

*G550 Series for general milling (Hardened steel & Steel HRC 25~55)*



Milling

Solid Carbide Endmills

- Micro grain carbide rod is suitable for general machining.
- UNICO coating provides superior wear resistance and reduces the coefficient of friction.
- Stabilization of the cutting edge by edge flatland design and prevent chipping at corners.
- Universal geometry design is suitable for most materials.

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**G550 Series for general milling (Hardened steel & Steel HRC 25~55)**

	Square · 2F	EPSSC	Ø0.2-Ø25	2	30	UNICO	●	●	●									○	A075
	Square · 3F	EPSSC	Ø1-Ø25	3	30	UNICO	●	●	●									○	A076
	Square · 4F	EPSSC	Ø1-Ø25	4	30	UNICO	●	●	●									○	A077
	High Helix · Square · 4F	EPSSH	Ø1-Ø16	4	45	UNICO	●	●	●									○	A078
	Long Flute · Square · 4F	EPSCC	Ø3-Ø25	4	35	UNICO	●	●	●									○	A079
	High Helix · Square · 6F	EPSSH	Ø6-Ø12	6	45	UNICO	●	●	●									○	A080
	High Helix · Long Flute · Square · 6F	EPSCH	Ø6-Ø16	6	45	UNICO	●	●	●									○	A081
	Long Shank · Square · 2F	EPSLC	Ø4-Ø20	2	30	UNICO	●	●	●									○	A082
	Long Shank · Square · 4F	EPSLC	Ø3-Ø20	4	30	UNICO	●	●	●									○	A083
	Roughing · Square · 4F	EPSRR	Ø6-Ø20	4	30	UNICO	●	●	●									○	A084
	Stub Length · Square · 2F	EPSHC	Ø0.2-Ø6	2	30	UNICO	●	●	●									○	A085
	Stub Length · Square · 4F	EPSHC	Ø1-Ø6	4	30	UNICO	●	●	●									○	A086
	Taper · Square · 2F	EPSST	Ø0.15-10	2	35	UNICO	●	●	●									○	A087
	Ball Nose · 2F	EPBSC	0.1R-10R	2	30	UNICO	●	●	●									○	A090
	Ball Nose · 4F	EPBSC	1R-10R	4	30	UNICO	●	●	●									○	A091
	Long Shank · Ball Nose · 2F	EPBLC	1.5R-10R	2	30	UNICO	●	●	●									○	A092
	Long Shank · Ball Nose · 4F	EPBLC	2R-8R	4	30	UNICO	●	●	●									○	A093
	Stub Length · Ball Nose · 2F	EPBHC	0.1R-3R	2	30	UNICO	●	●	●									○	A094
	Taper · Ball Nose · 2F	EPBST	1R-3R	2	30	UNICO	●	●	●									○	A095
	Taper Neck · Ball Nose · 2F	EPBRT	0.5R-2R	2	30	UNICO	●	●	●									○	A096
	Corner Radius · 2F	EPCSC	Ø1-Ø12	2	30	UNICO	●	●	●									○	A097
	Corner Radius · 4F	EPCSC	Ø1-Ø16	4	30	UNICO	●	●	●									○	A098
	High Helix · Corner Radius · 4F	EPCSH	Ø3-Ø12	4	45	UNICO	●	●	●									○	A099
	Long Shank · Corner Radius · 4F	EPCLC	Ø4-Ø16	4	30	UNICO	●	●	●									○	A100
	Stub Length · Corner Radius · 2F	EPCHC	Ø1-Ø6	2	30	UNICO	●	●	●									○	A101
	Stub Length · Corner Radius · 4F	EPCHC	Ø2-Ø6	4	30	UNICO	●	●	●									○	A102
	Taper Neck · Corner Radius · 2F	EPCRT	Ø1-Ø6	2	30	UNICO	●	●	●									○	A103
	Inner Radius · 2F / 4F	EPISA	Ø2.9-Ø3.9	2	0	UNICO	●	●	●									○	A105

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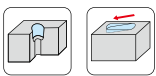
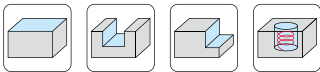
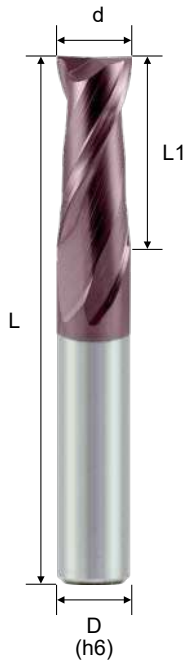
**G550 Series for general milling (Hardened steel & Steel HRC 25~55)**

	Chamfering Type Endmill · 4F / 5F / 6F	EPFSA	Ø4~Ø12	4	0	UNICO	●	●	●	○	●	●	A106
	Drill Mills · 2F	EPFSC	Ø3~Ø12	2	30	UNICO	●	●	●	○			A107
	Long Neck · Square · 2F	EPSRC	Ø0.2~Ø12	2	30	UNICO	●	●	●			○	A108
	Long Neck · Square · 4F	EPSRC	Ø1~Ø12	4	30	UNICO	●	●	●			○	A114
	Long Neck · Ball Nose · 2F	EPBRC	0.15R~6R	2	30	UNICO	●	●	●			○	A117
	Long Neck · Corner Radius · 2F	EPCRC	Ø1~Ø12	2	30	UNICO	●	●	●			○	A122
	Long Neck · Corner Radius · 4F	EPCRC	Ø2~Ø12	4	30	UNICO	●	●	●			○	A129

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

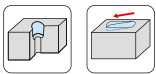
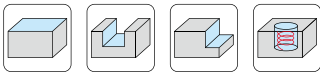
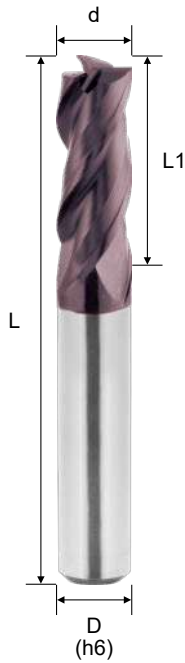
Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPSSC240200U	0.2	0.4	50	4	2
* EPSSC240300U	0.3	0.6	50	4	2
* EPSSC240400U	0.4	0.8	50	4	2
* EPSSC240500U	0.5	1.0	50	4	2
* EPSSC240600U	0.6	1.5	50	4	2
* EPSSC240700U	0.7	2.0	50	4	2
* EPSSC240800U	0.8	2.0	50	4	2
* EPSSC240900U	0.9	2.0	50	4	2
* EPSSC241000U	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

G550 - Square · 3F

- 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



Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPSSC331000U	1.0	3	50	3	3
* EPSSC331500U	1.5	4	50	3	3
* EPSSC332000U	2.0	5	50	3	3
* EPSSC333000U	3.0	8	50	3	3
* EPSSC341000U	1.0	3	50	4	3
* EPSSC341500U	1.5	4	50	4	3
* EPSSC342000U	2.0	5	50	4	3
* EPSSC342500U	2.5	6	50	4	3
* EPSSC343000U	3.0	8	50	4	3
* EPSSC343500U	3.5	9	50	4	3
* EPSSC344000U	4.0	10	50	4	3
EPSSC303000U	3.0	8	50	6	3
EPSSC303500U	3.5	9	50	6	3
EPSSC304000U	4.0	10	50	6	3
EPSSC304500U	4.5	11	50	6	3
EPSSC305000U	5.0	13	50	6	3
EPSSC305500U	5.5	14	50	6	3
EPSSC306000U	6.0	15	50	6	3
EPSSC306500U	6.5	16	60	8	3
EPSSC307000U	7.0	18	60	8	3
EPSSC308000U	8.0	20	60	8	3
EPSSC309000U	9.0	22	75	10	3
EPSSC310000U	10.0	25	75	10	3
EPSSC311000U	11.0	25	75	12	3
EPSSC312000U	12.0	30	75	12	3
EPSSC314000U	14.0	30	75	14	3
EPSSC316000U	16.0	40	100	16	3
EPSSC318000U	18.0	40	100	20	3
EPSSC320000U	20.0	45	100	20	3
EPSSC325000U	25.0	45	100	25	3

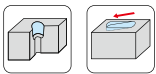
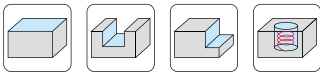
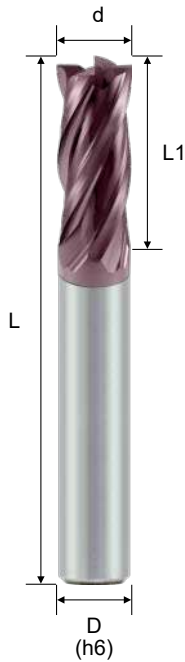
Cutting conditions : Table 026

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

G550 - Square · 4F

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

EPSSC



Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPSSC431000U	1.0	3	50	3	4
* EPSSC431500U	1.5	4	50	3	4
* EPSSC432000U	2.0	5	50	3	4
* EPSSC433000U	3.0	8	50	3	4
* EPSSC441000U	1.0	3	50	4	4
* EPSSC441500U	1.5	4	50	4	4
* EPSSC442000U	2.0	5	50	4	4
* EPSSC442500U	2.5	6	50	4	4
* EPSSC443000U	3.0	8	50	4	4
* EPSSC443500U	3.5	9	50	4	4
* EPSSC444000U	4.0	10	50	4	4
EPSSC403000U	3.0	8	50	6	4
EPSSC403500U	3.5	9	50	6	4
EPSSC404000U	4.0	10	50	6	4
EPSSC404500U	4.5	11	50	6	4
EPSSC405000U	5.0	13	50	6	4
EPSSC405500U	5.5	14	50	6	4
EPSSC406000U	6.0	15	50	6	4
EPSSC406500U	6.5	16	60	8	4
EPSSC407000U	7.0	18	60	8	4
EPSSC408000U	8.0	20	60	8	4
EPSSC409000U	9.0	22	75	10	4
EPSSC410000U	10.0	25	75	10	4
EPSSC411000U	11.0	25	75	12	4
EPSSC412000U	12.0	30	75	12	4
EPSSC414000U	14.0	30	75	14	4
EPSSC416000U	16.0	40	100	16	4
EPSSC418000U	18.0	40	100	20	4
EPSSC420000U	20.0	45	100	20	4
EPSSC425000U	25.0	45	100	25	4

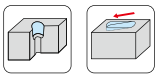
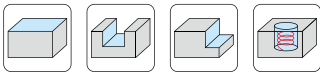
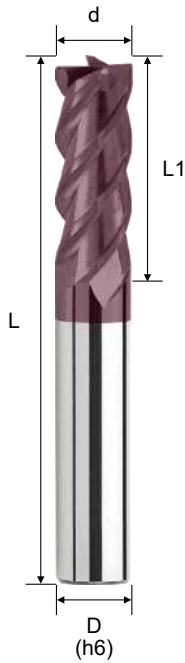
Cutting conditions : Table 026

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

**G550 - High Helix · Square · 4F**

- 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, FRP, etc.
- Greater shearing action results in increased speeds and feeds and faster stock removal.
- Strong helix design provides hi speed milling capabilities.

**EPSSH**



Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPSSH441000U	1.0	3	50	4	4
* EPSSH442000U	2.0	5	50	4	4
* EPSSH443000U	3.0	8	50	4	4
* EPSSH444000U	4.0	10	50	4	4
EPSSH405000U	5.0	13	50	6	4
EPSSH406000U	6.0	15	50	6	4
EPSSH407000U	7.0	18	60	8	4
EPSSH408000U	8.0	20	60	8	4
EPSSH409000U	9.0	22	75	10	4
EPSSH410000U	10.0	25	75	10	4
EPSSH411000U	11.0	25	75	12	4
EPSSH412000U	12.0	30	75	12	4
EPSSH414000U	14.0	30	75	14	4
EPSSH416000U	16.0	35	100	16	4



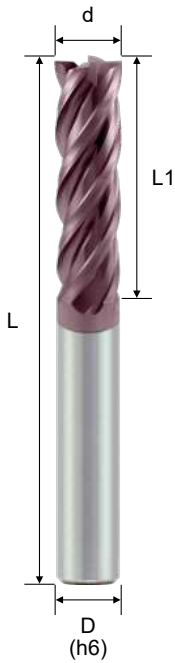
Cutting conditions : Table 027

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

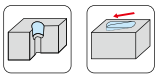
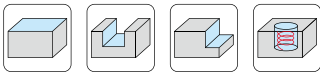
**G550 - Long Flute · Square · 4F**

- 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.

**EPSCC**



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



d Tolerance	
d ≤ 6	0 ~ -0.03
6 < d ≤ 12	0 ~ -0.04
d > 12	0 ~ -0.05

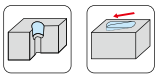
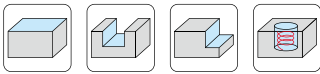
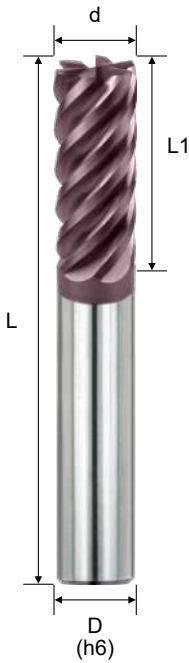
Cutting conditions : Table 028



**G550 - High Helix · Square · 6F**

- 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, FRP, etc.
- Greater shearing action results in increased speeds and feeds and faster stock removal.
- Strong helix design provides hi speed milling capabilities.
- Six flute for good surface milling.

**EPSSH**



Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
EPSSH606000U	6	15	50	6	6
EPSSH608000U	8	20	60	8	6
EPSSH610000U	10	25	75	10	6
EPSSH612000U	12	30	75	12	6



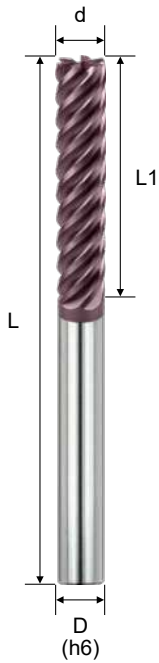
Cutting conditions : Table 027

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

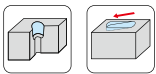
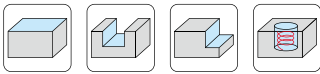
**G550 - High Helix · Long Flute · Square · 6F**

- 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, FRP, etc.
- Greater shearing action results in increased speeds and feeds and faster stock removal.
- Strong helix design provides hi speed milling capabilities.
- Six flute for good surface milling.

**EPSCH**



Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
EPSCH606000U	6	30	75	6	6
EPSCH608000U	8	35	100	8	6
EPSCH610000U	10	45	100	10	6
EPSCH612000U	12	45	100	12	6
EPSCH616000U	16	70	150	16	6



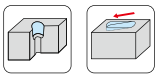
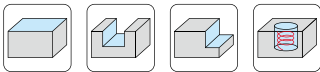
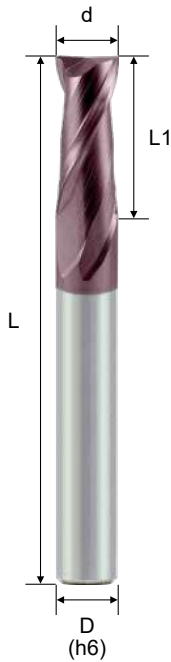
d Tolerance	
d ≤ 6	0 ~ -0.03
6 < d ≤ 12	0 ~ -0.04
d > 12	0 ~ -0.05

Cutting conditions : Table 029

**G550 - Long Shank · 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.
- Available in various length of cut and overall length end mills.
- Flat design to avoid chipping of the cutting tip.

**EPSLC**



d Tolerance	
d ≤ 6	0 ~ -0.03
6 < d ≤ 12	0 ~ -0.04
d > 12	0 ~ -0.05

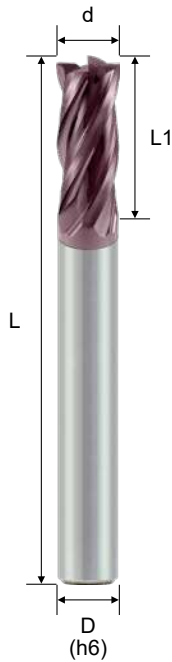
Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPSLC244006U	4	10	60	4	2
* EPSLC244007U	4	10	75	4	2
* EPSLC244010U	4	10	100	4	2
* EPSLC204006U	4	10	60	6	2
* EPSLC204007U	4	10	75	6	2
* EPSLC204010U	4	10	100	6	2
* EPSLC206006U	6	15	60	6	2
* EPSLC206007U	6	15	75	6	2
* EPSLC206010U	6	15	100	6	2
* EPSLC208007U	8	20	75	8	2
* EPSLC208010U	8	20	100	8	2
* EPSLC208015U	8	20	150	8	2
* EPSLC210010U	10	25	100	10	2
* EPSLC210015U	10	25	150	10	2
* EPSLC212010U	12	30	100	12	2
* EPSLC212015U	12	30	150	12	2
* EPSLC216015U	16	40	150	16	2
* EPSLC220015U	20	40	150	20	2

Cutting conditions : Table 030

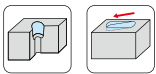
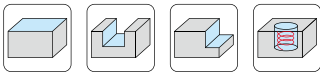
**G550 - Long Shank · Square · 4F**

- 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.
- Flat design to avoid chipping of the cutting tip.

