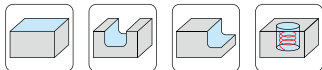
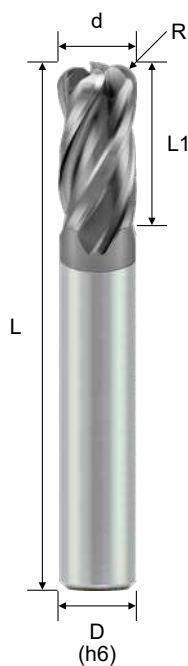


H650 - Corner Radius · 4F

- ARCO coating provides a superior wear resistance.
- Suitable for HRC 50 and over HRC 50 Hardened Steel, also maximum up to HRC 65.
- Long tool life and wear resistant due to its negative angle with corner radius design.
- The coating can change to SICO.

EHCSH



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)	OAL (L)	Shank (D)	Flutes (F)
* EHCSH441002A	1	0.2R	2	50	4	4
* EHCSH441003A	1	0.3R	2	50	4	4
* EHCSH441502A	1.5	0.2R	3	50	4	4
* EHCSH441503A	1.5	0.3R	3	50	4	4
* EHCSH442002A	2	0.2R	4	50	4	4
* EHCSH442003A	2	0.3R	4	50	4	4
* EHCSH442005A	2	0.5R	4	50	4	4
* EHCSH433002A	3	0.2R	6	50	3	4
* EHCSH443002A	3	0.2R	6	50	4	4
* EHCSH433003A	3	0.3R	6	50	3	4
* EHCSH443003A	3	0.3R	6	50	4	4
* EHCSH433005A	3	0.5R	6	50	3	4
* EHCSH443005A	3	0.5R	6	50	4	4
* EHCSH433010A	3	1.0R	6	50	3	4
* EHCSH443010A	3	1.0R	6	50	4	4
* EHCSH444002A	4	0.2R	8	50	4	4
* EHCSH444003A	4	0.3R	8	50	4	4
* EHCSH444005A	4	0.5R	8	50	4	4
* EHCSH444010A	4	1.0R	8	50	4	4
EHCSH404003A	4	0.3R	8	50	6	4
EHCSH404005A	4	0.5R	8	50	6	4
EHCSH404010A	4	1.0R	8	50	6	4
EHCSH405005A	5	0.5R	10	50	6	4
EHCSH405010A	5	1.0R	10	50	6	4
EHCSH406003A	6	0.3R	12	50	6	4
EHCSH406005A	6	0.5R	12	50	6	4
EHCSH406010A	6	1.0R	12	50	6	4
EHCSH408005A	8	0.5R	16	60	8	4
EHCSH408010A	8	1.0R	16	60	8	4
EHCSH408015A	8	1.5R	16	60	8	4
EHCSH410005A	10	0.5R	20	75	10	4
EHCSH410010A	10	1.0R	20	75	10	4
EHCSH410015A	10	1.5R	20	75	10	4
EHCSH410020A	10	2.0R	20	75	10	4
EHCSH412005A	12	0.5R	24	75	12	4
EHCSH412010A	12	1.0R	24	75	12	4
EHCSH412015A	12	1.5R	24	75	12	4
EHCSH412020A	12	2.0R	24	75	12	4

Cutting conditions : Table 014

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

Recommended Cutting Conditions

Table 014

H650 Seires EHCSH4

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)			
Dia	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)
3mm	15390	1415	3	0.15	13270	1220	3	0.15	11150	1025	3	0.15
4mm	11550	1386	4	0.2	9950	1194	4	0.2	8360	1003	4	0.2
6mm	7700	1232	6	0.3	6630	1060	6	0.3	5570	891	6	0.3
8mm	5770	923	8	0.4	4980	796	8	0.4	4180	668	8	0.4
10mm	4620	924	10	0.5	3980	796	10	0.5	3345	669	10	0.5
12mm	3850	770	12	0.6	3320	664	12	0.6	2790	558	12	0.6

Table 015

H650 Seires EHCLH4

Material	PREHARDENED STEELS NAK80 CENA1				HARDENED STEELS SKD61,SKD11				Hardened Steel SKD11,SKH51			
Hardness	HRC 35~45				HRC 40~55				HRC 55~65			
Vc	123 (m/min)				106 (m/min)				89 (m/min)			
Dia	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)
3mm	13080	1200	3	0.15	11280	1038	3	0.15	9480	871	3	0.15
4mm	9820	1178	4	0.2	8460	1015	4	0.2	7100	852	4	0.2
6mm	6545	1050	6	0.3	5635	900	6	0.3	4740	757	6	0.3
8mm	4905	785	8	0.4	4235	676	8	0.4	3555	568	8	0.4
10mm	3927	785	10	0.5	3385	676	10	0.5	2845	568	10	0.5
12mm	3270	655	12	0.6	2820	564	12	0.6	2370	474	12	0.6

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.

