
2R	18100	1086	0.28	0.4	15600	930	0.28	0.4	13120	787	0.28	0.4
3R	12050	904	0.42	0.6	10400	780	0.42	0.6	8750	656	0.42	0.6
4R	9050	724	0.56	0.8	7800	624	0.56	0.8	6550	524	0.56	0.8
5R	7250	616	0.7	1	6250	530	0.7	1	5250	446	0.7	1
6R	6036	544	0.84	1.2	5200	468	0.84	1.2	4370	393	0.84	1.2

1. Use as highly rigid and accurate machine as possible.
2. If the rpm available is lower than the recommend condition, please reduce the feed rate to the same ratio.
3. Use long shank type please reduce the rpm and feed rate.
4. The Feed and RPM may be changed depending on the M/C conditions, lubricating and cooling system.