**EPSLC**



Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPSLC443007U	3	8	75	4	4
* EPSLC443010U	3	8	100	4	4
* EPSLC444006U	4	10	60	4	4
* EPSLC444007U	4	10	75	4	4
* EPSLC444010U	4	10	100	4	4
* EPSLC404006U	4	10	60	6	4
* EPSLC404007U	4	10	75	6	4
* EPSLC404010U	4	10	100	6	4
* EPSLC406006U	6	15	60	6	4
* EPSLC406007U	6	15	75	6	4
* EPSLC406010U	6	15	100	6	4
* EPSLC408007U	8	20	75	8	4
* EPSLC408010U	8	20	100	8	4
* EPSLC408015U	8	20	150	8	4
* EPSLC410010U	10	25	100	10	4
* EPSLC410015U	10	25	150	10	4
* EPSLC412010U	12	30	100	12	4
* EPSLC412015U	12	30	150	12	4
* EPSLC416015U	16	40	150	16	4
* EPSLC420015U	20	40	150	20	4



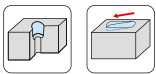
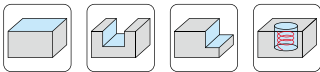
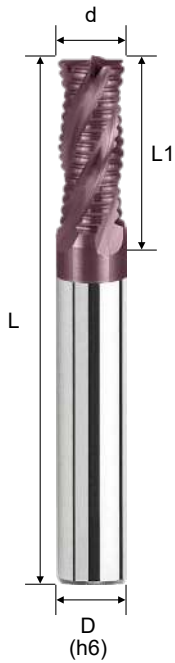
d Tolerance	
d ≤ 6	0 ~ -0.03
6 < d ≤ 12	0 ~ -0.04
d > 12	0 ~ -0.05

Cutting conditions : Table 031

**G550 - Roughing · Square · 4F**

- 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.
- Suitable for rough and high remove rate cutting environment.
- Chamfering design provides a stronger cutting edge.
- Middle coarse pitch provides hi performance and avoids tip fracture.

**EPSRR**



Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
EPSRR406000U	6	15	50	6	4
EPSRR408000U	8	20	60	8	4
EPSRR410000U	10	25	75	10	4
EPSRR412000U	12	30	75	12	4
EPSRR416000U	16	40	100	16	4
EPSRR420000U	20	45	100	20	4

Milling

Solid Carbide Endmills

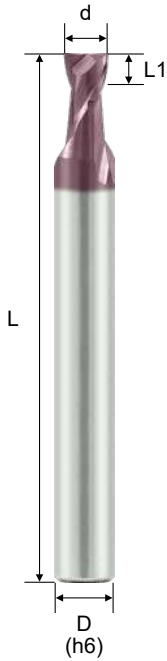
Cutting conditions : Table 032

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

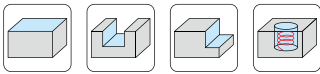
**G550 - Stub Length · Square · 2F**

- UNICO Coating provides superior wear resistance and reduces the coefficient of friction.
- The cutting length of approximately 1×D.
- Short cutting length with high rigidity is suitable for high feed milling.
- For die, mold, mechanical and electronic parts made of steel.
- Good for surface milling.

**EPSHC**



Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
EPSHC240200U	0.2	0.3	50	4	2
EPSHC240300U	0.3	0.4	50	4	2
EPSHC240400U	0.4	0.5	50	4	2
EPSHC240500U	0.5	0.6	50	4	2
EPSHC240600U	0.6	0.7	50	4	2
EPSHC240700U	0.7	0.8	50	4	2
EPSHC240800U	0.8	1.0	50	4	2
EPSHC240900U	0.9	1.1	50	4	2
EPSHC241000U	1.0	1.2	50	4	2
EPSHC241200U	1.2	1.5	50	4	2
EPSHC241400U	1.4	1.8	50	4	2
EPSHC241500U	1.5	1.8	50	4	2
EPSHC241600U	1.6	1.9	50	4	2
EPSHC241800U	1.8	2.0	50	4	2
EPSHC242000U	2.0	2.5	50	4	2
EPSHC242500U	2.5	3.0	50	4	2
EPSHC203000U	3.0	3.5	50	6	2
EPSHC204000U	4.0	4.5	50	6	2
EPSHC205000U	5.0	7.0	50	6	2
EPSHC206000U	6.0	9.0	50	6	2



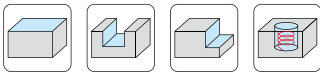
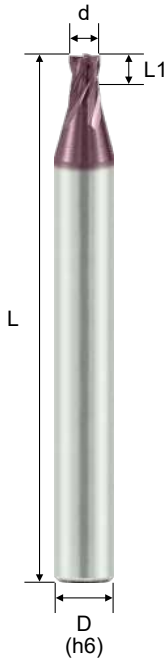
d Tolerance	
d ≤ 6	0 ~ -0.02
6 < d ≤ 12	0 ~ -0.03
d > 12	0 ~ -0.04

Cutting conditions : Table 033

G550 - Stub Length · Square · 4F

- UNICO Coating provides superior wear resistance and reduces the coefficient of friction.
- The cutting length of approximately 1×D.
- Short cutting length with high rigidity is suitable for high feed milling.
- For die, mold, mechanical and electronic parts made of steel.
- Good for surface milling.

EPSHC



Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
EPSHC441000U	1.0	1.0	50	4	4
EPSHC441500U	1.5	1.5	50	4	4
EPSHC442000U	2.0	2.0	50	4	4
EPSHC442500U	2.5	2.5	50	4	4
EPSHC403000U	3.0	3.0	50	6	4
EPSHC404000U	4.0	4.0	50	6	4
EPSHC405000U	5.0	5.0	50	6	4
EPSHC406000U	6.0	6.0	50	6	4

Milling

Solid Carbide Endmills

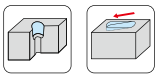
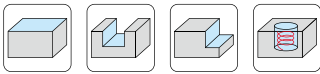
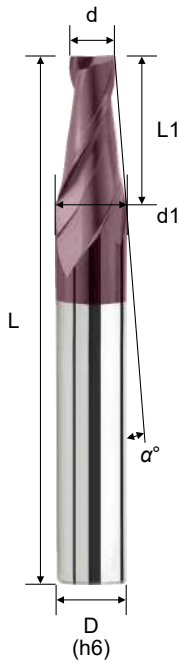
Cutting conditions : Table 033

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

G550 - Taper · 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.
- High strength of taper cutting length, can cut deep grooves without breaking.
- Convenient for Tap cutting in 3 axis machine.

EPSST



Order No.	Dia. (d)	$\alpha^\circ$	CL (L1)	NL (d1)	OAL (L)	Shank (D)	Flutes (F)
* EPSST24015CU	0.15	20°	5.29	-	42	4	2
* EPSST24030CU	0.30	20°	5.08	-	42	4	2
* EPSST24030DU	0.30	25°	3.96	-	42	4	2
* EPSST24060BU	0.60	15°	4.50	-	42	4	2
* EPSST24060CU	0.60	20°	4.67	-	42	4	2
* EPSST24120CU	1.20	20°	3.84	-	42	4	2
* EPSST241005U	1.0	0.5°	4.0	1.07	50	4	2
* EPSST241010U	1.0	1.0°	4.0	1.14	50	4	2
* EPSST241015U	1.0	1.5°	4.0	1.21	50	4	2
* EPSST241020U	1.0	2.0°	4.0	1.28	50	4	2
* EPSST241025U	1.0	2.5°	4.0	1.35	50	4	2
* EPSST241030U	1.0	3.0°	4.0	1.42	50	4	2
* EPSST241050U	1.0	5.0°	4.0	1.70	50	4	2
* EPSST241070U	1.0	7.0°	4.0	1.98	50	4	2
* EPSST2410A0U	1.0	10.0°	4.0	2.41	50	4	2
* EPSST2410A5U	1.0	15.0°	4.0	3.14	50	4	2
* EPSST241505U	1.5	0.5°	5.0	1.59	50	4	2
* EPSST241510U	1.5	1.0°	5.0	1.68	50	4	2
* EPSST241515U	1.5	1.5°	5.0	1.76	50	4	2
* EPSST241520U	1.5	2.0°	5.0	1.85	50	4	2
* EPSST241525U	1.5	2.5°	5.0	1.93	50	4	2
* EPSST241530U	1.5	3.0°	5.0	2.02	50	4	2
* EPSST241550U	1.5	5.0°	5.0	2.37	50	4	2
* EPSST242005U	2.0	0.5°	6.0	2.10	50	4	2
* EPSST242010U	2.0	1.0°	6.0	2.21	50	4	2
* EPSST242015U	2.0	1.5°	6.0	2.31	50	4	2
* EPSST242020U	2.0	2.0°	6.0	2.41	50	4	2
* EPSST242025U	2.0	2.5°	6.0	2.52	50	4	2
* EPSST242030U	2.0	3.0°	6.0	2.62	50	4	2
* EPSST242050U	2.0	5.0°	6.0	3.05	50	4	2
* EPSST242070U	2.0	7.0°	6.0	3.47	50	4	2
EPSST2020A0U	2.0	10.0°	6.0	4.11	50	6	2
EPSST2020A5U	2.0	15.0°	6.0	5.22	50	6	2

Cutting conditions : Table 034

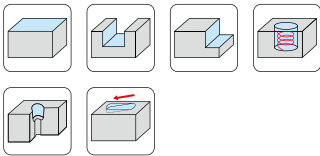
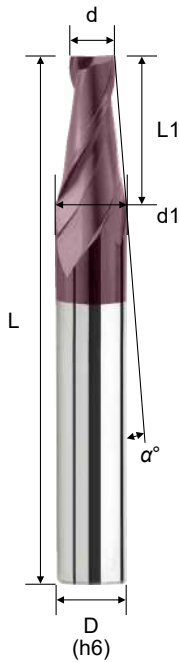
d Tolerance	
d ≤ 6	0 ~ -0.02
6 < d ≤ 12	0 ~ -0.03
d > 12	0 ~ -0.04



G550 - Taper · 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.
- High strength of taper cutting length, can cut deep grooves without breaking.
- Convenient for Tap cutting in 3 axis machine.

EPSST



Order No.	Dia. (d)	$\alpha^\circ$	CL (L1)	NL (d1)	OAL (L)	Shank (D)	Flutes (F)
* EPSST242505U	2.5	0.5°	8.0	2.64	50	4	2
* EPSST242510U	2.5	1.0°	8.0	2.78	50	4	2
* EPSST242515U	2.5	1.5°	8.0	2.91	50	4	2
* EPSST242520U	2.5	2.0°	8.0	3.05	50	4	2
* EPSST242525U	2.5	2.5°	8.0	3.20	50	4	2
* EPSST242530U	2.5	3.0°	8.0	3.33	50	4	2
* EPSST242550U	2.5	5.0°	8.0	3.90	50	4	2
EPSST203005U	3.0	0.5°	10.0	3.17	50	6	2
EPSST203010U	3.0	1.0°	10.0	3.35	50	6	2
EPSST203015U	3.0	1.5°	10.0	3.52	50	6	2
EPSST203020U	3.0	2.0°	10.0	3.69	50	6	2
EPSST203025U	3.0	2.5°	10.0	3.87	50	6	2
EPSST203030U	3.0	3.0°	10.0	4.05	50	6	2
EPSST203050U	3.0	5.0°	10.0	4.75	50	6	2
EPSST203070U	3.0	7.0°	12.0	6.00	50	6	2
EPSST2030A0U	3.0	10.0°	12.0	7.22	60	8	2
EPSST2030A5U	3.0	15.0°	12.0	9.40	75	10	2
EPSST204005U	4.0	0.5°	15.0	4.26	50	6	2
EPSST204010U	4.0	1.0°	15.0	4.52	50	6	2
EPSST204015U	4.0	1.5°	15.0	4.79	50	6	2
EPSST204020U	4.0	2.0°	15.0	5.04	50	6	2
EPSST204025U	4.0	2.5°	15.0	5.31	50	6	2
EPSST204030U	4.0	3.0°	15.0	5.57	50	6	2
EPSST204050U	4.0	5.0°	15.0	6.62	60	8	2
EPSST204070U	4.0	7.0°	16.0	8.00	60	8	2
EPSST2040A0U	4.0	10.0°	17.0	10.00	75	10	2
EPSST2040A5U	4.0	15.0°	14.9	12.00	75	12	2

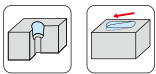
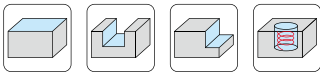
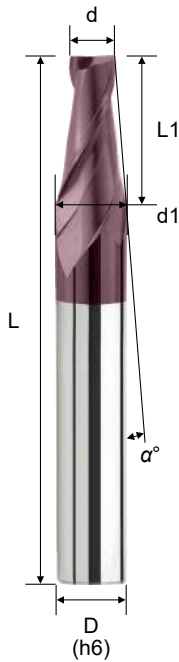
Cutting conditions : Table 034

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

G550 - Taper · 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.
- High strength of taper cutting length, can cut deep grooves without breaking.
- Convenient for Tap cutting in 3 axis machine.

EPSST



Order No.	Dia. (d)	$\alpha^\circ$	CL (L1)	NL (d1)	OAL (L)	Shank (D)	Flutes (F)
EPSST205005U	5.0	0.5°	20.0	5.34	60	6	2
EPSST205010U	5.0	1.0°	20.0	5.70	60	6	2
EPSST205015U	5.0	1.5°	19.6	6.00	60	6	2
EPSST205020U	5.0	2.0°	20.0	6.39	60	8	2
EPSST205025U	5.0	2.5°	20.0	6.74	60	8	2
EPSST205030U	5.0	3.0°	20.0	7.10	60	8	2
EPSST205050U	5.0	5.0°	20.0	8.50	75	10	2
EPSST205070U	5.0	7.0°	20.0	10.00	75	10	2
EPSST2050A0U	5.0	10.0°	20.0	12.00	75	12	2
EPSST206005U	6.0	0.5°	20.0	6.35	60	8	2
EPSST206010U	6.0	1.0°	20.0	6.70	60	8	2
EPSST206015U	6.0	1.5°	20.0	7.05	60	8	2
EPSST206020U	6.0	2.0°	20.0	7.40	60	8	2
EPSST206025U	6.0	2.5°	20.0	7.75	60	8	2
EPSST206030U	6.0	3.0°	20.0	8.10	75	10	2
EPSST206050U	6.0	5.0°	20.0	9.50	75	10	2
EPSST206070U	6.0	7.0°	24.0	12.00	75	12	2
EPSST2060A0U	6.0	10.0°	22.0	14.00	75	14	2
EPSST208005U	8.0	0.5°	25.0	8.44	75	10	2
EPSST208010U	8.0	1.0°	25.0	8.87	75	10	2
EPSST208015U	8.0	1.5°	25.0	9.31	75	10	2
EPSST208020U	8.0	2.0°	25.0	9.75	75	10	2
EPSST208030U	8.0	3.0°	25.0	10.62	75	12	2
EPSST208050U	8.0	5.0°	25.0	12.37	75	14	2
EPSST208070U	8.0	7.0°	32.0	16.00	100	16	2
EPSST2080A0U	8.0	10.0°	28.0	18.00	100	18	2
EPSST210005U	10.0	0.5°	35.0	10.61	75	12	2
EPSST210010U	10.0	1.0°	35.0	11.22	75	12	2
EPSST210015U	10.0	1.5°	35.0	11.83	75	12	2
EPSST210020U	10.0	2.0°	35.0	12.44	75	14	2
EPSST210030U	10.0	3.0°	35.0	13.67	75	14	2
EPSST210050U	10.0	5.0°	34.2	16.00	100	16	2

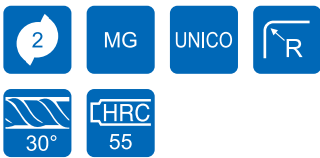
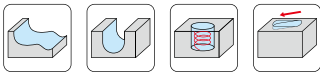
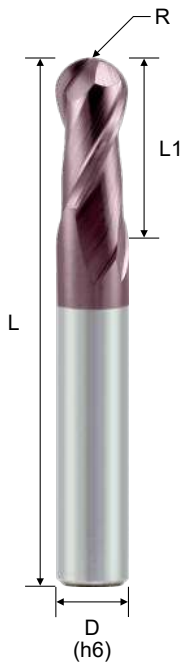
Cutting conditions : Table 034

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

**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**



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

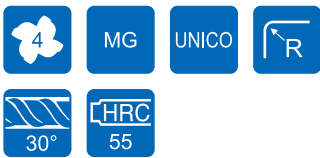
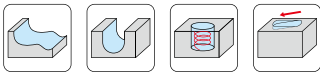
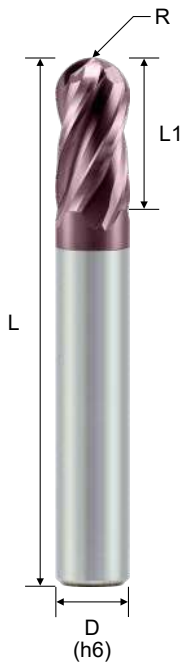
Order No.	Radius (R)	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPBSC240200U	0.10R	0.2	0.4	50	4	2
* EPBSC240300U	0.15R	0.3	0.6	50	4	2
* EPBSC240400U	0.20R	0.4	0.8	50	4	2
* EPBSC240500U	0.25R	0.5	1.0	50	4	2
* EPBSC240600U	0.30R	0.6	1.2	50	4	2
* EPBSC240700U	0.35R	0.7	1.4	50	4	2
* EPBSC240800U	0.40R	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

**G550 - Ball Nose · 4F**

- 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, Copper, FRP, etc.
- It provides an excellent surface due to better surface grindings.
- New tool geometry increases wear resistance and cutting force is decreased.
- Multiple flutes design improves the cutting surface.

