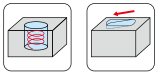
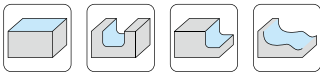
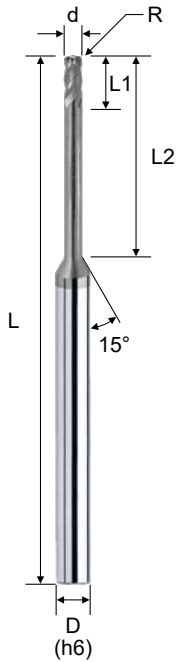


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- Available in various effective cutting lengths.
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- The coating can change to SICO, the prices will differ.

EHCRC



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

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

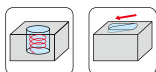
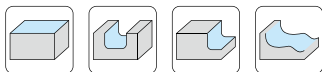
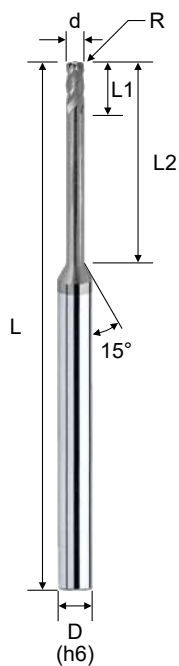
Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
*EHCRC44200106A	2.0	0.1R	2.0	6	50	4	4
*EHCRC44200108A	2.0	0.1R	2.0	8	50	4	4
*EHCRC44200110A	2.0	0.1R	2.0	10	50	4	4
*EHCRC44200112A	2.0	0.1R	2.0	12	50	4	4
*EHCRC44200116A	2.0	0.1R	2.0	16	50	4	4
*EHCRC44200120A	2.0	0.1R	2.0	20	50	4	4
*EHCRC44200125A	2.0	0.1R	2.0	25	60	4	4
*EHCRC44200206A	2.0	0.2R	2.0	6	50	4	4
*EHCRC44200208A	2.0	0.2R	2.0	8	50	4	4
*EHCRC44200210A	2.0	0.2R	2.0	10	50	4	4
*EHCRC44200212A	2.0	0.2R	2.0	12	50	4	4
*EHCRC44200216A	2.0	0.2R	2.0	16	50	4	4
*EHCRC44200220A	2.0	0.2R	2.0	20	50	4	4
*EHCRC44200225A	2.0	0.2R	2.0	25	60	4	4
*EHCRC44200306A	2.0	0.3R	2.0	6	50	4	4
*EHCRC44200308A	2.0	0.3R	2.0	8	50	4	4
*EHCRC44200310A	2.0	0.3R	2.0	10	50	4	4
*EHCRC44200312A	2.0	0.3R	2.0	12	50	4	4
*EHCRC44200316A	2.0	0.3R	2.0	16	50	4	4
*EHCRC44200320A	2.0	0.3R	2.0	20	50	4	4
*EHCRC44200325A	2.0	0.3R	2.0	25	60	4	4
*EHCRC44200506A	2.0	0.5R	2.0	6	50	4	4
*EHCRC44200508A	2.0	0.5R	2.0	8	50	4	4
*EHCRC44200510A	2.0	0.5R	2.0	10	50	4	4
*EHCRC44200512A	2.0	0.5R	2.0	12	50	4	4
*EHCRC44200516A	2.0	0.5R	2.0	16	50	4	4
*EHCRC44200520A	2.0	0.5R	2.0	20	50	4	4
*EHCRC44200525A	2.0	0.5R	2.0	25	60	4	4
EHCRC40200510A	2.0	0.5R	2.0	10	50	6	4
EHCRC40200515A	2.0	0.5R	2.0	15	50	6	4

