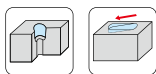
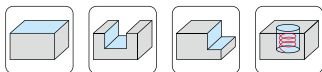
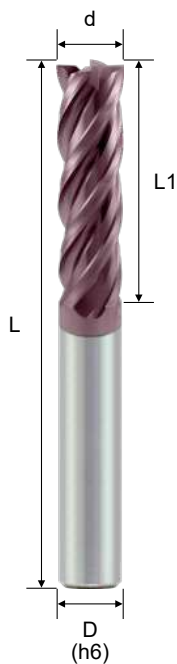


- UNICO Coating provides superior wear resistance and reduces the coefficient of friction.
- Suitable for HRC 30 to HRC 55 Ordinary Steel, Alloy Steel, Cast Iron, Heat-Resistant Steel, etc.
- Available in various length of cut and overall length end mills.
- Long cutting length is suitable for deep side milling.

P	M	K	N	S	H
●	●	●			○



d Tolerance	
$d \leq 6$	$0 \sim -0.03$
$6 < d \leq 12$	$0 \sim -0.04$
$d > 12$	$0 \sim -0.05$

Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
EPSCC403000U	3	15	60	6	4
EPSCC404000U	4	20	60	6	4
EPSCC405000U	5	25	75	6	4
EPSCC406000U	6	30	75	6	4
EPSCC408000U	8	35	100	8	4
EPSCC410000U	10	45	100	10	4
EPSCC412000U	12	45	100	12	4
EPSCC414000U	14	70	150	14	4
EPSCC416000U	16	70	150	16	4
EPSCC420000U	20	75	150	20	4
EPSCC425000U	25	75	150	25	4

Cutting conditions : Table 028

Recommended Cutting Conditions

Table 028

H600 Seires EHSCC4, EHSCH4 (H600 Series, vc, rpm and feed increase 20%)**G550 Seires EPSCC4**

Material	CARBON STEEL / ALLOY STEEL				ALLOY STEEL / TOOL STEEL SCM, SKT, SKD				PREHARDENED STEEL NAK80 CENA1			
Hardness	HB180~250				HRC25~35				HRC35~45			
Vc	96 (m/min)				76 (m/min)				63 (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	10160	610	3	0.15	8000	480	3	0.15	6708	402	3	0.15
4mm	7640	610	4	0.2	6048	483	4	0.2	5032	402	4	0.2
6mm	5096	712	6	0.3	4032	564	6	0.3	3360	470	6	0.3
8mm	3816	534	8	0.4	3024	423	8	0.4	2512	352	8	0.4
10mm	3056	366	10	0.5	2416	290	10	0.5	2012	240	10	0.5
12mm	2544	304	12	0.6	2016	242	12	0.6	1680	202	12	0.6

Material	HARDENED STEEL SKD61, SKD11				STAINLESS STEEL SUS304 316				CAST IRON FC / FCD			
Hardness	HRC 40~55)											
Vc	38 (m/min)				63 (m/min)				96 (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	4076	244	3	0.15	6708	402	3	0.15	10160	610	3	0.15
4mm	3056	244	4	0.2	5032	402	4	0.2	7640	610	4	0.2
6mm	2038	285	6	0.3	3360	470	6	0.3	5096	712	6	0.3
8mm	1528	214	8	0.4	2512	352	8	0.4	3816	534	8	0.4
10mm	1222	146	10	0.5	2012	240	10	0.5	3056	366	10	0.5
12mm	1016	122	12	0.6	1680	202	12	0.6	2544	304	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.