**EPBSC**



Order No.	Radius (R)	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPBSC442000U	1.0R	2	4	50	4	4
* EPBSC443000U	1.5R	3	6	50	4	4
* EPBSC444000U	2.0R	4	8	50	4	4
EPBSC404000U	2.0R	4	8	50	6	4
EPBSC405000U	2.5R	5	10	50	6	4
EPBSC406000U	3.0R	6	12	50	6	4
EPBSC408000U	4.0R	8	16	60	8	4
EPBSC410000U	5.0R	10	20	75	10	4
EPBSC412000U	6.0R	12	24	75	12	4
EPBSC416000U	8.0R	16	32	100	16	4
EPBSC420000U	10.0R	20	40	100	20	4

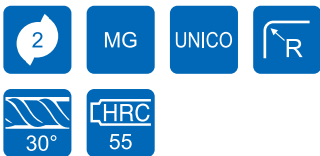
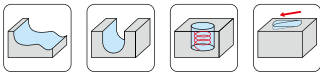
Cutting conditions : Table 036

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

**G550 - Long Shank · 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.

**EPBLC**



Order No.	Radius (R)	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPBLC243007U	1.5R	3	6	75	4	2
* EPBLC243010U	1.5R	3	6	100	4	2
* EPBLC244006U	2.0R	4	8	60	4	2
* EPBLC244007U	2.0R	4	8	75	4	2
* EPBLC244010U	2.0R	4	8	100	4	2
* EPBLC204006U	2.0R	4	8	60	6	2
* EPBLC204007U	2.0R	4	8	75	6	2
* EPBLC204010U	2.0R	4	8	100	6	2
* EPBLC206006U	3.0R	6	12	60	6	2
* EPBLC206007U	3.0R	6	12	75	6	2
* EPBLC206010U	3.0R	6	12	100	6	2
* EPBLC208007U	4.0R	8	16	75	8	2
* EPBLC208010U	4.0R	8	16	100	8	2
* EPBLC208015U	4.0R	8	16	150	8	2
* EPBLC210010U	5.0R	10	20	100	10	2
* EPBLC210015U	5.0R	10	20	150	10	2
* EPBLC212010U	6.0R	12	24	100	12	2
* EPBLC212015U	6.0R	12	24	150	12	2
* EPBLC216015U	8.0R	16	32	150	16	2
* EPBLC220015U	10.0R	20	40	150	20	2

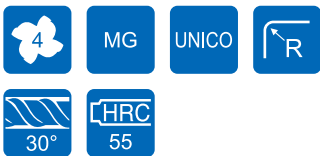
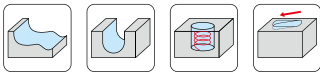
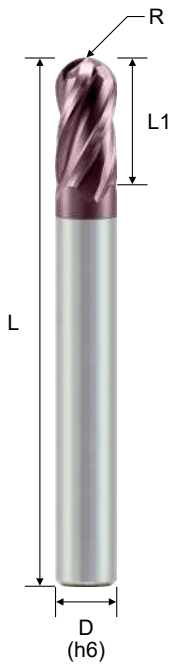
Cutting conditions : Table 037

R Tolerance	
R ≤ 3	±0.020
R > 3	±0.025

**G550 - Long Shank · Ball Nose · 4F**

- 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.
- Multiple flutes design and long shank design makes possible deep surface cutting.

**EPBLC**



Order No.	Radius (R)	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPBLC444007U	2R	4	8	75	4	4
* EPBLC444010U	2R	4	8	100	4	4
* EPBLC404007U	2R	4	8	75	6	4
* EPBLC404010U	2R	4	8	100	6	4
* EPBLC406007U	3R	6	12	75	6	4
* EPBLC406010U	3R	6	12	100	6	4
* EPBLC408007U	4R	8	16	75	8	4
* EPBLC408010U	4R	8	16	100	8	4
* EPBLC408015U	4R	8	16	150	8	4
* EPBLC410010U	5R	10	20	100	10	4
* EPBLC410015U	5R	10	20	150	10	4
* EPBLC412010U	6R	12	24	100	12	4
* EPBLC412015U	6R	12	24	150	12	4
* EPBLC416015U	8R	16	32	150	16	4

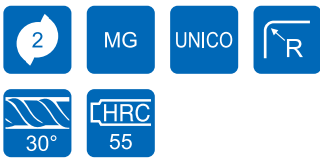
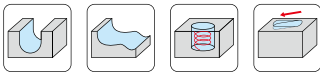
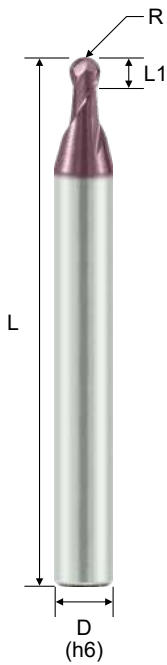
Cutting conditions : Table 038

R Tolerance	
R ≤ 3	±0.020
R > 3	±0.025

**G550 - Stub Length · Ball Nose · 2F**

- UNICO Coating provides superior wear resistance and reduces the coefficient of friction.
- The cutting length of approximately 1×D.
- Short cutting length with high rigidity is suitable for high feed milling.
- For die, mold, mechanical and electronic parts made of steel.
- Good for surface milling.

**EPBHC**



Order No.	Radius (R)	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
EPBHC240200U	0.10R	0.2	0.2	50	4	2
EPBHC240300U	0.15R	0.3	0.3	50	4	2
EPBHC240400U	0.20R	0.4	0.4	50	4	2
EPBHC240500U	0.25R	0.5	0.5	50	4	2
EPBHC240600U	0.30R	0.6	0.6	50	4	2
EPBHC240700U	0.35R	0.7	0.7	50	4	2
EPBHC240800U	0.40R	0.8	0.8	50	4	2
EPBHC240900U	0.45R	0.9	0.9	50	4	2
EPBHC241000U	0.50R	1.0	1.0	50	4	2
EPBHC241200U	0.60R	1.2	1.2	50	4	2
EPBHC241400U	0.70R	1.4	1.4	50	4	2
EPBHC241500U	0.75R	1.5	1.5	50	4	2
EPBHC241600U	0.80R	1.6	1.6	50	4	2
EPBHC241800U	0.90R	1.8	1.8	50	4	2
EPBHC242000U	1.00R	2.0	2.0	50	4	2
EPBHC242500U	1.25R	2.5	2.5	50	4	2
EPBHC203000U	1.50R	3.0	3.0	50	6	2
EPBHC204000U	2.00R	4.0	4.0	50	6	2
EPBHC205000U	2.50R	5.0	5.0	50	6	2
EPBHC206000U	3.00R	6.0	9.0	50	6	2

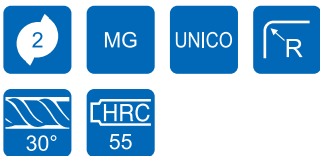
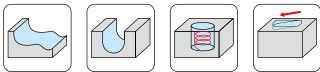
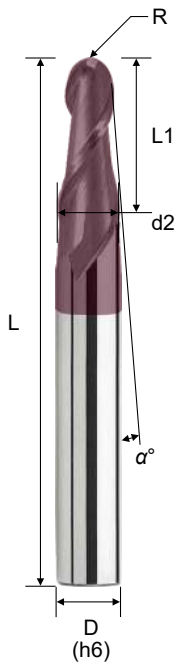
Cutting conditions : Table 039

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

**G550 - Taper · 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.
- Tape cutting length is convenient for high performance 3D milling.
- Stronger geometry design gives good wear resistance.

**EPBST**



Order No.	Radius (R)	$\alpha^\circ$	CL (L1)	NL (d2)	OAL (L)	Shank (D)	Flutes (F)
* EPBST242010U	1.00R	1°	8	2.24	50	4	2
* EPBST242030U	1.00R	3°	8	2.74	50	4	2
* EPBST242050U	1.00R	5°	8	3.23	50	4	2
* EPBST242510U	1.25R	1°	10	2.81	50	4	2
* EPBST242530U	1.25R	3°	10	3.42	50	4	2
EPBST202550U	1.25R	5°	10	4.04	50	6	2
* EPBST243010U	1.50R	1°	12	3.37	50	4	2
EPBST203030U	1.50R	3°	12	4.10	50	6	2
EPBST203050U	1.50R	5°	12	4.85	50	6	2
EPBST204010U	2.00R	1°	16	4.49	60	6	2
EPBST204030U	2.00R	3°	16	5.47	60	6	2
EPBST204050U	2.00R	5°	16	6.46	60	8	2
EPBST206010U	3.00R	1°	24	6.73	75	8	2
EPBST206030U	3.00R	3°	24	8.20	75	10	2
EPBST206050U	3.00R	5°	24	9.67	75	10	2

Cutting conditions : Table 040

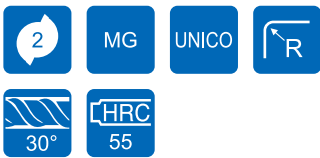
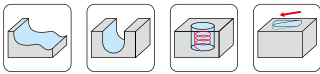
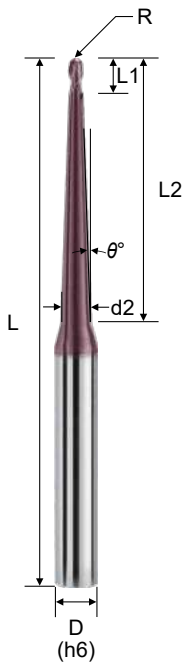
R Tolerance	
R ≤ 3	±0.015
R > 3	±0.020



**G550 - Taper Neck · 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.
- Suitable for high performance profile milling.
- High strength of taper neck, can cut deep grooves without breaking.

**EPBRT**



Order No.	Radius (R)	Dia. (d)	$\theta^\circ$	CL (L1)	EFF-L (L2)	NL (d2)	OAL (L)	Shank (D)	Flutes (F)
EPBRT201023AU	0.5R	1	1.5°	2	23	2.10	60	6	2
EPBRT2010235U	0.5R	1	5.0°	2	23	4.67	60	6	2
EPBRT2010423U	0.5R	1	3.0°	2	42	5.19	75	6	2
EPBRT202035HU	1.0R	2	0.5°	4	35	2.54	75	6	2
EPBRT2020351U	1.0R	2	1.0°	4	35	3.08	75	6	2
EPBRT202023AU	1.0R	2	1.5°	4	23	3.00	60	6	2
EPBRT202035AU	1.0R	2	1.5°	4	35	3.62	75	6	2
EPBRT2020235U	1.0R	2	5.0°	4	23	5.32	60	6	2
EPBRT2020413U	1.0R	2	3.0°	4	41	5.88	75	6	2
EPBRT203052AU	1.5R	3	1.5°	6	52	5.40	100	6	2
EPBRT2030323U	1.5R	3	3.0°	6	32	5.73	75	6	2
EPBRT204046AU	2.0R	4	1.5°	8	46	6.00	100	6	2
EPBRT2040273U	2.0R	4	3.0°	8	27	6.00	75	6	2

Milling

Solid Carbide Endmills

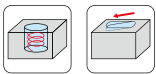
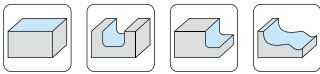
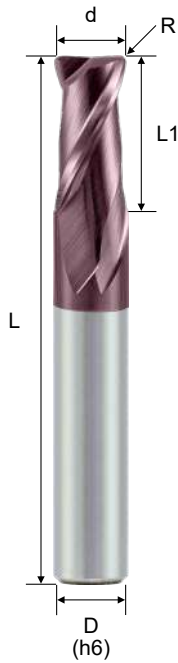
Cutting conditions : Table 040

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

**G550 - Corner Radius · 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.
- Corner radius design is suitable for high speed surface milling and profiling.

**EPCSC**



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

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

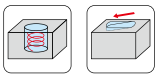
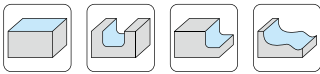
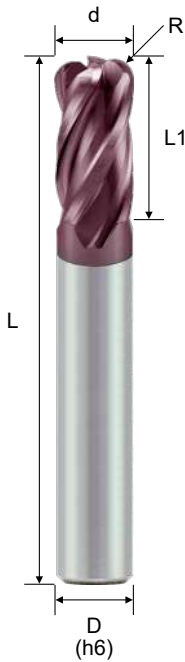
Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPCSC241001U	1.0	0.1R	2	50	4	2
* EPCSC241002U	1.0	0.2R	2	50	4	2
* EPCSC241003U	1.0	0.3R	2	50	4	2
* EPCSC241502U	1.5	0.2R	3	50	4	2
* EPCSC241503U	1.5	0.3R	3	50	4	2
* EPCSC241505U	1.5	0.5R	3	50	4	2
* EPCSC242002U	2.0	0.2R	4	50	4	2
* EPCSC242003U	2.0	0.3R	4	50	4	2
* EPCSC242005U	2.0	0.5R	4	50	4	2
* EPCSC243002U	3.0	0.2R	6	50	4	2
* EPCSC243003U	3.0	0.3R	6	50	4	2
* EPCSC243005U	3.0	0.5R	6	50	4	2
* EPCSC244002U	4.0	0.2R	8	50	4	2
* EPCSC244003U	4.0	0.3R	8	50	4	2
* EPCSC244005U	4.0	0.5R	8	50	4	2
* EPCSC244010U	4.0	1R	8	50	4	2
EPCSC204003U	4.0	0.3R	8	50	6	2
EPCSC204005U	4.0	0.5R	8	50	6	2
EPCSC204010U	4.0	1.0R	8	50	6	2
EPCSC205005U	5.0	0.5R	10	50	6	2
EPCSC205010U	5.0	1.0R	10	50	6	2
EPCSC206003U	6.0	0.3R	12	50	6	2
EPCSC206005U	6.0	0.5R	12	50	6	2
EPCSC206010U	6.0	1.0R	12	50	6	2
EPCSC208005U	8.0	0.5R	16	60	8	2
EPCSC208010U	8.0	1.0R	16	60	8	2
EPCSC208015U	8.0	1.5R	16	60	8	2
EPCSC210005U	10.0	0.5R	20	75	10	2
EPCSC210010U	10.0	1.0R	20	75	10	2
EPCSC210015U	10.0	1.5R	20	75	10	2
EPCSC212020U	10.0	2.0R	20	75	10	2
EPCSC212005U	12.0	0.5R	20	75	12	2
EPCSC212010U	12.0	1.0R	20	75	12	2
EPCSC212015U	12.0	1.5R	20	75	12	2
EPCSC212020U	12.0	2.0R	20	75	12	2

Cutting conditions : Table 041

G550 - Corner Radius · 4F

- 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.
- Corner radius with multiple design increases the finish milling surface.

EPCSC



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

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

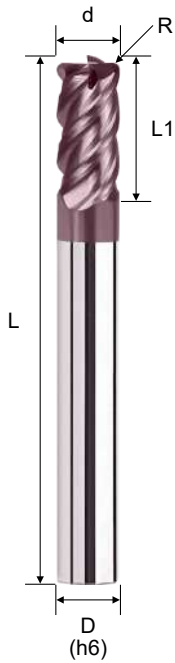
Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPCSC441002U	1.0	0.2R	2	50	4	4
* EPCSC441003U	1.0	0.3R	2	50	4	4
* EPCSC441502U	1.5	0.2R	3	50	4	4
* EPCSC441503U	1.5	0.3R	3	50	4	4
* EPCSC441505U	1.5	0.5R	3	50	4	4
* EPCSC442002U	2.0	0.2R	4	50	4	4
* EPCSC442003U	2.0	0.3R	4	50	4	4
* EPCSC442005U	2.0	0.5R	4	50	4	4
* EPCSC443002U	3.0	0.2R	6	50	4	4
* EPCSC443003U	3.0	0.3R	6	50	4	4
* EPCSC433005U	3.0	0.5R	6	50	3	4
* EPCSC443005U	3.0	0.5R	6	50	4	4
* EPCSC443010U	3.0	1.0R	6	50	4	4
EPCSC403003U	3.0	0.3R	6	50	6	4
EPCSC403005U	3.0	0.5R	6	50	6	4
EPCSC403010U	3.0	1.0R	6	50	6	4
* EPCSC444001U	4.0	0.1R	8	50	4	4
* EPCSC444002U	4.0	0.2R	8	50	4	4
* EPCSC444003U	4.0	0.3R	8	50	4	4
* EPCSC444005U	4.0	0.5R	8	50	4	4
* EPCSC444010U	4.0	1.0R	8	50	4	4
EPCSC404003U	4.0	0.3R	8	50	6	4
EPCSC404005U	4.0	0.5R	8	50	6	4
EPCSC404010U	4.0	1.0R	8	50	6	4
EPCSC405005U	5.0	0.5R	10	50	6	4
EPCSC405010U	5.0	1.0R	10	50	6	4
EPCSC406003U	6.0	0.3R	12	50	6	4
EPCSC406005U	6.0	0.5R	12	50	6	4
EPCSC406010U	6.0	1.0R	12	50	6	4
EPCSC408005U	8.0	0.5R	16	60	8	4
EPCSC408010U	8.0	1.0R	16	60	8	4
EPCSC408015U	8.0	1.5R	16	60	8	4
EPCSC410005U	10.0	0.5R	20	75	10	4
EPCSC410010U	10.0	1.0R	20	75	10	4
EPCSC410015U	10.0	1.5R	20	75	10	4
EPCSC410020U	10.0	2.0R	20	75	10	4
EPCSC412005U	12.0	0.5R	24	75	12	4
EPCSC412010U	12.0	1.0R	24	75	12	4
EPCSC412015U	12.0	1.5R	24	75	12	4
EPCSC412020U	12.0	2.0R	24	75	12	4
EPCSC412030U	12.0	3.0R	24	75	12	4
EPCSC416010U	16.0	1.0R	32	100	16	4
EPCSC416020U	16.0	2.0R	32	100	16	4
EPCSC416030U	16.0	3.0R	32	100	16	4

Cutting conditions : Table 042

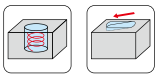
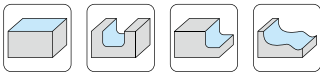
**G550 - High Helix · Corner Radius · 4F**

- 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.
- Corner radius with high helix angle improves the side milling quality.

