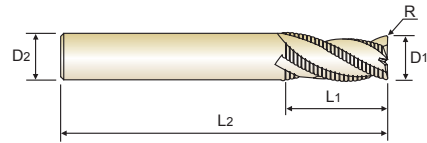
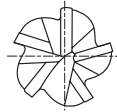


**CARBIDE, 5 FLUTE 40° HELIX CORNER RADIUS ROUGHING - FINE**

- ▶ Suitable for Titanium, Titanium Alloys, Inconel and Stainless Steels
- ▶ Optimized flute design for chip evacuation and rigidity when machining difficult-to-cut materials
- ▶ Special roughing profile for machining Titanium and Titanium Alloys
- ▶ Longer tool life with special coating



for Titanium

Unit : mm

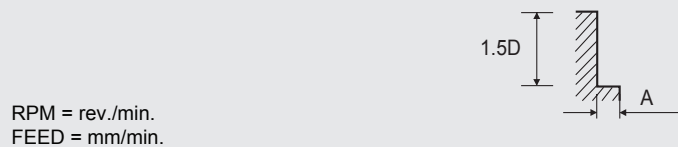
EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT	R	D1	D2	L1	L2
<b>EHE54060</b>	<b>EHE55060</b>	R0.2	<b>6.0</b>	6	16	57
<b>EHE54080</b>	<b>EHE55080</b>	R0.2	<b>8.0</b>	8	16	63
<b>EHE54100</b>	<b>EHE55100</b>	R0.3	<b>10.0</b>	10	22	72
<b>EHE54120</b>	<b>EHE55120</b>	R0.3	<b>12.0</b>	12	26	83
<b>EHE54140</b>	<b>EHE55140</b>	R0.3	<b>14.0</b>	14	26	83
<b>EHE54160</b>	<b>EHE55160</b>	R0.3	<b>16.0</b>	16	32	92
<b>EHE54200</b>	<b>EHE55200</b>	R0.3	<b>20.0</b>	20	38	104
<b>EHE54250</b>	<b>EHE55250</b>	R0.3	<b>25.0</b>	25	45	121

Tolerance(μm) / Size (mm)		from 1 to 3	over 3 to 6	over 6 to 10	over 10 to 18	over 18 to 30
Mill Dia.	<b>h10</b>	- 40	- 48	- 58	- 70	- 84
Shank Dia.	<b>h6</b>	- 6	- 8	- 9	- 11	- 13

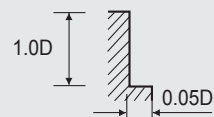
Stainless Steels	Titanium	Inconel
○	◎	○

**Cutting Conditions**

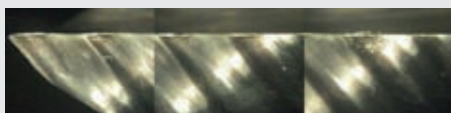
MATERIAL	STAINLESS STEELS				TITANIUM TITANIUM ALLOY				INCONEL			
	DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc
6.0	4250	530	80	0.025	3450	380	65	0.022	2100	210	40	0.020
8.0	3200	545	80	0.034	2600	405	65	0.031	1600	200	40	0.025
10.0	2550	520	80	0.041	2050	390	65	0.038	1250	230	40	0.037
12.0	2100	535	80	0.051	1700	390	65	0.046	1050	210	40	0.040
14.0	1800	515	80	0.057	1500	390	65	0.052	900	210	40	0.046
16.0	1600	505	80	0.063	1300	375	65	0.058	800	210	40	0.052
20.0	1250	505	80	0.081	1050	390	65	0.074	650	200	40	0.061
25.0	1000	455	80	0.091	850	355	65	0.084	500	170	40	0.068



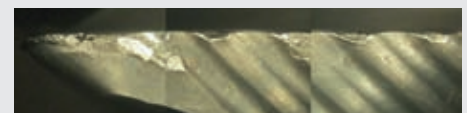
A : Ø6~Ø10 : 0.15D  
Ø12~Ø16 : 0.10D  
Ø20~Ø25 : 0.05D



YG-1 (43.890 μm)



A Company (315.711 μm)



<b>CUTTING CONDITION</b>	<b>Tools</b> : 5Flute, TN Mill	<b>Cutting Speed</b> : 158.336 m/min.	<b>Milling Length</b> : 30mm
	<b>Size</b> : Ø12×Ø12×26×73	<b>R.P.M</b> : 4,200 rev./min.	<b>Coolant</b> : Wet Cut
	<b>Work Material</b> : JIS : SUS420J(HRc35)	<b>Feed</b> : 714 mm/min.	<b>Overhang</b> : 34 mm
	<b>DIN</b> : X20Cr13	<b>Milling Method</b> : Down & Side Cutting	<b>Machine</b> : Machining Center
	<b>WR</b> : 1.4021	<b>Milling Depth</b> : Axial : 18 mm / Radial : 1.2 mm	