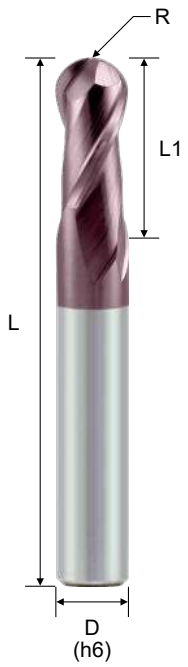
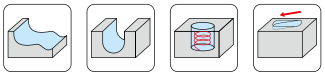
G550 - Ball Nose · 2F

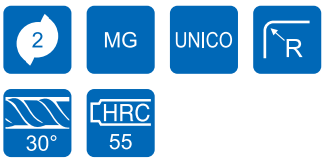
- UNICO Coating provides superior wear resistance and reduces the coefficient of friction.
- Suitable for HRC 30 to HRC 55 Ordinary Steel, Alloy Steel, Cast Iron, Heat-Resistant Steel, etc.
- It provides an excellent surface due to better surface grindings.
- New tool geometry increases wear resistance and cutting force is decreased.
- Suitable for high speed profile surface milling.

EPBSC

P	M	K	N	S	H
●	●	●			○







R Tolerance	
R ≤ 3	±0.015
R > 3	±0.020

Order No.	Radius (R)	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPBSC240200U	0.10R	0.2	0.4	50	4	2
* EPBSC240300U	0.15R	0.3	0.6	50	4	2
* EPBSC240400U	0.20R	0.4	0.8	50	4	2
* EPBSC240500U	0.25R	0.5	1.0	50	4	2
* EPBSC240600U	0.30R	0.6	1.2	50	4	2
* EPBSC240700U	0.35R	0.7	1.4	50	4	2
* EPBSC240800U	0.40R	0.8	1.6	50	4	2
* EPBSC240900U	0.45R	0.9	1.8	50	4	2
* EPBSC241000U	0.50R	1.0	2.0	50	4	2
* EPBSC241500U	0.75R	1.5	3.0	50	4	2
* EPBSC242000U	1.00R	2.0	4.0	50	4	2
EPBSC233000U	1.50R	3.0	6.0	50	3	2
* EPBSC243000U	1.50R	3.0	6.0	50	4	2
* EPBSC244000U	2.00R	4.0	8.0	50	4	2
EPBSC203000U	1.50R	3.0	6.0	50	6	2
EPBSC204000U	2.00R	4.0	8.0	50	6	2
EPBSC205000U	2.50R	5.0	10.0	50	6	2
EPBSC206000U	3.00R	6.0	12.0	50	6	2
EPBSC207000U	3.50R	7.0	14.0	60	8	2
EPBSC208000U	4.00R	8.0	16.0	60	8	2
EPBSC210000U	5.00R	10.0	20.0	75	10	2
EPBSC212000U	6.00R	12.0	24.0	75	12	2
EPBSC216000U	8.00R	16.0	32.0	100	16	2
EPBSC220000U	10.00R	20.0	40.0	100	20	2

Cutting conditions：Table 035

Table 035

H600 Seires EHBSC2 *(H600 Series, vc, rpm and feed increase 20%)*

G550 Seires EPBSC2

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)			
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	37470	936	0.14	0.2	29660	740	0.14	0.2	24660	616	0.14	0.2
2R	18730	1120	0.28	0.4	14830	890	0.28	0.4	12330	740	0.28	0.4
3R	12490	936	0.42	0.6	9890	740	0.42	0.6	8220	616	0.42	0.6
4R	9366	750	0.56	0.8	7415	593	0.56	0.8	6170	494	0.56	0.8
5R	7490	636	0.7	1	5930	504	0.7	1	4930	420	0.7	1
6R	6244	560	0.84	1.2	4940	444	0.84	1.2	4110	370	0.84	1.2

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)			
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	14990	374	0.14	0.2	24660	616	0.14	0.2	37470	936	0.14	0.2
2R	7490	450	0.28	0.4	12330	740	0.28	0.4	18730	1120	0.28	0.4
3R	4995	374	0.42	0.6	8220	616	0.42	0.6	12490	936	0.42	0.6
4R	3750	300	0.56	0.8	6170	494	0.56	0.8	9366	750	0.56	0.8
5R	3000	255	0.7	1	4930	420	0.7	1	7490	636	0.7	1
6R	2500	225	0.84	1.2	4110	370	0.84	1.2	6244	560	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.