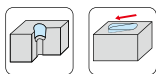
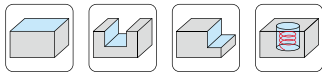
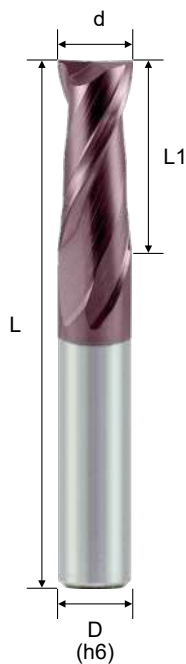


## G550 - Square · 2F

- 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.
- Strong geometry design has excellent cutting ability of cutting edges.
- High precision cutting for side milling.

## EPSSC



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

| Order No.      | Dia.<br>(d) | CL<br>(L1) | OAL<br>(L) | Shank<br>(D) | Flutes<br>(F) |
|----------------|-------------|------------|------------|--------------|---------------|
| * EPSSC240200U | 0.2         | 0.4        | 50         | 4            | 2             |
| * EPSSC240300U | 0.3         | 0.6        | 50         | 4            | 2             |
| * EPSSC240400U | 0.4         | 0.8        | 50         | 4            | 2             |
| * EPSSC240500U | 0.5         | 1.0        | 50         | 4            | 2             |
| * EPSSC240600U | 0.6         | 1.5        | 50         | 4            | 2             |
| * EPSSC240700U | 0.7         | 2.0        | 50         | 4            | 2             |
| * EPSSC240800U | 0.8         | 2.0        | 50         | 4            | 2             |
| * EPSSC240900U | 0.9         | 2.0        | 50         | 4            | 2             |
| * EPSSC241000U | 1.0         | 3.0        | 50         | 4            | 2             |
| EPSSC201000U   | 1.0         | 3.0        | 50         | 6            | 2             |
| * EPSSC241500U | 1.5         | 4.0        | 50         | 4            | 2             |
| * EPSSC242000U | 2.0         | 5.0        | 50         | 4            | 2             |
| EPSSC202000U   | 2.0         | 5.0        | 50         | 6            | 2             |
| * EPSSC242500U | 2.5         | 6.0        | 50         | 4            | 2             |
| EPSSC233000U   | 3.0         | 8.0        | 50         | 3            | 2             |
| * EPSSC243000U | 3.0         | 8.0        | 50         | 4            | 2             |
| EPSSC203000U   | 3.0         | 8.0        | 50         | 6            | 2             |
| * EPSSC243500U | 3.5         | 9.0        | 50         | 4            | 2             |
| EPSSC203500U   | 3.5         | 9.0        | 50         | 6            | 2             |
| * EPSSC244000U | 4.0         | 10.0       | 50         | 4            | 2             |
| EPSSC204000U   | 4.0         | 10.0       | 50         | 6            | 2             |
| EPSSC204500U   | 4.5         | 11.0       | 50         | 6            | 2             |
| EPSSC205000U   | 5.0         | 13.0       | 50         | 6            | 2             |
| EPSSC205500U   | 5.5         | 14.0       | 50         | 6            | 2             |
| EPSSC206000U   | 6.0         | 15.0       | 50         | 6            | 2             |
| EPSSC206500U   | 6.5         | 16.0       | 60         | 8            | 2             |
| EPSSC207000U   | 7.0         | 18.0       | 60         | 8            | 2             |
| EPSSC208000U   | 8.0         | 20.0       | 60         | 8            | 2             |
| EPSSC209000U   | 9.0         | 22.0       | 75         | 10           | 2             |
| EPSSC210000U   | 10.0        | 25.0       | 75         | 10           | 2             |
| EPSSC211000U   | 11.0        | 25.0       | 75         | 12           | 2             |
| EPSSC212000U   | 12.0        | 30.0       | 75         | 12           | 2             |
| EPSSC214000U   | 14.0        | 30.0       | 75         | 14           | 2             |
| EPSSC216000U   | 16.0        | 40.0       | 100        | 16           | 2             |
| EPSSC218000U   | 18.0        | 40.0       | 100        | 20           | 2             |
| EPSSC220000U   | 20.0        | 45.0       | 100        | 20           | 2             |
| EPSSC225000U   | 25.0        | 45.0       | 100        | 25           | 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<br>SCM, SKT, SKD |                  |            |            | PREHARDENED STEEL<br>NAK80 CENA1 |                  |            |            |
|----------|----------------------------|------------------|------------|------------|-------------------------------------------|------------------|------------|------------|----------------------------------|------------------|------------|------------|
| Hardness | HB180~250                  |                  |            |            | HRC25~35                                  |                  |            |            | HRC35~45                         |                  |            |            |
| Vc       | 120(m/min)                 |                  |            |            | 95(m/min)                                 |                  |            |            | 79(m/min)                        |                  |            |            |
| Dia      | RPM                        | Feed<br>(mm/min) | ap<br>(mm) | ae<br>(mm) | RPM                                       | Feed<br>(mm/min) | ap<br>(mm) | ae<br>(mm) | RPM                              | Feed<br>(mm/min) | ap<br>(mm) | ae<br>(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<br>SKD61, SKD11 |                  |            |            | STAINLESS STEEL<br>SUS304 316 |                  |            |            | CAST IRON<br>FC / FCD |                  |            |            |
|----------|--------------------------------|------------------|------------|------------|-------------------------------|------------------|------------|------------|-----------------------|------------------|------------|------------|
| Hardness | HRC 40~55)                     |                  |            |            |                               |                  |            |            |                       |                  |            |            |
| Vc       | 48(m/min)                      |                  |            |            | 79(m/min)                     |                  |            |            | 120(m/min)            |                  |            |            |
| Dia      | RPM                            | Feed<br>(mm/min) | ap<br>(mm) | ae<br>(mm) | RPM                           | Feed<br>(mm/min) | ap<br>(mm) | ae<br>(mm) | RPM                   | Feed<br>(mm/min) | ap<br>(mm) | ae<br>(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.

