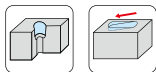
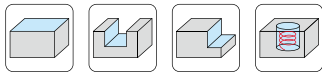
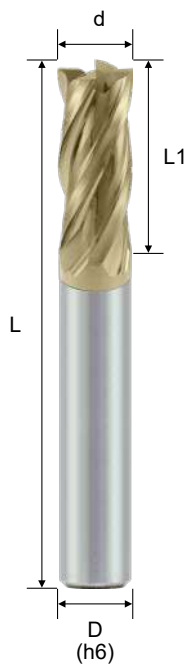


H600 - Square · 4F

- 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.

EHSSC



d Tolerance	
d ≤ 6	0 ~ -0.02
6 < d ≤ 12	0 ~ -0.03
d > 12	0 ~ -0.04

Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EHSSC441000S	1.0	3	50	4	4
* EHSSC441500S	1.5	4	50	4	4
* EHSSC442000S	2.0	5	50	4	4
* EHSSC442500S	2.5	6	50	4	4
* EHSSC433000S	3.0	8	50	3	4
* EHSSC443000S	3.0	8	50	4	4
* EHSSC444000S	4.0	10	50	4	4
EHSSC405000S	5.0	13	50	6	4
EHSSC406000S	6.0	15	50	6	4
EHSSC408000S	8.0	20	60	8	4
EHSSC410000S	10.0	25	75	10	4
EHSSC412000S	12.0	30	75	12	4
EHSSC414000S	14.0	30	75	14	4
EHSSC416000S	16.0	40	100	16	4
EHSSC420000S	20.0	45	100	20	4
EHSSC425000S	25.0	45	100	25	4

Cutting conditions : Table 026

Recommended Cutting Conditions

Table 026

H600 Seires EHSSC4, ESHC4 (H600 Series, vc, rpm and feed increase 20%)**G550 Seires EPSSC3, EPSSC4, EPSSA4****G450 Seires EPSSA4**

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	762	3	0.15	10000	600	3	0.15	8386	503	3	0.15
4mm	9550	764	4	0.2	7560	604	4	0.2	6290	503	4	0.2
6mm	6370	890	6	0.3	5040	705	6	0.3	4200	588	6	0.3
8mm	4770	668	8	0.4	3780	529	8	0.4	3140	440	8	0.4
10mm	3820	458	10	0.5	3020	362	10	0.5	2515	301	10	0.5
12mm	3180	380	12	0.6	2520	302	12	0.6	2100	252	12	0.6

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	305	3	0.15	8386	503	3	0.15	12700	503	3	0.15
4mm	3820	305	4	0.2	6290	503	4	0.2	9550	503	4	0.2
6mm	2548	356	6	0.3	4200	588	6	0.3	6370	588	6	0.3
8mm	1910	267	8	0.4	3140	440	8	0.4	4770	440	8	0.4
10mm	1528	183	10	0.5	2515	301	10	0.5	3820	301	10	0.5
12mm	1274	152	12	0.6	2100	252	12	0.6	3180	252	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.