**EPCSH**



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPCSH443005U	3.0	0.5R	6	50	4	4
* EPCSH444005U	4.0	0.5R	8	50	4	4
EPCSH405005U	5.0	0.5R	10	50	6	4
EPCSH405010U	5.0	1.0R	10	50	6	4
EPCSH406005U	6.0	0.5R	12	50	6	4
EPCSH406010U	6.0	1.0R	12	50	6	4
EPCSH408005U	8.0	0.5R	16	60	8	4
EPCSH408010U	8.0	1.0R	16	60	8	4
EPCSH410005U	10.0	0.5R	20	75	10	4
EPCSH410010U	10.0	1.0R	20	75	10	4
EPCSH410015U	10.0	1.5R	20	75	10	4
EPCSH410020U	10.0	2.0R	20	75	10	4
EPCSH412010U	12.0	1.0R	24	75	12	4
EPCSH412020U	12.0	2.0R	24	75	12	4
EPCSH412030U	12.0	3.0R	24	75	12	4



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

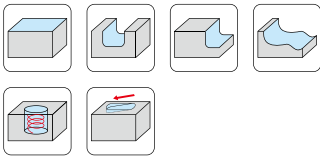
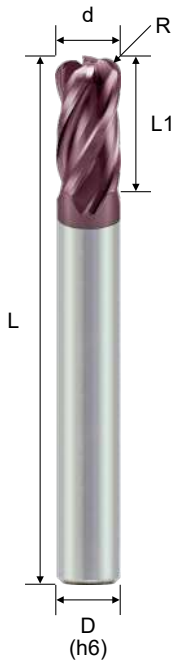
R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

Cutting conditions : Table 043

**G550 - Long Shank · Corner Radius · 4F**

- 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.
- Corner radius with multiple flutes is suitable for general cutting and 3D milling.

**EPCLC**



d Tolerance	
d ≤ 6	0 ~ -0.03
6 < d ≤ 12	0 ~ -0.04
d > 12	0 ~ -0.05

R Tolerance	
R < 2	±0.020
R ≥ 2	±0.025

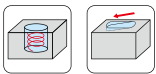
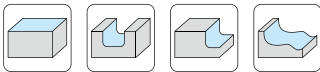
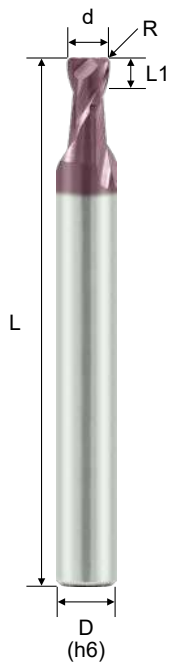
Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* EPCLC44400507U	4	0.5R	8	75	4	4
* EPCLC44400510U	4	0.5R	8	100	4	4
* EPCLC40300507U	3	0.5R	6	75	6	4
* EPCLC40301007U	3	1.0R	6	75	6	4
* EPCLC40400507U	4	0.5R	8	75	6	4
* EPCLC40401007U	4	1.0R	8	75	6	4
* EPCLC40500507U	5	0.5R	10	75	6	4
* EPCLC40501007U	5	1.0R	10	75	6	4
* EPCLC40600507U	6	0.5R	12	75	6	4
* EPCLC40601007U	6	1.0R	12	75	6	4
* EPCLC40600510U	6	0.5R	12	100	6	4
* EPCLC40800507U	8	0.5R	16	75	8	4
* EPCLC40800510U	8	0.5R	16	100	8	4
* EPCLC40801010U	8	1.0R	16	100	8	4
* EPCLC40801510U	8	1.5R	16	100	8	4
* EPCLC41000510U	10	0.5R	20	100	10	4
* EPCLC41001010U	10	1.0R	20	100	10	4
* EPCLC41001510U	10	1.5R	20	100	10	4
* EPCLC41002010U	10	2.0R	20	100	10	4
* EPCLC41000515U	10	0.5R	20	150	10	4
* EPCLC41200510U	12	0.5R	24	100	12	4
* EPCLC41201010U	12	1.0R	24	100	12	4
* EPCLC41201510U	12	1.5R	24	100	12	4
* EPCLC41202010U	12	2.0R	24	100	12	4
* EPCLC41200515U	12	0.5R	24	150	12	4
* EPCLC41601015U	16	1.0R	32	150	16	4
* EPCLC41602015U	16	2.0R	32	150	16	4
* EPCLC41603015U	16	3.0R	32	150	16	4

Cutting conditions : Table 044

G550 - Stub Length · Corner Radius · 2F

- UNICO Coating provides superior wear resistance and reduces the coefficient of friction.
- The cutting length of approximately 1×D.
- Short cutting length with high rigidity is suitable for high feed milling.
- For die, mold, mechanical and electronic parts made of steel.
- Good for surface milling.

EPCHC



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

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

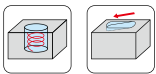
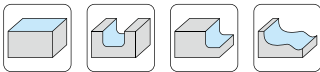
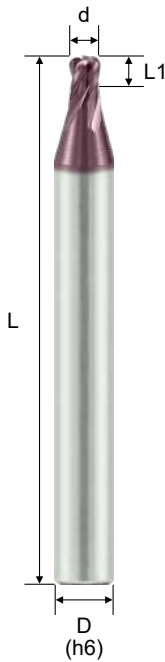
Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
EPCHC241001U	1.0	0.1R	1.0	50	4	2
EPCHC241002U	1.0	0.2R	1.0	50	4	2
EPCHC241003U	1.0	0.3R	1.0	50	4	2
EPCHC241201U	1.2	0.1R	1.2	50	4	2
EPCHC241202U	1.2	0.2R	1.2	50	4	2
EPCHC241203U	1.2	0.3R	1.2	50	4	2
EPCHC241501U	1.5	0.1R	1.5	50	4	2
EPCHC241502U	1.5	0.2R	1.5	50	4	2
EPCHC241503U	1.5	0.3R	1.5	50	4	2
EPCHC241505U	1.5	0.5R	1.5	50	4	2
EPCHC242001U	2.0	0.1R	2.0	50	4	2
EPCHC242002U	2.0	0.2R	2.0	50	4	2
EPCHC242003U	2.0	0.3R	2.0	50	4	2
EPCHC242005U	2.0	0.5R	2.0	50	4	2
EPCHC242501U	2.5	0.1R	2.5	50	4	2
EPCHC242502U	2.5	0.2R	2.5	50	4	2
EPCHC242503U	2.5	0.3R	2.5	50	4	2
EPCHC242505U	2.5	0.5R	2.5	50	4	2
EPCHC203001U	3.0	0.1R	3.0	50	6	2
EPCHC203002U	3.0	0.2R	3.0	50	6	2
EPCHC203003U	3.0	0.3R	3.0	50	6	2
EPCHC203005U	3.0	0.5R	3.0	50	6	2
EPCHC203010U	3.0	1.0R	3.0	50	6	2
EPCHC204001U	4.0	0.1R	4.0	50	6	2
EPCHC204002U	4.0	0.2R	4.0	50	6	2
EPCHC204003U	4.0	0.3R	4.0	50	6	2
EPCHC204005U	4.0	0.5R	4.0	50	6	2
EPCHC204010U	4.0	1.0R	4.0	50	6	2
EPCHC205001U	5.0	0.1R	5.0	50	6	2
EPCHC205002U	5.0	0.2R	5.0	50	6	2
EPCHC205003U	5.0	0.3R	5.0	50	6	2
EPCHC205005U	5.0	0.5R	5.0	50	6	2
EPCHC205010U	5.0	1.0R	5.0	50	6	2
EPCHC206001U	6.0	0.1R	7.0	50	6	2
EPCHC206002U	6.0	0.2R	7.0	50	6	2
EPCHC206003U	6.0	0.3R	7.0	50	6	2
EPCHC206005U	6.0	0.5R	7.0	50	6	2
EPCHC206010U	6.0	1.0R	7.0	50	6	2
EPCHC206015U	6.0	1.5R	7.0	50	6	2

Cutting conditions : Table 045

G550 - Stub Length · Corner Radius · 4F

- UNICO Coating provides superior wear resistance and reduces the coefficient of friction.
- The cutting length of approximately 1×D.
- Short cutting length with high rigidity is suitable for high feed milling.
- For die, mold, mechanical and electronic parts made of steel.
- Good for surface milling.

EPCHC



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

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

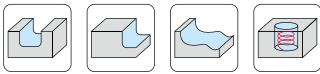
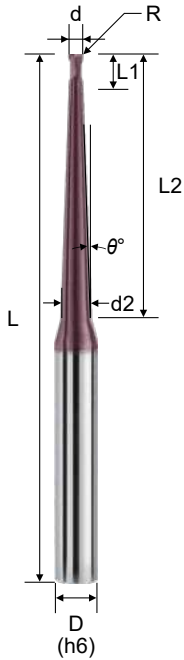
Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
EPCHC442001U	2.0	0.1R	2.0	50	4	4
EPCHC442002U	2.0	0.2R	2.0	50	4	4
EPCHC442003U	2.0	0.3R	2.0	50	4	4
EPCHC442005U	2.0	0.5R	2.0	50	4	4
EPCHC442501U	2.5	0.1R	2.5	50	4	4
EPCHC442502U	2.5	0.2R	2.5	50	4	4
EPCHC442503U	2.5	0.3R	2.5	50	4	4
EPCHC442505U	2.5	0.5R	2.5	50	4	4
EPCHC403001U	3.0	0.1R	3.0	50	6	4
EPCHC403002U	3.0	0.2R	3.0	50	6	4
EPCHC403003U	3.0	0.3R	3.0	50	6	4
EPCHC403005U	3.0	0.5R	3.0	50	6	4
EPCHC403010U	3.0	1.0R	3.0	50	6	4
EPCHC404001U	4.0	0.1R	4.0	50	6	4
EPCHC404002U	4.0	0.2R	4.0	50	6	4
EPCHC404003U	4.0	0.3R	4.0	50	6	4
EPCHC404005U	4.0	0.5R	4.0	50	6	4
EPCHC404010U	4.0	1.0R	4.0	50	6	4
EPCHC405001U	5.0	0.1R	5.0	50	6	4
EPCHC405002U	5.0	0.2R	5.0	50	6	4
EPCHC405003U	5.0	0.3R	5.0	50	6	4
EPCHC405005U	5.0	0.5R	5.0	50	6	4
EPCHC405010U	5.0	1.0R	5.0	50	6	4
EPCHC406001U	6.0	0.1R	7.0	50	6	4
EPCHC406002U	6.0	0.2R	7.0	50	6	4
EPCHC406003U	6.0	0.3R	7.0	50	6	4
EPCHC406005U	6.0	0.5R	7.0	50	6	4
EPCHC406010U	6.0	1.0R	7.0	50	6	4
EPCHC406015U	6.0	1.5R	7.0	50	6	4

Cutting conditions : Table 045

**G550 - Taper Neck · Corner Radius · 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.
  - Various taper angle makes it suitable for different applications.
  - Small corner radius applied protect chipping of cutting edges.
- High strength of taper neck, can cut deep grooves without breaking.

**EPCRT**



Order No.	Dia. (d)	Corner Radius (R)	$\theta^\circ$	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EPCRT20100120HU	1.0	0.10R	0.5°	2.0	20	60	6	2
EPCRT201001201U	1.0	0.10R	1.0°	2.0	20	60	6	2
EPCRT20100120AU	1.0	0.10R	1.5°	2.0	20	60	6	2
EPCRT201201230HU2C	1.2	0.12R	0.5°	2.0	30	75	6	2
EPCRT2012012301U2C	1.2	0.12R	1.0°	2.0	30	75	6	2
EPCRT201201230AU2C	1.2	0.12R	1.5°	2.0	30	75	6	2
EPCRT201501530HU2C	1.5	0.15R	0.5°	2.0	30	75	6	2
EPCRT2015015301U2C	1.5	0.15R	1.0°	2.0	30	75	6	2
EPCRT201501530AU2C	1.5	0.15R	1.5°	2.0	30	75	6	2
EPCRT201801830HU2C	1.8	0.18R	0.5°	2.0	30	75	6	2
EPCRT2018018301U2C	1.8	0.18R	1.0°	2.0	30	75	6	2
EPCRT201801830AU2C	1.8	0.18R	1.5°	2.0	30	75	6	2
EPCRT20200225AU	2.0	0.20R	1.5°	3.0	25	75	6	2
EPCRT20200239AU	2.0	0.20R	1.5°	3.0	39	75	6	2
EPCRT20200525AU	2.0	0.50R	1.5°	3.0	25	75	6	2
EPCRT20200539AU	2.0	0.50R	1.5°	3.0	39	75	6	2
EPCRT20200550AU	2.0	0.50R	1.5°	3.0	50	100	6	2
EPCRT20200535HU4C	2.0	0.50R	0.5°	4.0	35	75	6	2
EPCRT202005351U4C	2.0	0.50R	1.0°	4.0	35	75	6	2
EPCRT20200535AU4C	2.0	0.50R	1.5°	4.0	35	75	6	2
EPCRT20250535HU5C	2.5	0.50R	0.5°	5.0	35	75	6	2
EPCRT202505351U5C	2.5	0.50R	1.0°	5.0	35	75	6	2
EPCRT20250535AU5C	2.5	0.50R	1.5°	5.0	35	75	6	2
EPCRT20251035HU5C	2.5	1.00R	0.5°	5.0	35	75	6	2
EPCRT202510351U5C	2.5	1.00R	1.0°	5.0	35	75	6	2
EPCRT20251035AU5C	2.5	1.00R	1.5°	5.0	35	75	6	2

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

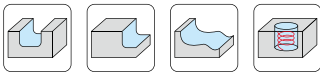
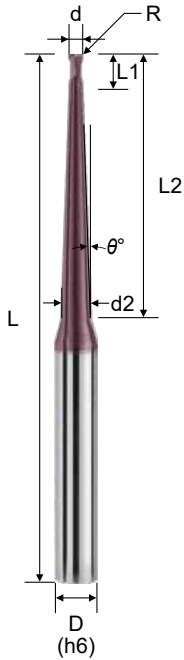
R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020



G550 - Taper Neck · Corner Radius · 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.
- Various taper angle makes it suitable for different applications.
- Small corner radius applied protect chipping of cutting edges.
- High strength of taper neck, can cut deep grooves without breaking.