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

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
*EHCRC44250110A	2.5	0.1R	2.5	10	50	4	4
*EHCRC44250116A	2.5	0.1R	2.5	16	50	4	4
*EHCRC44250120A	2.5	0.1R	2.5	20	50	4	4
*EHCRC44250125A	2.5	0.1R	2.5	25	60	4	4
*EHCRC44250210A	2.5	0.2R	2.5	10	50	4	4
*EHCRC44250216A	2.5	0.2R	2.5	16	50	4	4
*EHCRC44250220A	2.5	0.2R	2.5	20	50	4	4
*EHCRC44250225A	2.5	0.2R	2.5	25	60	4	4
*EHCRC44250310A	2.5	0.3R	2.5	10	50	4	4
*EHCRC44250316A	2.5	0.3R	2.5	16	50	4	4
*EHCRC44250320A	2.5	0.3R	2.5	20	50	4	4
*EHCRC44250325A	2.5	0.3R	2.5	25	60	4	4
*EHCRC44250510A	2.5	0.5R	2.5	10	50	4	4
*EHCRC44250516A	2.5	0.5R	2.5	16	50	4	4
*EHCRC44250520A	2.5	0.5R	2.5	20	50	4	4
*EHCRC44250525A	2.5	0.5R	2.5	25	60	4	4

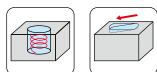
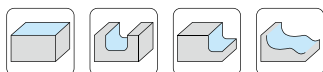
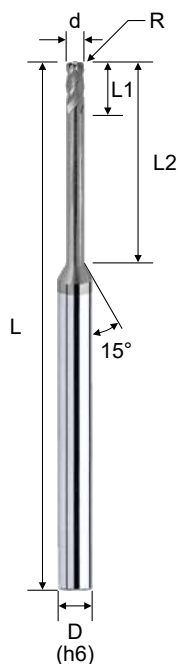
Cutting conditions : Table 024

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EHCRC



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EHCRC40300110A	3.0	0.1R	3.0	10	50	6	4
EHCRC40300116A	3.0	0.1R	3.0	16	60	6	4
EHCRC40300120A	3.0	0.1R	3.0	20	60	6	4
EHCRC40300125A	3.0	0.1R	3.0	25	60	6	4
EHCRC40300130A	3.0	0.1R	3.0	30	75	6	4
EHCRC40300135A	3.0	0.1R	3.0	35	75	6	4
EHCRC40300210A	3.0	0.2R	3.0	10	50	6	4
EHCRC40300216A	3.0	0.2R	3.0	16	60	6	4
EHCRC40300220A	3.0	0.2R	3.0	20	60	6	4
EHCRC40300225A	3.0	0.2R	3.0	25	60	6	4
EHCRC40300230A	3.0	0.2R	3.0	30	75	6	4
EHCRC40300235A	3.0	0.2R	3.0	35	75	6	4
EHCRC40300310A	3.0	0.3R	3.0	10	50	6	4
EHCRC40300316A	3.0	0.3R	3.0	16	60	6	4
EHCRC40300320A	3.0	0.3R	3.0	20	60	6	4
EHCRC40300325A	3.0	0.3R	3.0	25	60	6	4
EHCRC40300330A	3.0	0.3R	3.0	30	75	6	4
EHCRC40300335A	3.0	0.3R	3.0	35	75	6	4
EHCRC40300510A	3.0	0.5R	3.0	10	50	6	4
EHCRC40300516A	3.0	0.5R	3.0	16	60	6	4
EHCRC40300520A	3.0	0.5R	3.0	20	60	6	4
EHCRC40300525A	3.0	0.5R	3.0	25	60	6	4
EHCRC40300530A	3.0	0.5R	3.0	30	75	6	4
EHCRC40300535A	3.0	0.5R	3.0	35	75	6	4
EHCRC40301010A	3.0	1.0R	3.0	10	50	6	4
EHCRC40301016A	3.0	1.0R	3.0	16	60	6	4
EHCRC40301020A	3.0	1.0R	3.0	20	60	6	4
EHCRC40301025A	3.0	1.0R	3.0	25	60	6	4
EHCRC40301030A	3.0	1.0R	3.0	30	75	6	4
EHCRC40301035A	3.0	1.0R	3.0	35	75	6	4

