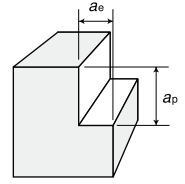


END MILL

ดอกเอ็นมิลล์

END MILL
เอ็นมิลล์



Side Milling

DEEP SERIES เอ็นมิลล์ตระกูลดีพ	Work material (Hardness)	Condition Range	Depth of cut (mm)	Cutting Conditions	Dc Tool Dia. (mm)								
					Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
CBN END MILL CBN เอ็นมิลล์	Alloy Steels (200 ~ 250HB) SKD61, SKD11	High Speed	ap=1.5Dc	min ⁻¹	16,000	12,000	9,600	8,000	6,000	4,800	4,000	3,000	2,400
		General	ae=0.1Dc	mm / min	1,800	1,900	2,100	2,200	2,400	2,200	2,100	1,700	1,400
Carbide Endmill เอ็นมิลล์คาร์ไบด์	Alloy Steels (25 ~ 35HRC) SCM440		High Speed	ap=1.5Dc	min ⁻¹	9,600	7,200	5,700	4,800	3,600	2,900	2,400	1,800
		General	ae=0.15Dc	mm / min	860	920	1,000	1,080	1,150	1,070	1,000	810	670
HSS Endmill เอ็นมิลล์ไฮสปีด	Alloy Steels (25 ~ 35HRC) SCM440		High Speed	ap=1.5Dc	min ⁻¹	14,000	10,000	8,300	6,900	5,200	4,100	3,500	2,600
		General	ae=0.05Dc	mm / min	1,400	1,400	1,600	1,700	1,900	1,700	1,600	1,300	1,100
Ball หัวบอล	Pre-Harden Steels (35 ~ 45HRC) NAK80		High Speed	ap=1.5Dc	min ⁻¹	9,600	7,200	5,700	4,800	3,600	2,900	2,400	1,800
		General	ae=0.15Dc	mm / min	770	830	900	970	1,040	960	900	730	600
Radius หัวก้นมุม R	Pre-Harden Steels (35 ~ 45HRC) NAK80		High Speed	ap=1.5Dc	min ⁻¹	12,000	8,800	7,000	5,800	4,400	3,500	2,900	2,200
		General	ae=0.15Dc	mm / min	1,100	1,100	1,200	1,300	1,400	1,300	1,200	1,000	860
Square หัวตัด	Hardened Steels (45 ~ 55HRC) SKD61, SKT4		High Speed	ap=1.5Dc	min ⁻¹	8,500	6,400	5,100	4,200	3,200	2,500	2,100	1,600
		General	ae=0.07Dc	mm / min	610	660	720	750	820	740	700	570	500
Taper Ball หัวเตเปอร์บอล	Hardened Steels (45 ~ 55HRC) SKD61, SKT4		High Speed	ap=1.5Dc	min ⁻¹	11,000	8,000	6,400	5,300	4,000	3,200	2,700	2,000
		General	ae=0.02Dc	mm / min	860	900	990	1,040	1,120	1,030	980	780	670
Roughing	Hardened Steels (45 ~ 55HRC) SKD61, SKT4		High Speed	ap=1.5Dc	min ⁻¹	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,400
		General	ae=0.05Dc	mm / min	460	500	550	580	630	570	550	440	370

- [Note]**
- ① Use a highly rigid and accurate machine as possible.
 - ② Use the appropriate coolant for the work material and machining shape.
 - ③ These conditions are for general guidance; in actual machining conditions adjust the parameters according to your actual machine and work-piece conditions.
 - ④ If the rpm available is lower than that recommended please reduce the feed rate to the same ratio.

ดอกเอ็นมิลล์

EPOCH TH POWER MILL EPPS4 ○-TH



Short

Planing

Side Cutting

Slotting

Roughing

Semi Finishing

Finishing

P (Steel)

PH (Highhard)

MS (Stainless)

S (Titanium alloy)

N (Non ferrous)

CARBIDE

TH COATED

55 HRC

Helix: 43°

h6

Dia. tolerance
 ↑ ↓

Ø3 ~ Ø6 : 0~-0.015
 Ø6.5~Ø20 : 0~-0.02

Ds ≤ 6 : 0~-0.008
 6 < Ds ≤ 10 : 0~-0.009
 10 < Ds ≤ 18 : 0~-0.011
 18 < Ds : 0~-0.013

(mm)

For machining of high-hardness materials. Excellent chip removal performance enables high efficiency.

Item Code	Stock	Size (mm)			
		Tool Dia.	Flute Length	Overall length	Shank Dia.
EPPS4030-TH	●	3	4.5	60	6
EPPS4035-TH	●	3.5	5.3	60	6
EPPS4040-TH	●	4	6	60	6
EPPS4045-TH	●	4.5	6.8	60	6
EPPS4050-TH	●	5	7.5	60	6
EPPS4055-TH	●	5.5	8.3	60	6
EPPS4060-TH	●	6	9	60	6
EPPS4065-TH	●	6.5	9.8	70	8
EPPS4070-TH	●	7	10.5	70	8
EPPS4075-TH	●	7.5	11.3	75	8
EPPS4080-TH	●	8	12	75	8
EPPS4085-TH	●	8.5	12.8	80	10
EPPS4090-TH	●	9	13.5	80	10
EPPS4095-TH	●	9.5	14.3	80	10
EPPS4100-TH	●	10	15	80	10
EPPS4120-TH	●	12	18	100	12
EPPS4160-TH	●	16	24	110	16
EPPS4200-TH	●	20	30	125	20

● : Stocked Items.