EPCRT



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

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

Order No.	Dia. (d)	Corner Radius (R)	θ°	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EPCRT20300525AU	3.0	0.50R	1.5°	4.5	25	75	6	2
EPCRT20301025AU	3.0	1.00R	1.5°	4.5	25	75	6	2
EPCRT20301039AU	3.0	1.00R	1.5°	4.5	39	75	6	2
EPCRT20301050AU	3.0	1.00R	1.5°	4.5	50	100	6	2
EPCRT20300535HU5C	3.0	0.50R	0.5°	5.0	35	75	6	2
EPCRT203005351U5C	3.0	0.50R	1.0°	5.0	35	75	6	2
EPCRT20300535AU5C	3.0	0.50R	1.5°	5.0	35	75	6	2
EPCRT20301035HU5C	3.0	1.00R	0.5°	5.0	35	75	6	2
EPCRT203010351U5C	3.0	1.00R	1.0°	5.0	35	75	6	2
EPCRT20301035AU5C	3.0	1.00R	1.5°	5.0	35	75	6	2
EPCRT20350535HU	3.5	0.50R	0.5°	5.0	35	75	6	2
EPCRT203505351U	3.5	0.50R	1.0°	5.0	35	75	6	2
EPCRT20350535AU	3.5	0.50R	1.5°	5.0	35	75	6	2
EPCRT20351035HU	3.5	1.00R	0.5°	5.0	35	75	6	2
EPCRT203510351U	3.5	1.00R	1.0°	5.0	35	75	6	2
EPCRT20351035AU	3.5	1.00R	1.5°	5.0	35	75	6	2
EPCRT20400545HU	4.0	0.50R	0.5°	6.0	45	100	6	2
EPCRT204005451U	4.0	0.50R	1.0°	6.0	45	100	6	2
EPCRT20400525AU	4.0	0.50R	1.5°	6.0	25	75	6	2
EPCRT20400545AU	4.0	0.50R	1.5°	6.0	45	100	6	2
EPCRT20401045HU	4.0	1.00R	0.5°	6.0	45	100	6	2
EPCRT204010451U	4.0	1.00R	1.0°	6.0	45	100	6	2
EPCRT20401025AU	4.0	1.00R	1.5°	6.0	25	75	6	2
EPCRT20401045AU	4.0	1.00R	1.5°	6.0	45	100	6	2
EPCRT20501025AU	5.0	1.00R	1.5°	7.5	25	75	6	2
EPCRT20501050AU	5.0	1.00R	1.5°	7.5	50	100	8	2
EPCRT20601035AU	6.0	1.00R	1.5°	9.0	35	75	8	2
EPCRT20601050AU	6.0	1.00R	1.5°	9.0	50	100	10	2

Milling

Solid Carbide Endmills

G550 - Inner Radius · 2F / 4F

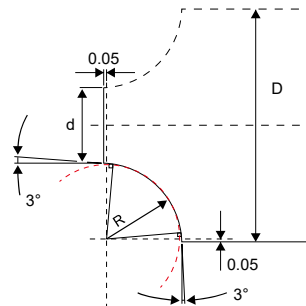
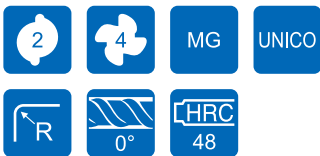
- UNICO Coating provides superior wear resistance and reduces the coefficient of friction.
- Suitable for HRC 30 to HRC 55 Ordinary Steel, Alloy Steel, Cast Iron, Heat-Resistant Steel, etc.
- Inner radius tools are suitable for chamfering with round corner application.

EPISA



Order No.	Corner Radius (R)	Dia. (d)	OAL (L)	Shank (D)	Flutes (F)
* EPISA242905U	0.5R	2.9	50	4	2
EPISA204905U	0.5R	4.9	50	6	2
* EPISA241910U	1.0R	1.9	50	4	2
EPISA203910U	1.0R	3.9	50	6	2
EPISA205910U	1.0R	5.9	60	8	2
EPISA204915U	1.5R	4.9	60	8	2
EPISA205920U	2.0R	5.9	75	10	2
EPISA204925U	2.5R	4.9	75	10	2
EPISA205930U	3.0R	5.9	75	12	2
EPISA203940U	4.0R	3.9	75	12	2
EPISA205950U	5.0R	5.9	75	16	2
EPISA203960U	6.0R	3.9	75	16	2
* EPISA442905U	0.5R	2.9	50	4	4
EPISA404905U	0.5R	4.9	50	6	4
* EPISA441910U	1.0R	1.9	50	4	4
EPISA403910U	1.0R	3.9	50	6	4
EPISA405910U	1.0R	5.9	60	8	4
EPISA404915U	1.5R	4.9	60	8	4
EPISA405920U	2.0R	5.9	75	10	4
EPISA404925U	2.5R	4.9	75	10	4
EPISA405930U	3.0R	5.9	75	12	4
EPISA403940U	4.0R	3.9	75	12	4
EPISA405950U	5.0R	5.9	75	16	4
EPISA403960U	6.0R	3.9	75	16	4

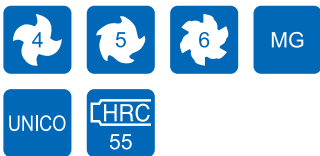
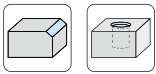
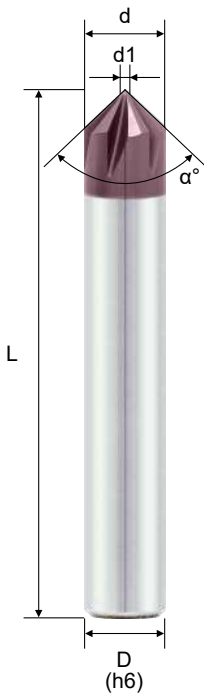
Cutting conditions : Table 046



**G550 - Chamfering Type Endmill · 4F / 5F / 6F**

- Designed for chamfer milling.
- Chamfering angle can be divided into 30° or 45°.
- UNICO Coating provides superior wear resistance and reduces the coefficient of friction.
- Suitable for Steel, Alloy steel, Stainless steel, Cast iron, & Hardened steel.

**EPFSA**



Order No.	Dia. (d)	(d1)	OAL (L)	Shank (D)	$\alpha^\circ$	Flutes (F)
* EPFSA444060U	4	0.5	50	4	60°	4
EPFSA406060U	6	1.0	60	6	60°	4
EPFSA508060U	8	1.5	60	8	60°	5
EPFSA610060U	10	1.5	75	10	60°	6
EPFSA612060U	12	2.0	75	12	60°	6
* EPFSA444090U	4	0.5	50	4	90°	4
EPFSA406090U	6	1.0	60	6	90°	4
EPFSA508090U	8	1.5	60	8	90°	5
EPFSA610090U	10	1.5	75	10	90°	6
EPFSA612090U	12	2.0	75	12	90°	6

※ Use uncoating tools for **N** material machining.

Cutting conditions : Table 047

G550 - Drill Mills · 2F

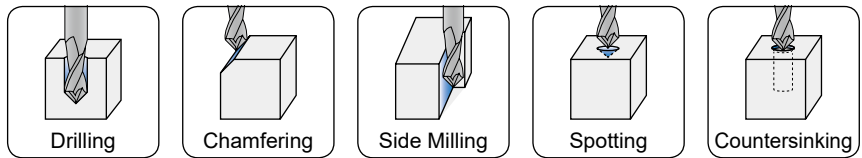
- Designed for chamfer milling.
- Chamfering angle can be divided into 30° or 45°.
- UNICO Coating provides superior wear resistance and reduces the coefficient of friction.
- Suitable for Steel, Alloy steel, Stainless steel, Cast iron, & Hardened steel.

EPFSC



Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	$\alpha^\circ$	Flutes (F)
EPFSC203060U	3	6	50	6	60°	2
EPFSC204060U	4	8	50	6	60°	2
EPFSC205060U	5	10	50	6	60°	2
EPFSC206060U	6	12	50	6	60°	2
EPFSC208060U	8	16	60	8	60°	2
EPFSC210060U	10	20	75	10	60°	2
EPFSC212060U	12	24	75	12	60°	2
EPFSC203090U	3	6	50	6	90°	2
EPFSC204090U	4	8	50	6	90°	2
EPFSC205090U	5	10	50	6	90°	2
EPFSC206090U	6	12	50	6	90°	2
EPFSC208090U	8	16	60	8	90°	2
EPFSC210090U	10	20	75	10	90°	2
EPFSC212090U	12	24	75	12	90°	2
EPFSC203012U	3	6	50	6	120°	2
EPFSC204012U	4	8	50	6	120°	2
EPFSC205012U	5	10	50	6	120°	2
EPFSC206012U	6	12	50	6	120°	2
EPFSC208012U	8	16	60	8	120°	2
EPFSC210012U	10	20	75	10	120°	2
EPFSC212012U	12	24	75	12	120°	2

Cutting conditions : Table 048

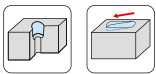
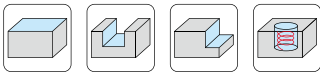
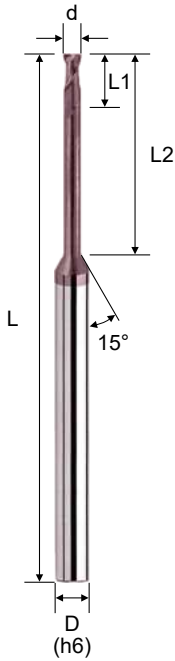


Tolerance	
$\varnothing d \leq 6$	0 ~ -0.02
$6 < \varnothing d \leq 12$	0 ~ -0.03
$\varnothing d > 12$	0 ~ -0.04

G550 - Long Neck · 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.
- Toughness and reduction of vibration.
- Available in various cut lengths.
- Suitable for deep cutting application.

EPSRC



Order No.	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
* EPSRC240201U	0.2	0.3	1	50	4	2
* EPSRC240202U	0.2	0.3	2	50	4	2
* EPSRC240301U	0.3	0.4	1	50	4	2
* EPSRC240302U	0.3	0.4	2	50	4	2
* EPSRC240303U	0.3	0.4	3	50	4	2
* EPSRC240304U	0.3	0.4	4	50	4	2
* EPSRC240305U	0.3	0.4	5	50	4	2
* EPSRC240401U	0.4	0.5	1	50	4	2
* EPSRC240402U	0.4	0.5	2	50	4	2
* EPSRC240403U	0.4	0.5	3	50	4	2
* EPSRC240404U	0.4	0.5	4	50	4	2
* EPSRC240405U	0.4	0.5	5	50	4	2
* EPSRC240406U	0.4	0.5	6	50	4	2
* EPSRC240408U	0.4	0.5	8	50	4	2
* EPSRC240410U	0.4	0.5	10	50	4	2
* EPSRC240502U	0.5	0.6	2	50	4	2
* EPSRC240503U	0.5	0.6	3	50	4	2
* EPSRC240504U	0.5	0.6	4	50	4	2
* EPSRC240505U	0.5	0.6	5	50	4	2
* EPSRC240506U	0.5	0.6	6	50	4	2
* EPSRC240508U	0.5	0.6	8	50	4	2
* EPSRC240510U	0.5	0.6	10	50	4	2
* EPSRC240512U	0.5	0.6	12	50	4	2
* EPSRC240514U	0.5	0.6	14	50	4	2

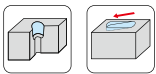
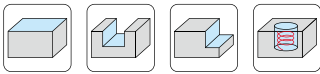
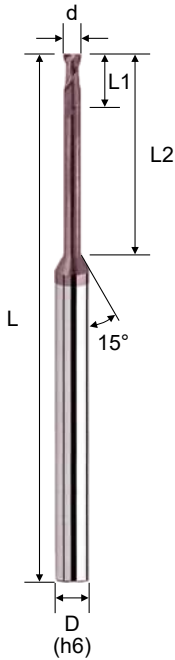
Cutting conditions : Table 049 ~ 051

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

G550 - Long Neck · 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.
- Toughness and reduction of vibration.
- Available in various cut lengths.
- Suitable for deep cutting application.

EPSRC



Order No.	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
* EPSRC240602U	0.6	0.7	2	50	4	2
* EPSRC240603U	0.6	0.7	3	50	4	2
* EPSRC240604U	0.6	0.7	4	50	4	2
* EPSRC240605U	0.6	0.7	5	50	4	2
* EPSRC240606U	0.6	0.7	6	50	4	2
* EPSRC240608U	0.6	0.7	8	50	4	2
* EPSRC240610U	0.6	0.7	10	50	4	2
* EPSRC240612U	0.6	0.7	12	50	4	2
* EPSRC240614U	0.6	0.7	14	50	4	2
* EPSRC240616U	0.6	0.7	16	50	4	2
* EPSRC240702U	0.7	0.8	2	50	4	2
* EPSRC240704U	0.7	0.8	4	50	4	2
* EPSRC240706U	0.7	0.8	6	50	4	2
* EPSRC240708U	0.7	0.8	8	50	4	2
* EPSRC240710U	0.7	0.8	10	50	4	2
* EPSRC240712U	0.7	0.8	12	50	4	2
* EPSRC240802U	0.8	1.0	2	50	4	2
* EPSRC240804U	0.8	1.0	4	50	4	2
* EPSRC240806U	0.8	1.0	6	50	4	2
* EPSRC240808U	0.8	1.0	8	50	4	2
* EPSRC240810U	0.8	1.0	10	50	4	2
* EPSRC240812U	0.8	1.0	12	50	4	2
* EPSRC240814U	0.8	1.0	14	50	4	2
* EPSRC240906U	0.9	1.1	6	50	4	2
* EPSRC240908U	0.9	1.1	8	50	4	2
* EPSRC240910U	0.9	1.1	10	50	4	2

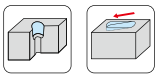
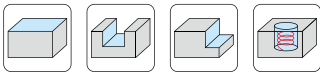
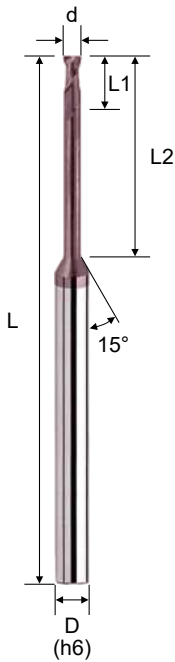
Cutting conditions : Table 049 ~ 051

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

G550 - Long Neck · 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.
- Toughness and reduction of vibration.
- Available in various cut lengths.
- Suitable for deep cutting application.

EPSRC



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

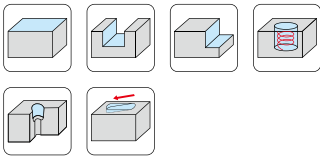
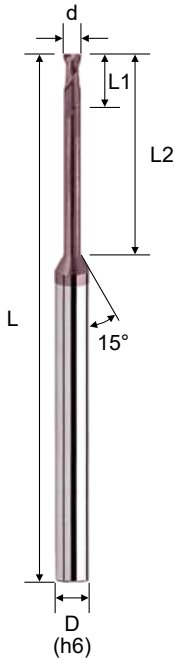
Order No.	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
* EPSRC241002U	1.0	1.2	2	50	4	2
* EPSRC241003U	1.0	1.2	3	50	4	2
* EPSRC241004U	1.0	1.2	4	50	4	2
* EPSRC241005U	1.0	1.2	5	50	4	2
* EPSRC241006U	1.0	1.2	6	50	4	2
* EPSRC241008U	1.0	1.2	8	50	4	2
* EPSRC241010U	1.0	1.2	10	50	4	2
* EPSRC241012U	1.0	1.2	12	50	4	2
* EPSRC241014U	1.0	1.2	14	50	4	2
* EPSRC241016U	1.0	1.2	16	50	4	2
* EPSRC241018U	1.0	1.2	18	50	4	2
* EPSRC241020U	1.0	1.2	20	50	4	2
* EPSRC241204U	1.2	1.5	4	50	4	2
* EPSRC241206U	1.2	1.5	6	50	4	2
* EPSRC241208U	1.2	1.5	8	50	4	2
* EPSRC241210U	1.2	1.5	10	50	4	2
* EPSRC241212U	1.2	1.5	12	50	4	2
* EPSRC241216U	1.2	1.5	16	50	4	2
* EPSRC241220U	1.2	1.5	20	50	4	2
* EPSRC241406U	1.4	1.8	6	50	4	2
* EPSRC241408U	1.4	1.8	8	50	4	2
* EPSRC241410U	1.4	1.8	10	50	4	2
* EPSRC241414U	1.4	1.8	14	50	4	2
* EPSRC241416U	1.4	1.8	16	50	4	2
* EPSRC241420U	1.4	1.8	20	50	4	2

Cutting conditions : Table 049 ~ 051

**G550 - Long Neck · 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.
- Toughness and reduction of vibration.
- Available in various cut lengths.
- Suitable for deep cutting application.

**EPSRC**



Order No.	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
* EPSRC241504U	1.5	1.8	4	50	4	2
* EPSRC241506U	1.5	1.8	6	50	4	2
* EPSRC241508U	1.5	1.8	8	50	4	2
* EPSRC241510U	1.5	1.8	10	50	4	2
* EPSRC241512U	1.5	1.8	12	50	4	2
* EPSRC241514U	1.5	1.8	14	50	4	2
* EPSRC241516U	1.5	1.8	16	50	4	2
* EPSRC241518U	1.5	1.8	18	50	4	2
* EPSRC241520U	1.5	1.8	20	50	4	2
* EPSRC241610U	1.6	1.9	10	50	4	2
* EPSRC241614U	1.6	1.9	14	50	4	2
* EPSRC241618U	1.6	1.9	18	50	4	2
* EPSRC241810U	1.8	2.0	10	50	4	2
* EPSRC241814U	1.8	2.0	14	50	4	2
* EPSRC241818U	1.8	2.0	18	50	4	2
* EPSRC242004U	2.0	2.5	4	50	4	2
* EPSRC242006U	2.0	2.5	6	50	4	2
* EPSRC242008U	2.0	2.5	8	50	4	2
* EPSRC242010U	2.0	2.5	10	50	4	2
* EPSRC242012U	2.0	2.5	12	50	4	2
* EPSRC242014U	2.0	2.5	14	50	4	2
* EPSRC242016U	2.0	2.5	16	50	4	2
* EPSRC242018U	2.0	2.5	18	50	4	2
* EPSRC242020U	2.0	2.5	20	50	4	2
* EPSRC242022U	2.0	2.5	22	60	4	2
* EPSRC242025U	2.0	2.5	25	60	4	2
* EPSRC242030U	2.0	2.5	30	75	4	2
* EPSRC242035U	2.0	2.5	35	75	4	2

Cutting conditions : Table 049 ~ 051

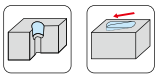
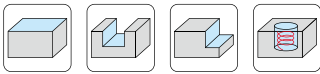
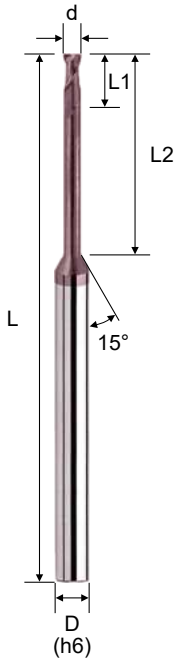
d Tolerance	
d ≤ 6	0 ~ -0.02
6 < d ≤ 12	0 ~ -0.03
d > 12	0 ~ -0.04



G550 - Long Neck · 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.
- Toughness and reduction of vibration.
- Available in various cut lengths.
- Suitable for deep cutting application.

