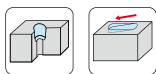
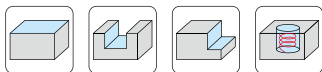
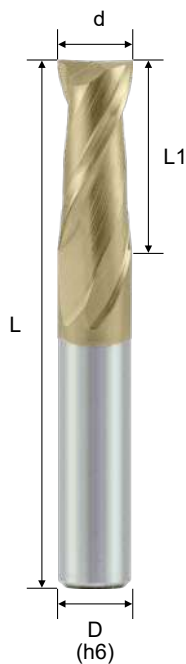


- SICO coating with anti-high temperature & anti-oxidation.
- Suitable for HRC 30 to HRC 60 Alloy Steel, Cast Iron, Prehardened steel, Hardened Steel, etc.
- Strong geometry design has excellent cutting ability of cutting edges.
- Universal geometry design is suitable for most materials.

P	M	K	N	S	H
●	○	●		○	●



d Tolerance	
$d \leq 6$	$0 \sim -0.02$
$6 < d \leq 12$	$0 \sim -0.03$
$d > 12$	$0 \sim -0.04$

Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EHSSC241000S	1	3	50	4	2
* EHSSC242000S	2	5	50	4	2
* EHSSC243000S	3	8	50	4	2
* EHSSC203000S	3	8	50	6	2
* EHSSC244000S	4	10	50	4	2
EHSSC204000S	4	10	50	6	2
EHSSC205000S	5	13	50	6	2
EHSSC206000S	6	15	50	6	2
EHSSC208000S	8	20	60	8	2
EHSSC210000S	10	25	75	10	2
EHSSC212000S	12	30	75	12	2
EHSSC216000S	16	35	100	16	2
EHSSC220000S	20	45	100	20	2

Cutting conditions : Table 025

Recommended Cutting Conditions

Table 025

H600 Seires EHSSC2 (H600 Series, vc, rpm and feed increase 20%)**G550 Seires EPSSC2****G450 Seires EPSSA2**

Material	CARBON STEEL / ALLOY STEEL				ALLOY STEEL / TOOL STEEL SCM, SKT, SKD				PREHARDENED STEEL NAK80 CENA1			
Hardness	HB180~250				HRC25~35				HRC35~45			
Vc	120(m/min)				95(m/min)				79(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	12700	380	1.5	3	10000	300	0.9	3	8386	251	0.15	3
4mm	9550	382	2	4	7560	302	1.2	4	6290	251	0.2	4
6mm	6370	445	3	6	5040	352	1.8	6	4200	294	0.3	6
8mm	4770	333	4	8	3780	264	2.4	8	3140	220	0.4	8
10mm	3820	230	5	10	3020	181	3	10	2515	150	0.5	10
12mm	3180	190	6	12	2520	151	3.6	12	2100	126	0.6	12

Material	HARDENED STEEL SKD61, SKD11				STAINLESS STEEL SUS304 316				CAST IRON FC / FCD			
Hardness	HRC 40~55)											
Vc	48(m/min)				79(m/min)				120(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	5095	152	0.15	3	8386	251	0.15	3	12700	380	1.5	3
4mm	3820	152	0.2	4	6290	251	0.2	4	9550	382	2	4
6mm	2548	178	0.3	6	4200	294	0.3	6	6370	445	3	6
8mm	1910	133	0.4	8	3140	220	0.4	8	4770	333	4	8
10mm	1528	92	0.5	10	2515	150	0.5	10	3820	230	5	10
12mm	1274	76	0.6	12	2100	126	0.6	12	3180	190	6	12

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.