Cutting conditions : Table 024

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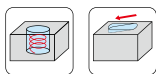
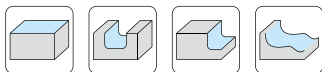
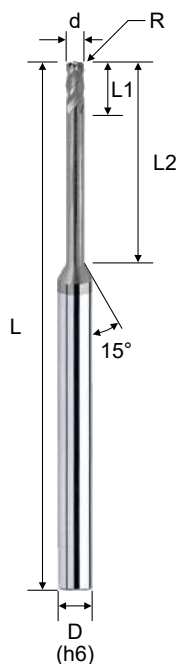
d Tolerance	
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R < 2	±0.015
R ≥ 2	±0.020

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EHCRC



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EHCRC40400113A	4.0	0.1R	4.0	13	50	6	4
EHCRC40400116A	4.0	0.1R	4.0	16	60	6	4
EHCRC40400120A	4.0	0.1R	4.0	20	60	6	4
EHCRC40400125A	4.0	0.1R	4.0	25	60	6	4
EHCRC40400130A	4.0	0.1R	4.0	30	75	6	4
EHCRC40400135A	4.0	0.1R	4.0	35	75	6	4
EHCRC40400213A	4.0	0.2R	4.0	13	50	6	4
EHCRC40400216A	4.0	0.2R	4.0	16	60	6	4
EHCRC40400220A	4.0	0.2R	4.0	20	60	6	4
EHCRC40400225A	4.0	0.2R	4.0	25	60	6	4
EHCRC40400230A	4.0	0.2R	4.0	30	75	6	4
EHCRC40400235A	4.0	0.2R	4.0	35	75	6	4
EHCRC40400313A	4.0	0.3R	4.0	13	50	6	4
EHCRC40400316A	4.0	0.3R	4.0	16	60	6	4
EHCRC40400320A	4.0	0.3R	4.0	20	60	6	4
EHCRC40400325A	4.0	0.3R	4.0	25	60	6	4
EHCRC40400330A	4.0	0.3R	4.0	30	75	6	4
EHCRC40400335A	4.0	0.3R	4.0	35	75	6	4
EHCRC40400513A	4.0	0.5R	4.0	13	50	6	4
EHCRC40400516A	4.0	0.5R	4.0	16	60	6	4
EHCRC40400520A	4.0	0.5R	4.0	20	60	6	4
EHCRC40400525A	4.0	0.5R	4.0	25	60	6	4
EHCRC40400530A	4.0	0.5R	4.0	30	75	6	4
EHCRC40400535A	4.0	0.5R	4.0	35	75	6	4
EHCRC40401013A	4.0	1.0R	4.0	13	50	6	4
EHCRC40401016A	4.0	1.0R	4.0	16	60	6	4
EHCRC40401020A	4.0	1.0R	4.0	20	60	6	4
EHCRC40401025A	4.0	1.0R	4.0	25	60	6	4
EHCRC40401030A	4.0	1.0R	4.0	30	75	6	4
EHCRC40401035A	4.0	1.0R	4.0	35	75	6	4

Cutting conditions : Table 024

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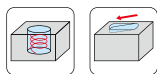
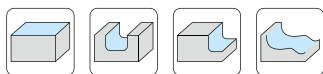
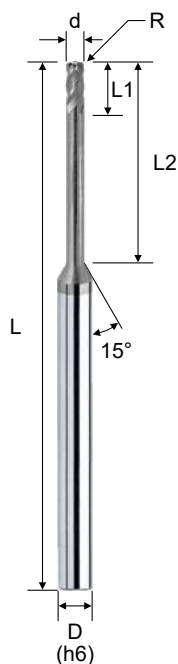
d Tolerance	
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R Tolerance	
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EHCRC