EPSRC



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

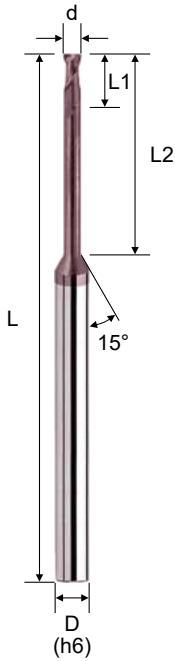
Order No.	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
* EPSRC242508U	2.5	3.0	8	50	4	2
* EPSRC242510U	2.5	3.0	10	50	4	2
* EPSRC242512U	2.5	3.0	12	50	4	2
* EPSRC242516U	2.5	3.0	16	50	4	2
* EPSRC242520U	2.5	3.0	20	50	4	2
* EPSRC242525U	2.5	3.0	25	60	4	2
* EPSRC242530U	2.5	3.0	30	75	4	2
* EPSRC242535U	2.5	3.0	35	75	4	2
EPSRC203006U	3.0	3.5	6	50	6	2
EPSRC203010U	3.0	3.5	10	50	6	2
EPSRC203012U	3.0	3.5	12	50	6	2
EPSRC203016U	3.0	3.5	16	50	6	2
EPSRC203020U	3.0	3.5	20	60	6	2
EPSRC203025U	3.0	3.5	25	60	6	2
EPSRC203030U	3.0	3.5	30	75	6	2
EPSRC203035U	3.0	3.5	35	75	6	2
EPSRC204008U	4.0	4.5	8	50	6	2
EPSRC204010U	4.0	4.5	10	50	6	2
EPSRC204012U	4.0	4.5	12	50	6	2
EPSRC204016U	4.0	4.5	16	50	6	2
EPSRC204020U	4.0	4.5	20	60	6	2
EPSRC204025U	4.0	4.5	25	60	6	2
EPSRC204030U	4.0	4.5	30	75	6	2
EPSRC204035U	4.0	4.5	35	75	6	2

Cutting conditions : Table 049 ~ 051

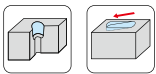
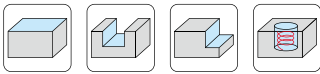
G550 - Long Neck · Square · 2F

- 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.
- Toughness and reduction of vibration.
- Available in various cut lengths.
- Suitable for deep cutting application.

EPSRC



Order No.	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EPSRC205016U	5.0	7.0	16	50	6	2
EPSRC205020U	5.0	7.0	20	60	6	2
EPSRC205025U	5.0	7.0	25	60	6	2
EPSRC205030U	5.0	7.0	30	75	6	2
EPSRC205035U	5.0	7.0	35	75	6	2
EPSRC206020U	6.0	10.0	20	60	6	2
EPSRC206030U	6.0	10.0	30	75	6	2
EPSRC208020U	8.0	15.0	20	60	8	2
EPSRC208030U	8.0	15.0	30	75	8	2
EPSRC208040U	8.0	15.0	40	100	8	2
EPSRC210025U	10.0	20.0	25	75	10	2
EPSRC210035U	10.0	20.0	35	75	10	2
EPSRC210045U	10.0	20.0	45	100	10	2
EPSRC212030U	12.0	25.0	30	75	12	2
EPSRC212040U	12.0	25.0	40	100	12	2
EPSRC212050U	12.0	25.0	50	100	12	2



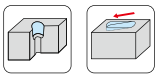
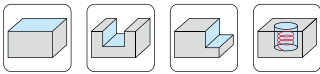
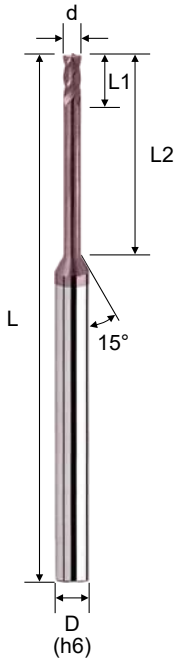
Cutting conditions : Table 049 ~ 051

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

G550 - Long Neck · Square · 4F

- 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, Copper, FRP, etc.
- Toughness and reduction of vibration.
- Available in various cut lengths.
- Suitable for deep cutting application.

EPSRC



Order No.	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
* EPSRC441003U	1.0	1.0	3	50	4	4
* EPSRC441004U	1.0	1.0	4	50	4	4
* EPSRC441006U	1.0	1.0	6	50	4	4
* EPSRC441008U	1.0	1.0	8	50	4	4
* EPSRC441010U	1.0	1.0	10	50	4	4
* EPSRC441012U	1.0	1.0	12	50	4	4
* EPSRC441016U	1.0	1.0	16	50	4	4
* EPSRC441020U	1.0	1.0	20	50	4	4
* EPSRC441025U	1.0	1.0	25	60	4	4
EPSRC401004U	1.0	1.0	4	50	6	4
EPSRC401006U	1.0	1.0	6	50	6	4
EPSRC401008U	1.0	1.0	8	50	6	4
EPSRC401010U	1.0	1.0	10	50	6	4
EPSRC401012U	1.0	1.0	12	50	6	4
EPSRC441506U	1.5	1.5	6	50	4	4
EPSRC441508U	1.5	1.5	8	50	4	4
EPSRC441510U	1.5	1.5	10	50	4	4
EPSRC441512U	1.5	1.5	12	50	4	4
EPSRC441516U	1.5	1.5	16	50	4	4
EPSRC441520U	1.5	1.5	20	50	4	4
EPSRC441525U	1.5	1.5	25	60	4	4
EPSRC401506U	1.5	1.5	6	50	6	4
EPSRC401508U	1.5	1.5	8	50	6	4
EPSRC401510U	1.5	1.5	10	50	6	4
EPSRC401512U	1.5	1.5	12	50	6	4

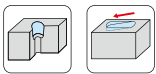
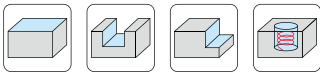
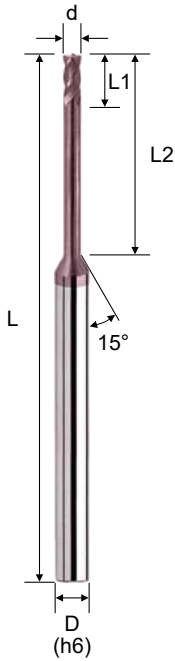
Cutting conditions : Table 052 ~ 053

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

**G550 - Long Neck · Square · 4F**

- 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, Copper, FRP, etc.
- Toughness and reduction of vibration.
- Available in various cut lengths.
- Suitable for deep cutting application.

**EPSRC**



Order No.	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
* EPSRC442006U	2.0	2.0	6	50	4	4
* EPSRC442008U	2.0	2.0	8	50	4	4
* EPSRC442010U	2.0	2.0	10	50	4	4
* EPSRC442012U	2.0	2.0	12	50	4	4
* EPSRC442016U	2.0	2.0	16	50	4	4
* EPSRC442020U	2.0	2.0	20	50	4	4
* EPSRC442025U	2.0	2.0	25	60	4	4
* EPSRC442030U	2.0	2.0	30	75	4	4
EPSRC402006U	2.0	2.0	6	50	6	4
EPSRC402008U	2.0	2.0	8	50	6	4
EPSRC402010U	2.0	2.0	10	50	6	4
EPSRC402016U	2.0	2.0	16	50	6	4
* EPSRC442510U	2.5	2.5	10	50	4	4
* EPSRC442512U	2.5	2.5	12	50	4	4
* EPSRC442516U	2.5	2.5	16	50	4	4
* EPSRC442520U	2.5	2.5	20	50	4	4
* EPSRC442525U	2.5	2.5	25	60	4	4
* EPSRC442530U	2.5	2.5	30	75	4	4
EPSRC402506U	2.5	2.5	6	50	6	4
EPSRC402510U	2.5	2.5	10	50	6	4
EPSRC403010U	3.0	3.0	10	50	6	4
EPSRC403012U	3.0	3.0	12	50	6	4
EPSRC403016U	3.0	3.0	16	50	6	4
EPSRC403020U	3.0	3.0	20	60	6	4
EPSRC403025U	3.0	3.0	25	60	6	4
EPSRC403030U	3.0	3.0	30	75	6	4
EPSRC403035U	3.0	3.0	35	75	6	4

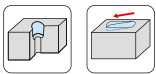
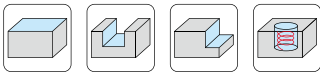
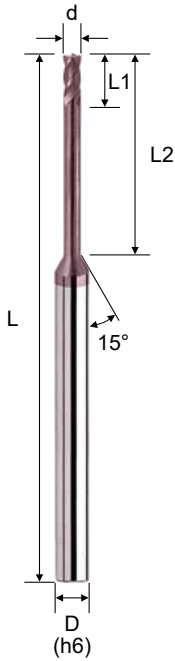
Cutting conditions : Table 052 ~ 053

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

G550 - Long Neck · Square · 4F

- 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, Copper, FRP, etc.
- Toughness and reduction of vibration.
- Available in various cut lengths.
- Suitable for deep cutting application.

EPSRC



Order No.	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EPSRC404010U	4.0	4.0	10	50	6	4
EPSRC404012U	4.0	4.0	12	50	6	4
EPSRC404016U	4.0	4.0	16	50	6	4
EPSRC404020U	4.0	4.0	20	60	6	4
EPSRC404025U	4.0	4.0	25	60	6	4
EPSRC404030U	4.0	4.0	30	75	6	4
EPSRC405016U	5.0	5.0	16	50	6	4
EPSRC405020U	5.0	5.0	20	60	6	4
EPSRC405025U	5.0	5.0	25	60	6	4
EPSRC405030U	5.0	5.0	30	75	6	4
EPSRC406020U	6.0	6.0	20	60	6	4
EPSRC406030U	6.0	6.0	30	75	6	4
EPSRC408020U	8.0	15.0	20	60	8	4
EPSRC408030U	8.0	15.0	30	75	8	4
EPSRC408040U	8.0	15.0	40	100	8	4
EPSRC410025U	10.0	20.0	25	75	10	4
EPSRC410035U	10.0	20.0	35	100	10	4
EPSRC410045U	10.0	20.0	45	100	10	4
EPSRC412030U	12.0	25.0	30	75	12	4
EPSRC412040U	12.0	25.0	40	100	12	4
EPSRC412050U	12.0	25.0	50	100	12	4

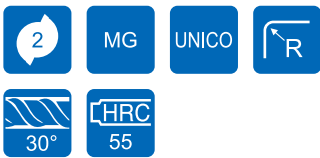
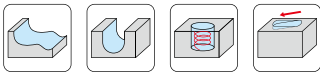
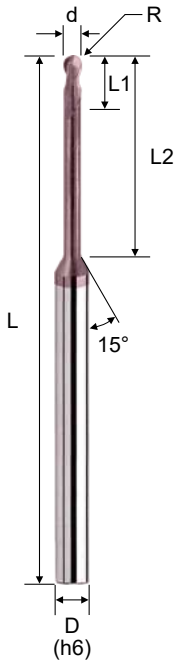
Cutting conditions : Table 052 ~ 053

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

**G550 - Long Neck · 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, Copper, FRP, etc.
- Reduce vibration and more toughness.
- It provides an excellent surface due to better surface grindings.
- Long neck design is suitable for rid cutting.

**EPBRC**



Order No.	Radius (R)	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
* EPBRC240301U	0.15R	0.3	0.3	1	50	4	2
* EPBRC240302U	0.15R	0.3	0.3	2	50	4	2
* EPBRC240303U	0.15R	0.3	0.3	3	50	4	2
* EPBRC240401U	0.20R	0.4	0.4	1	50	4	2
* EPBRC240402U	0.20R	0.4	0.4	2	50	4	2
* EPBRC240403U	0.20R	0.4	0.4	3	50	4	2
* EPBRC240404U	0.20R	0.4	0.4	4	50	4	2
* EPBRC240405U	0.20R	0.4	0.4	5	50	4	2
* EPBRC240406U	0.20R	0.4	0.4	6	50	4	2
* EPBRC240408U	0.20R	0.4	0.4	8	50	4	2
* EPBRC240501U	0.25R	0.5	0.5	1	50	4	2
* EPBRC240502U	0.25R	0.5	0.5	2	50	4	2
* EPBRC240503U	0.25R	0.5	0.5	3	50	4	2
* EPBRC240504U	0.25R	0.5	0.5	4	50	4	2
* EPBRC240505U	0.25R	0.5	0.5	5	50	4	2
* EPBRC240506U	0.25R	0.5	0.5	6	50	4	2
* EPBRC240508U	0.25R	0.5	0.5	8	50	4	2
* EPBRC240510U	0.25R	0.5	0.5	10	50	4	2
* EPBRC240601U	0.30R	0.6	0.6	1	50	4	2
* EPBRC240602U	0.30R	0.6	0.6	2	50	4	2
* EPBRC240603U	0.30R	0.6	0.6	3	50	4	2
* EPBRC240604U	0.30R	0.6	0.6	4	50	4	2
* EPBRC240605U	0.30R	0.6	0.6	5	50	4	2
* EPBRC240606U	0.30R	0.6	0.6	6	50	4	2
* EPBRC240608U	0.30R	0.6	0.6	8	50	4	2
* EPBRC240610U	0.30R	0.6	0.6	10	50	4	2
* EPBRC240612U	0.30R	0.6	0.6	12	50	4	2

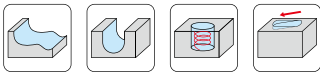
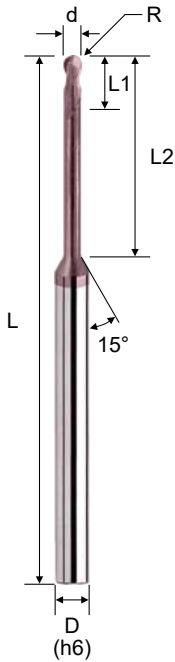
Cutting conditions : Table 054 ~ 056

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

**G550 - Long Neck · 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, Copper, FRP, etc.
- Reduce vibration and more toughness.
- It provides an excellent surface due to better surface grindings.
- Long neck design is suitable for rid cutting.

**EPBRC**



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

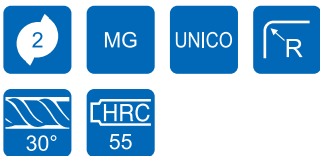
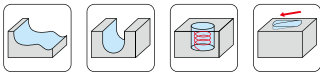
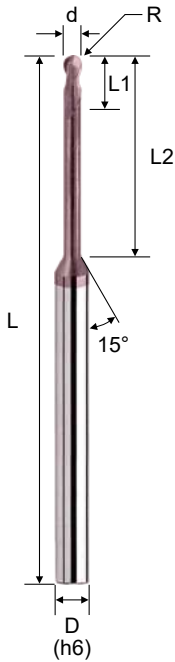
Order No.	Radius (R)	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
* EPBRC240702U	0.35R	0.7	0.7	2	50	4	2
* EPBRC240704U	0.35R	0.7	0.7	4	50	4	2
* EPBRC240708U	0.35R	0.7	0.7	8	50	4	2
* EPBRC240710U	0.35R	0.7	0.7	10	50	4	2
* EPBRC240712U	0.35R	0.7	0.7	12	50	4	2
* EPBRC240802U	0.40R	0.8	0.8	2	50	4	2
* EPBRC240804U	0.40R	0.8	0.8	4	50	4	2
* EPBRC240806U	0.40R	0.8	0.8	6	50	4	2
* EPBRC240808U	0.40R	0.8	0.8	8	50	4	2
* EPBRC240810U	0.40R	0.8	0.8	10	50	4	2
* EPBRC240812U	0.40R	0.8	0.8	12	50	4	2
* EPBRC240904U	0.45R	0.9	0.9	4	50	4	2
* EPBRC241002U	0.50R	1.0	1.0	2	50	4	2
* EPBRC241003U	0.50R	1.0	1.0	3	50	4	2
* EPBRC241004U	0.50R	1.0	1.0	4	50	4	2
* EPBRC241005U	0.50R	1.0	1.0	5	50	4	2
* EPBRC241006U	0.50R	1.0	1.0	6	50	4	2
* EPBRC241008U	0.50R	1.0	1.0	8	50	4	2
* EPBRC241010U	0.50R	1.0	1.0	10	50	4	2
* EPBRC241012U	0.50R	1.0	1.0	12	50	4	2
* EPBRC241014U	0.50R	1.0	1.0	14	50	4	2
* EPBRC241016U	0.50R	1.0	1.0	16	50	4	2
* EPBRC241018U	0.50R	1.0	1.0	18	50	4	2
* EPBRC241020U	0.50R	1.0	1.0	20	50	4	2
* EPBRC241022U	0.50R	1.0	1.0	22	60	4	2
EPBRC201004U	0.50R	1.0	1.0	4	50	6	2
EPBRC201006U	0.50R	1.0	1.0	6	50	6	2
EPBRC201008U	0.50R	1.0	1.0	8	50	6	2
EPBRC201010U	0.50R	1.0	1.0	10	50	6	2
EPBRC201012U	0.50R	1.0	1.0	12	50	6	2

Cutting conditions : Table 054 ~ 056

**G550 - Long Neck · 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, Copper, FRP, etc.
- Reduce vibration and more toughness.
- It provides an excellent surface due to better surface grindings.
- Long neck design is suitable for rid cutting.

**EPBRC**



Order No.	Radius (R)	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
* EPBRC241204U	0.60R	1.2	1.2	4	50	4	2
* EPBRC241206U	0.60R	1.2	1.2	6	50	4	2
* EPBRC241208U	0.60R	1.2	1.2	8	50	4	2
* EPBRC241210U	0.60R	1.2	1.2	10	50	4	2
* EPBRC241212U	0.60R	1.2	1.2	12	50	4	2
* EPBRC241216U	0.60R	1.2	1.2	16	50	4	2
* EPBRC241220U	0.60R	1.2	1.2	20	50	4	2
* EPBRC241224U	0.60R	1.2	1.2	24	60	4	2
* EPBRC241406U	0.70R	1.4	1.4	6	50	4	2
* EPBRC241408U	0.70R	1.4	1.4	8	50	4	2
* EPBRC241412U	0.70R	1.4	1.4	12	50	4	2
* EPBRC241416U	0.70R	1.4	1.4	16	50	4	2
* EPBRC241503U	0.75R	1.5	1.5	3	50	4	2
* EPBRC241504U	0.75R	1.5	1.5	4	50	4	2
* EPBRC241506U	0.75R	1.5	1.5	6	50	4	2
* EPBRC241508U	0.75R	1.5	1.5	8	50	4	2
* EPBRC241510U	0.75R	1.5	1.5	10	50	4	2
* EPBRC241512U	0.75R	1.5	1.5	12	50	4	2
* EPBRC241514U	0.75R	1.5	1.5	14	50	4	2
* EPBRC241516U	0.75R	1.5	1.5	16	50	4	2
* EPBRC241518U	0.75R	1.5	1.5	18	50	4	2
* EPBRC241520U	0.75R	1.5	1.5	20	50	4	2
* EPBRC241522U	0.75R	1.5	1.5	22	60	4	2
* EPBRC241525U	0.75R	1.5	1.5	25	60	4	2
* EPBRC241530U	0.75R	1.5	1.5	30	75	4	2
EPBRC201506U	0.75R	1.5	1.5	6	50	6	2
EPBRC201508U	0.75R	1.5	1.5	8	50	6	2
EPBRC201510U	0.75R	1.5	1.5	10	50	6	2
EPBRC201512U	0.75R	1.5	1.5	12	50	6	2

Cutting conditions : Table 054 ~ 056

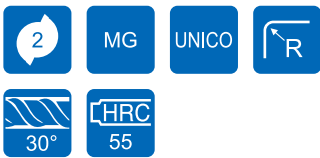
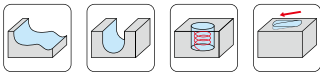
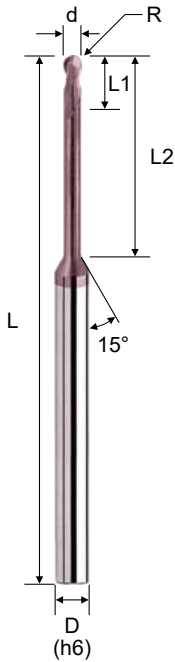
R Tolerance	
R ≤ 3	±0.015
R > 3	±0.020



**G550 - Long Neck · 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, Copper, FRP, etc.
- Reduce vibration and more toughness.
- It provides an excellent surface due to better surface grindings.
- Long neck design is suitable for rid cutting.

**EPBRC**



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

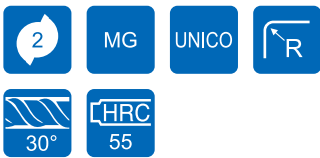
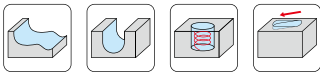
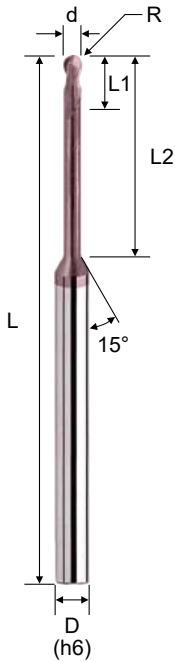
Order No.	Radius (R)	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
* EPBRC241606U	0.80R	1.6	1.6	6	50	4	2
* EPBRC241608U	0.80R	1.6	1.6	8	50	4	2
* EPBRC241612U	0.80R	1.6	1.6	12	50	4	2
* EPBRC241616U	0.80R	1.6	1.6	16	50	4	2
* EPBRC241620U	0.80R	1.6	1.6	20	50	4	2
* EPBRC241806U	0.90R	1.8	1.8	6	50	4	2
* EPBRC241808U	0.90R	1.8	1.8	8	50	4	2
* EPBRC241812U	0.90R	1.8	1.8	12	50	4	2
* EPBRC241816U	0.90R	1.8	1.8	16	50	4	2
* EPBRC241820U	0.90R	1.8	1.8	20	50	4	2
* EPBRC242004U	1.00R	2.0	2.0	4	50	4	2
* EPBRC242006U	1.00R	2.0	2.0	6	50	4	2
* EPBRC242008U	1.00R	2.0	2.0	8	50	4	2
* EPBRC242010U	1.00R	2.0	2.0	10	50	4	2
* EPBRC242012U	1.00R	2.0	2.0	12	50	4	2
* EPBRC242014U	1.00R	2.0	2.0	14	50	4	2
* EPBRC242016U	1.00R	2.0	2.0	16	50	4	2
* EPBRC242018U	1.00R	2.0	2.0	18	50	4	2
* EPBRC242020U	1.00R	2.0	2.0	20	50	4	2
* EPBRC242022U	1.00R	2.0	2.0	22	60	4	2
* EPBRC242025U	1.00R	2.0	2.0	25	60	4	2
EPBRC202006U	1.00R	2.0	2.0	6	50	6	2
EPBRC202008U	1.00R	2.0	2.0	8	50	6	2
EPBRC202010U	1.00R	2.0	2.0	10	50	6	2
EPBRC202016U	1.00R	2.0	2.0	16	50	6	2

Cutting conditions : Table 054 ~ 056

**G550 - Long Neck · 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, Copper, FRP, etc.
- Reduce vibration and more toughness.
- It provides an excellent surface due to better surface grindings.
- Long neck design is suitable for rid cutting.

**EPBRC**



Order No.	Radius (R)	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
* EPBRC242508U	1.25R	2.5	2.5	8	50	4	2
* EPBRC242510U	1.25R	2.5	2.5	10	50	4	2
* EPBRC242516U	1.25R	2.5	2.5	16	50	4	2
* EPBRC242520U	1.25R	2.5	2.5	20	60	4	2
* EPBRC242525U	1.25R	2.5	2.5	25	60	4	2
* EPBRC242530U	1.25R	2.5	2.5	30	75	4	2
EPBRC202506U	1.25R	2.5	2.5	6	50	6	2
EPBRC202510U	1.25R	2.5	2.5	10	50	6	2
EPBRC203006U	1.50R	3.0	3.0	6	50	6	2
EPBRC203008U	1.50R	3.0	3.0	8	50	6	2
EPBRC203012U	1.50R	3.0	3.0	12	50	6	2
EPBRC203016U	1.50R	3.0	3.0	16	60	6	2
EPBRC203020U	1.50R	3.0	3.0	20	60	6	2
EPBRC203025U	1.50R	3.0	3.0	25	60	6	2
EPBRC203030U	1.50R	3.0	3.0	30	75	6	2
EPBRC203035U	1.50R	3.0	3.0	35	75	6	2
EPBRC204008U	2.00R	4.0	4.0	8	50	6	2
EPBRC204010U	2.00R	4.0	4.0	10	50	6	2
EPBRC204012U	2.00R	4.0	4.0	12	50	6	2
EPBRC204016U	2.00R	4.0	4.0	16	60	6	2
EPBRC204020U	2.00R	4.0	4.0	20	60	6	2
EPBRC204025U	2.00R	4.0	4.0	25	60	6	2
EPBRC204030U	2.00R	4.0	4.0	30	75	6	2
EPBRC204035U	2.00R	4.0	4.0	35	75	6	2
EPBRC205015U	2.50R	5.0	5.0	15	60	6	2
EPBRC205020U	2.50R	5.0	5.0	20	60	6	2
EPBRC205025U	2.50R	5.0	5.0	25	60	6	2
EPBRC205030U	2.50R	5.0	5.0	30	75	6	2
EPBRC206015U	3.00R	6.0	10.0	15	50	6	2
EPBRC208025U	4.00R	8.0	12.0	25	60	8	2
EPBRC210030U	5.00R	10.0	16.0	30	75	10	2
EPBRC212030U	6.00R	12.0	18.0	30	75	12	2

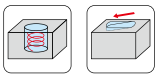
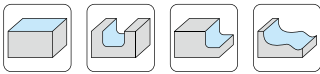
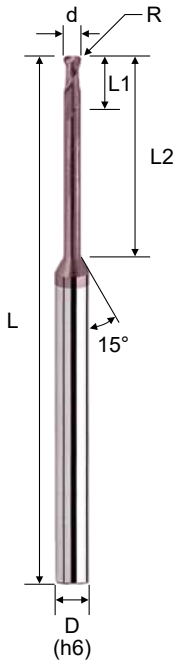
Cutting conditions : Table 054 ~ 056

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

**G550 - Long Neck · Corner Radius · 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.
- Available in various cut lengths.
- Corner radius with long neck are suitable for deep general cutting and 3D milling.

**EPCRC**



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
*EPCRC24100104U	1.0	0.1R	1.0	4	50	4	2
*EPCRC24100106U	1.0	0.1R	1.0	6	50	4	2
*EPCRC24100108U	1.0	0.1R	1.0	8	50	4	2
*EPCRC24100110U	1.0	0.1R	1.0	10	50	4	2
*EPCRC24100112U	1.0	0.1R	1.0	12	50	4	2
*EPCRC24100204U	1.0	0.2R	1.0	4	50	4	2
*EPCRC24100206U	1.0	0.2R	1.0	6	50	4	2
*EPCRC24100208U	1.0	0.2R	1.0	8	50	4	2
*EPCRC24100210U	1.0	0.2R	1.0	10	50	4	2
*EPCRC24100212U	1.0	0.2R	1.0	12	50	4	2
*EPCRC24100304U	1.0	0.3R	1.0	4	50	4	2
*EPCRC24100306U	1.0	0.3R	1.0	6	50	4	2
*EPCRC24100308U	1.0	0.3R	1.0	8	50	4	2
*EPCRC24100310U	1.0	0.3R	1.0	10	50	4	2
*EPCRC24100312U	1.0	0.3R	1.0	12	50	4	2
*EPCRC24120104U	1.2	0.1R	1.2	4	50	4	2
*EPCRC24120106U	1.2	0.1R	1.2	6	50	4	2
*EPCRC24120108U	1.2	0.1R	1.2	8	50	4	2
*EPCRC24120110U	1.2	0.1R	1.2	10	50	4	2
*EPCRC24120112U	1.2	0.1R	1.2	12	50	4	2
*EPCRC24120204U	1.2	0.2R	1.2	4	50	4	2
*EPCRC24120206U	1.2	0.2R	1.2	6	50	4	2
*EPCRC24120208U	1.2	0.2R	1.2	8	50	4	2
*EPCRC24120210U	1.2	0.2R	1.2	10	50	4	2
*EPCRC24120212U	1.2	0.2R	1.2	12	50	4	2
*EPCRC24120304U	1.2	0.3R	1.2	4	50	4	2
*EPCRC24120306U	1.2	0.3R	1.2	6	50	4	2
*EPCRC24120308U	1.2	0.3R	1.2	8	50	4	2
*EPCRC24120310U	1.2	0.3R	1.2	10	50	4	2
*EPCRC24120312U	1.2	0.3R	1.2	12	50	4	2

Cutting conditions : Table 057

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

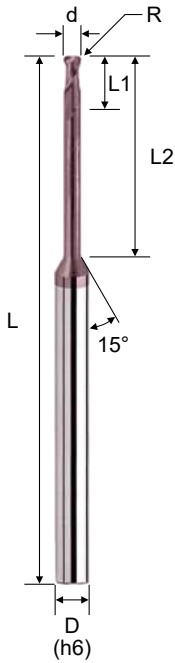
  

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

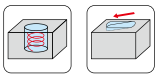
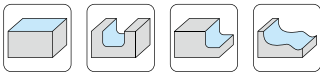
**G550 - Long Neck · Corner Radius · 2F**

- 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.
- Available in various cut lengths.
- Corner radius with long neck are suitable for deep general cutting and 3D milling.

**EPCRC**



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
*EPCRC24150106U	1.5	0.1R	1.5	6	50	4	2
*EPCRC24150108U	1.5	0.1R	1.5	8	50	4	2
*EPCRC24150110U	1.5	0.1R	1.5	10	50	4	2
*EPCRC24150112U	1.5	0.1R	1.5	12	50	4	2
*EPCRC24150116U	1.5	0.1R	1.5	16	50	4	2
*EPCRC24150206U	1.5	0.2R	1.5	6	50	4	2
*EPCRC24150208U	1.5	0.2R	1.5	8	50	4	2
*EPCRC24150210U	1.5	0.2R	1.5	10	50	4	2
*EPCRC24150212U	1.5	0.2R	1.5	12	50	4	2
*EPCRC24150216U	1.5	0.2R	1.5	16	50	4	2
*EPCRC24150306U	1.5	0.3R	1.5	6	50	4	2
*EPCRC24150308U	1.5	0.3R	1.5	8	50	4	2
*EPCRC24150310U	1.5	0.3R	1.5	10	50	4	2
*EPCRC24150312U	1.5	0.3R	1.5	12	50	4	2
*EPCRC24150316U	1.5	0.3R	1.5	16	50	4	2
*EPCRC24150506U	1.5	0.5R	1.5	6	50	4	2
*EPCRC24150508U	1.5	0.5R	1.5	8	50	4	2
*EPCRC24150510U	1.5	0.5R	1.5	10	50	4	2
*EPCRC24150512U	1.5	0.5R	1.5	12	50	4	2
*EPCRC24150516U	1.5	0.5R	1.5	16	50	4	2



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

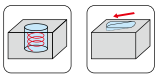
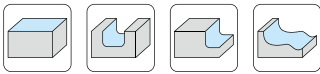
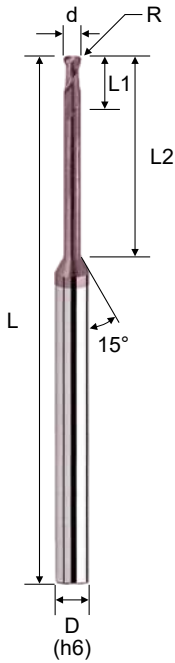
R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

Cutting conditions : Table 057

**G550 - Long Neck · Corner Radius · 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.
- Available in various cut lengths.
- Corner radius with long neck are suitable for deep general cutting and 3D milling.

**EPCRC**



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
*EPCRC24200106U	2.0	0.1R	2.0	6	50	4	2
*EPCRC24200108U	2.0	0.1R	2.0	8	50	4	2
*EPCRC24200110U	2.0	0.1R	2.0	10	50	4	2
*EPCRC24200112U	2.0	0.1R	2.0	12	50	4	2
*EPCRC24200116U	2.0	0.1R	2.0	16	50	4	2
*EPCRC24200120U	2.0	0.1R	2.0	20	50	4	2
*EPCRC24200125U	2.0	0.1R	2.0	25	60	4	2
*EPCRC24200206U	2.0	0.2R	2.0	6	50	4	2
*EPCRC24200208U	2.0	0.2R	2.0	8	50	4	2
*EPCRC24200210U	2.0	0.2R	2.0	10	50	4	2
*EPCRC24200212U	2.0	0.2R	2.0	12	50	4	2
*EPCRC24200216U	2.0	0.2R	2.0	16	50	4	2
*EPCRC24200220U	2.0	0.2R	2.0	20	50	4	2
*EPCRC24200225U	2.0	0.2R	2.0	25	60	4	2
*EPCRC24200306U	2.0	0.3R	2.0	6	50	4	2
*EPCRC24200308U	2.0	0.3R	2.0	8	50	4	2
*EPCRC24200310U	2.0	0.3R	2.0	10	50	4	2
*EPCRC24200312U	2.0	0.3R	2.0	12	50	4	2
*EPCRC24200316U	2.0	0.3R	2.0	16	50	4	2
*EPCRC24200320U	2.0	0.3R	2.0	20	50	4	2
*EPCRC24200325U	2.0	0.3R	2.0	25	60	4	2
*EPCRC24200506U	2.0	0.5R	2.0	6	50	4	2
*EPCRC24200508U	2.0	0.5R	2.0	8	50	4	2
*EPCRC24200510U	2.0	0.5R	2.0	10	50	4	2
*EPCRC24200512U	2.0	0.5R	2.0	12	50	4	2
*EPCRC24200516U	2.0	0.5R	2.0	16	50	4	2
*EPCRC24200520U	2.0	0.5R	2.0	20	50	4	2
*EPCRC24200525U	2.0	0.5R	2.0	25	60	4	2
EPCRC20200510U	2.0	0.5R	2.0	10	50	6	2
EPCRC20200515U	2.0	0.5R	2.0	15	50	6	2

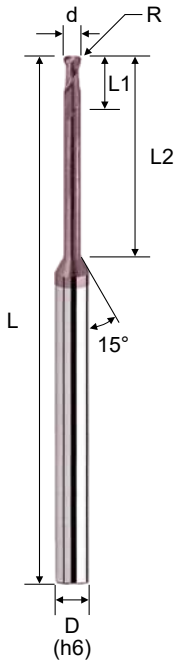
Cutting conditions : Table 057

d Tolerance	
d ≤ 6	0 ~ -0.02
6 < d ≤ 12	0 ~ -0.03
d > 12	0 ~ -0.04
R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

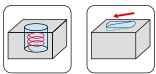
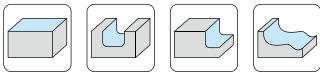
**G550 - Long Neck · Corner Radius · 2F**

- 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.
- Available in various cut lengths.
- Corner radius with long neck are suitable for deep general cutting and 3D milling.