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d > 12	0 ~ -0.03

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EHCRC40500116A	5.0	0.1R	5.0	16	60	6	4
EHCRC40500130A	5.0	0.1R	5.0	30	75	6	4
EHCRC40500216A	5.0	0.2R	5.0	16	60	6	4
EHCRC40500230A	5.0	0.2R	5.0	30	75	6	4
EHCRC40500316A	5.0	0.3R	5.0	16	60	6	4
EHCRC40500330A	5.0	0.3R	5.0	30	75	6	4
EHCRC40500516A	5.0	0.5R	5.0	16	60	6	4
EHCRC40500530A	5.0	0.5R	5.0	30	75	6	4
EHCRC40501016A	5.0	1.0R	5.0	16	60	6	4
EHCRC40501030A	5.0	1.0R	5.0	30	75	6	4
EHCRC40600120A	6.0	0.1R	7.0	20	60	6	4
EHCRC40600130A	6.0	0.1R	7.0	30	75	6	4
EHCRC40600220A	6.0	0.2R	7.0	20	60	6	4
EHCRC40600230A	6.0	0.2R	7.0	30	75	6	4
EHCRC40600320A	6.0	0.3R	7.0	20	60	6	4
EHCRC40600330A	6.0	0.3R	7.0	30	75	6	4
EHCRC40600520A	6.0	0.5R	7.0	20	60	6	4
EHCRC40600530A	6.0	0.5R	7.0	30	75	6	4
EHCRC40601020A	6.0	1.0R	7.0	20	60	6	4
EHCRC40601030A	6.0	1.0R	7.0	30	75	6	4
EHCRC40601520A	6.0	1.5R	7.0	20	60	6	4
EHCRC40601530A	6.0	1.5R	7.0	30	75	6	4
EHCRC40800522A	8.0	0.5R	9.0	22	60	8	4
EHCRC40801022A	8.0	1.0R	9.0	22	60	8	4
EHCRC40801522A	8.0	1.5R	9.0	22	60	8	4
EHCRC40802022A	8.0	2.0R	9.0	22	60	8	4
EHCRC41000524A	10.0	0.5R	11.0	24	75	10	4
EHCRC41001024A	10.0	1.0R	11.0	24	75	10	4
EHCRC41001524A	10.0	1.5R	11.0	24	75	10	4
EHCRC41002024A	10.0	2.0R	11.0	24	75	10	4
EHCRC41200526A	12.0	0.5R	13.0	26	75	12	4
EHCRC41201026A	12.0	1.0R	13.0	26	75	12	4
EHCRC41201526A	12.0	1.5R	13.0	26	75	12	4
EHCRC41202026A	12.0	2.0R	13.0	26	75	12	4

Cutting conditions : Table 024

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Recommended Cutting Conditions

Table 024

H650 Seires EHCBC4, EHCRC4

Material		PREHARDENED STEELS NAK80 CENA1				Hardened Steel SKD11,SKH51			
Hardness		HRC 35~45				HRC 55~65			
Dia	EFF-L	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)
2.0mm	6	12650	1265	0.063	0.633	11730	1173	0.059	0.713
	12	8970	1012	0.045	0.396	8280	943	0.043	0.396
2.5mm	10	10580	1380	0.065	0.528	9775	1150	0.065	0.528
	20	7590	1150	0.047	0.640	7360	655	0.030	0.220
3.0mm	10	11040	2070	0.094	0.684	10235	2070	0.059	0.684
	20	8165	1495	0.057	0.567	7705	1495	0.035	0.567
4.0mm	13	9085	1576	0.105	1.150	7590	1530	0.082	1.150
	20	7130	1380	0.069	0.920	5980	1288	0.054	0.920
	30	6325	1104	0.043	0.745	5290	1058	0.033	0.745
6.0mm	20	5635	1691	0.176	2.305	3335	978	0.176	1.281
	30	2875	782	0.098	1.320	1610	460	0.098	0.733
8.0mm	22	4600	1840	0.212	2.921	2760	782	0.212	1.518
10.0mm	24	3680	2013	0.242	3.140	2185	621	0.253	1.645
12.0mm	26	2875	2070	0.265	3.105	1725	495	0.276	1.714

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.