**EPCRC**



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
*EPCRC24250110U	2.5	0.1R	2.5	10	50	4	2
*EPCRC24250116U	2.5	0.1R	2.5	16	50	4	2
*EPCRC24250120U	2.5	0.1R	2.5	20	50	4	2
*EPCRC24250125U	2.5	0.1R	2.5	25	60	4	2
*EPCRC24250210U	2.5	0.2R	2.5	10	50	4	2
*EPCRC24250216U	2.5	0.2R	2.5	16	50	4	2
*EPCRC24250220U	2.5	0.2R	2.5	20	50	4	2
*EPCRC24250225U	2.5	0.2R	2.5	25	60	4	2
*EPCRC24250310U	2.5	0.3R	2.5	10	50	4	2
*EPCRC24250316U	2.5	0.3R	2.5	16	50	4	2
*EPCRC24250320U	2.5	0.3R	2.5	20	50	4	2
*EPCRC24250325U	2.5	0.3R	2.5	25	60	4	2
*EPCRC24250510U	2.5	0.5R	2.5	10	50	4	2
*EPCRC24250516U	2.5	0.5R	2.5	16	50	4	2
*EPCRC24250520U	2.5	0.5R	2.5	20	50	4	2
*EPCRC24250525U	2.5	0.5R	2.5	25	60	4	2



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

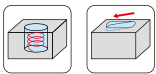
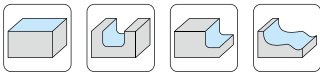
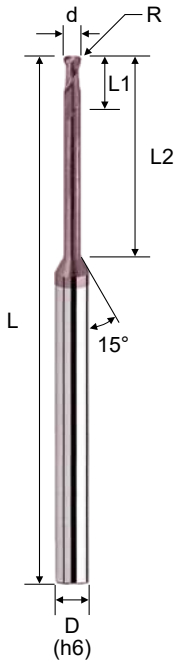
R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

Cutting conditions : Table 057

**G550 - Long Neck · Corner Radius · 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.
- Available in various cut lengths.
- Corner radius with long neck are suitable for deep general cutting and 3D milling.

**EPCRC**



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EPCRC20300110U	3.0	0.1R	3.0	10	50	6	2
EPCRC20300116U	3.0	0.1R	3.0	16	60	6	2
EPCRC20300120U	3.0	0.1R	3.0	20	60	6	2
EPCRC20300125U	3.0	0.1R	3.0	25	60	6	2
EPCRC20300130U	3.0	0.1R	3.0	30	75	6	2
EPCRC20300135U	3.0	0.1R	3.0	35	75	6	2
EPCRC20300210U	3.0	0.2R	3.0	10	50	6	2
EPCRC20300216U	3.0	0.2R	3.0	16	60	6	2
EPCRC20300220U	3.0	0.2R	3.0	20	60	6	2
EPCRC20300225U	3.0	0.2R	3.0	25	60	6	2
EPCRC20300230U	3.0	0.2R	3.0	30	75	6	2
EPCRC20300235U	3.0	0.2R	3.0	35	75	6	2
EPCRC20300310U	3.0	0.3R	3.0	10	50	6	2
EPCRC20300316U	3.0	0.3R	3.0	16	60	6	2
EPCRC20300320U	3.0	0.3R	3.0	20	60	6	2
EPCRC20300325U	3.0	0.3R	3.0	25	60	6	2
EPCRC20300330U	3.0	0.3R	3.0	30	75	6	2
EPCRC20300335U	3.0	0.3R	3.0	35	75	6	2
EPCRC20300510U	3.0	0.5R	3.0	10	50	6	2
EPCRC20300516U	3.0	0.5R	3.0	16	60	6	2
EPCRC20300520U	3.0	0.5R	3.0	20	60	6	2
EPCRC20300525U	3.0	0.5R	3.0	25	60	6	2
EPCRC20300530U	3.0	0.5R	3.0	30	75	6	2
EPCRC20300535U	3.0	0.5R	3.0	35	75	6	2
EPCRC20301010U	3.0	1.0R	3.0	10	50	6	2
EPCRC20301016U	3.0	1.0R	3.0	16	60	6	2
EPCRC20301020U	3.0	1.0R	3.0	20	60	6	2
EPCRC20301025U	3.0	1.0R	3.0	25	60	6	2
EPCRC20301030U	3.0	1.0R	3.0	30	75	6	2
EPCRC20301035U	3.0	1.0R	3.0	35	75	6	2

Cutting conditions : Table 057

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

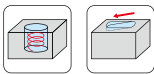
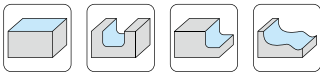
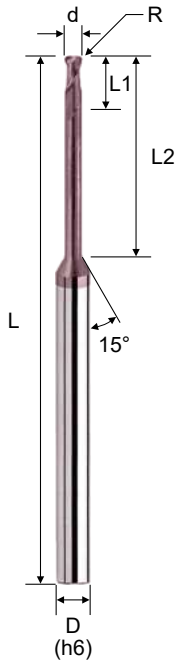
  

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

**G550 - Long Neck · Corner Radius · 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.
- Available in various cut lengths.
- Corner radius with long neck are suitable for deep general cutting and 3D milling.

**EPCRC**



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EPCRC20400113U	4.0	0.1R	4.0	13	50	6	2
EPCRC20400116U	4.0	0.1R	4.0	16	60	6	2
EPCRC20400120U	4.0	0.1R	4.0	20	60	6	2
EPCRC20400125U	4.0	0.1R	4.0	25	60	6	2
EPCRC20400130U	4.0	0.1R	4.0	30	75	6	2
EPCRC20400135U	4.0	0.1R	4.0	35	75	6	2
EPCRC20400213U	4.0	0.2R	4.0	13	50	6	2
EPCRC20400216U	4.0	0.2R	4.0	16	60	6	2
EPCRC20400220U	4.0	0.2R	4.0	20	60	6	2
EPCRC20400225U	4.0	0.2R	4.0	25	60	6	2
EPCRC20400230U	4.0	0.2R	4.0	30	75	6	2
EPCRC20400235U	4.0	0.2R	4.0	35	75	6	2
EPCRC20400313U	4.0	0.3R	4.0	13	50	6	2
EPCRC20400316U	4.0	0.3R	4.0	16	60	6	2
EPCRC20400320U	4.0	0.3R	4.0	20	60	6	2
EPCRC20400325U	4.0	0.3R	4.0	25	60	6	2
EPCRC20400330U	4.0	0.3R	4.0	30	75	6	2
EPCRC20400335U	4.0	0.3R	4.0	35	75	6	2
EPCRC20400513U	4.0	0.5R	4.0	13	50	6	2
EPCRC20400516U	4.0	0.5R	4.0	16	60	6	2
EPCRC20400520U	4.0	0.5R	4.0	20	60	6	2
EPCRC20400525U	4.0	0.5R	4.0	25	60	6	2
EPCRC20400530U	4.0	0.5R	4.0	30	75	6	2
EPCRC20400535U	4.0	0.5R	4.0	35	75	6	2
EPCRC20401013U	4.0	1.0R	4.0	13	50	6	2
EPCRC20401016U	4.0	1.0R	4.0	16	60	6	2
EPCRC20401020U	4.0	1.0R	4.0	20	60	6	2
EPCRC20401025U	4.0	1.0R	4.0	25	60	6	2
EPCRC20401030U	4.0	1.0R	4.0	30	75	6	2
EPCRC20401035U	4.0	1.0R	4.0	35	75	6	2

Cutting conditions : Table 057

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

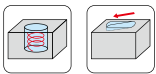
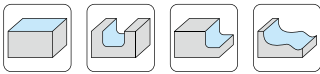
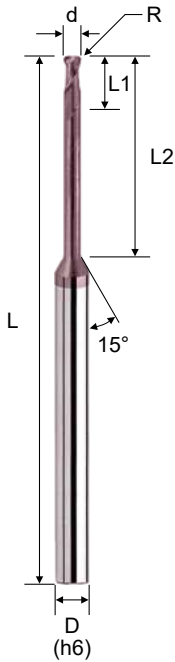
R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020



**G550 - Long Neck · Corner Radius · 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.
- Available in various cut lengths.
- Corner radius with long neck are suitable for deep general cutting and 3D milling.

**EPCRC**



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

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

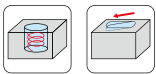
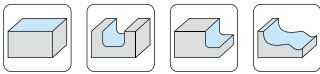
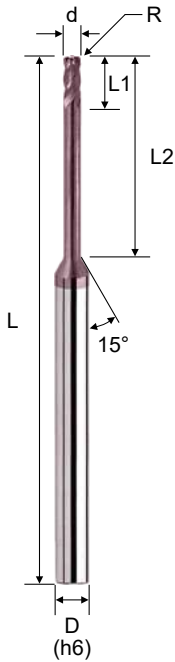
Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EPCRC20500116U	5.0	0.1R	5.0	16	60	6	2
EPCRC20500130U	5.0	0.1R	5.0	30	75	6	2
EPCRC20500216U	5.0	0.2R	5.0	16	60	6	2
EPCRC20500230U	5.0	0.2R	5.0	30	75	6	2
EPCRC20500316U	5.0	0.3R	5.0	16	60	6	2
EPCRC20500330U	5.0	0.3R	5.0	30	75	6	2
EPCRC20500516U	5.0	0.5R	5.0	16	60	6	2
EPCRC20500530U	5.0	0.5R	5.0	30	75	6	2
EPCRC20501016U	5.0	1.0R	5.0	16	60	6	2
EPCRC20501030U	5.0	1.0R	5.0	30	75	6	2
EPCRC20600120U	6.0	0.1R	7.0	20	60	6	2
EPCRC20600130U	6.0	0.1R	7.0	30	75	6	2
EPCRC20600220U	6.0	0.2R	7.0	20	60	6	2
EPCRC20600230U	6.0	0.2R	7.0	30	75	6	2
EPCRC20600320U	6.0	0.3R	7.0	20	60	6	2
EPCRC20600330U	6.0	0.3R	7.0	30	75	6	2
EPCRC20600520U	6.0	0.5R	7.0	20	60	6	2
EPCRC20600530U	6.0	0.5R	7.0	30	75	6	2
EPCRC20601020U	6.0	1.0R	7.0	20	60	6	2
EPCRC20601030U	6.0	1.0R	7.0	30	75	6	2
EPCRC20601520U	6.0	1.5R	7.0	20	60	6	2
EPCRC20601530U	6.0	1.5R	7.0	30	75	6	2
EPCRC20800522U	8.0	0.5R	9.0	22	60	8	2
EPCRC20801022U	8.0	1.0R	9.0	22	60	8	2
EPCRC20801522U	8.0	1.5R	9.0	22	60	8	2
EPCRC20802022U	8.0	2.0R	9.0	22	60	8	2
EPCRC21000524U	10.0	0.5R	11.0	24	75	10	2
EPCRC21001024U	10.0	1.0R	11.0	24	75	10	2
EPCRC21001524U	10.0	1.5R	11.0	24	75	10	2
EPCRC21002024U	10.0	2.0R	11.0	24	75	10	2
EPCRC21200526U	12.0	0.5R	13.0	26	75	12	2
EPCRC21201026U	12.0	1.0R	13.0	26	75	12	2
EPCRC21201526U	12.0	1.5R	13.0	26	75	12	2
EPCRC21202026U	12.0	2.0R	13.0	26	75	12	2

Cutting conditions : Table 057

**G550 - Long Neck · Corner Radius · 4F**

- 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.
- Multiple flutes and ling neck design provides better surface in deep cutting.
- Available in various cut lengths.

**EPCRC**



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
*EPCRC44200106U	2.0	0.1R	2.0	6	50	4	4
*EPCRC44200108U	2.0	0.1R	2.0	8	50	4	4
*EPCRC44200110U	2.0	0.1R	2.0	10	50	4	4
*EPCRC44200112U	2.0	0.1R	2.0	12	50	4	4
*EPCRC44200116U	2.0	0.1R	2.0	16	50	4	4
*EPCRC44200120U	2.0	0.1R	2.0	20	50	4	4
*EPCRC44200125U	2.0	0.1R	2.0	25	60	4	4
*EPCRC44200206U	2.0	0.2R	2.0	6	50	4	4
*EPCRC44200208U	2.0	0.2R	2.0	8	50	4	4
*EPCRC44200210U	2.0	0.2R	2.0	10	50	4	4
*EPCRC44200212U	2.0	0.2R	2.0	12	50	4	4
*EPCRC44200216U	2.0	0.2R	2.0	16	50	4	4
*EPCRC44200220U	2.0	0.2R	2.0	20	50	4	4
*EPCRC44200225U	2.0	0.2R	2.0	25	60	4	4
*EPCRC44200306U	2.0	0.3R	2.0	6	50	4	4
*EPCRC44200308U	2.0	0.3R	2.0	8	50	4	4
*EPCRC44200310U	2.0	0.3R	2.0	10	50	4	4
*EPCRC44200312U	2.0	0.3R	2.0	12	50	4	4
*EPCRC44200316U	2.0	0.3R	2.0	16	50	4	4
*EPCRC44200320U	2.0	0.3R	2.0	20	50	4	4
*EPCRC44200325U	2.0	0.3R	2.0	25	60	4	4
*EPCRC44200506U	2.0	0.5R	2.0	6	50	4	4
*EPCRC44200508U	2.0	0.5R	2.0	8	50	4	4
*EPCRC44200510U	2.0	0.5R	2.0	10	50	4	4
*EPCRC44200512U	2.0	0.5R	2.0	12	50	4	4
*EPCRC44200516U	2.0	0.5R	2.0	16	50	4	4
*EPCRC44200520U	2.0	0.5R	2.0	20	50	4	4
*EPCRC44200525U	2.0	0.5R	2.0	25	60	4	4
EPCRC40200510U	2.0	0.5R	2.0	10	50	6	4
EPCRC40200515U	2.0	0.5R	2.0	15	50	6	4

Cutting conditions : Table 058

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

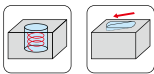
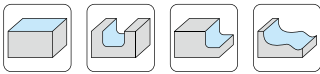
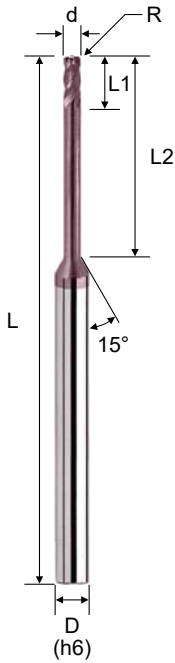
  

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

**G550 - Long Neck · Corner Radius · 4F**

- 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.
- Multiple flutes and ling neck design provides better surface in deep cutting.
- Available in various cut lengths.

**EPCRC**



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
*EPCRC44250110U	2.5	0.1R	2.5	10	50	4	4
*EPCRC44250116U	2.5	0.1R	2.5	16	50	4	4
*EPCRC44250120U	2.5	0.1R	2.5	20	50	4	4
*EPCRC44250125U	2.5	0.1R	2.5	25	60	4	4
*EPCRC44250210U	2.5	0.2R	2.5	10	50	4	4
*EPCRC44250216U	2.5	0.2R	2.5	16	50	4	4
*EPCRC44250220U	2.5	0.2R	2.5	20	50	4	4
*EPCRC44250225U	2.5	0.2R	2.5	25	60	4	4
*EPCRC44250310U	2.5	0.3R	2.5	10	50	4	4
*EPCRC44250316U	2.5	0.3R	2.5	16	50	4	4
*EPCRC44250320U	2.5	0.3R	2.5	20	50	4	4
*EPCRC44250325U	2.5	0.3R	2.5	25	60	4	4
*EPCRC44250510U	2.5	0.5R	2.5	10	50	4	4
*EPCRC44250516U	2.5	0.5R	2.5	16	50	4	4
*EPCRC44250520U	2.5	0.5R	2.5	20	50	4	4
*EPCRC44250525U	2.5	0.5R	2.5	25	60	4	4

Cutting conditions : Table 058

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

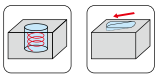
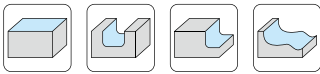
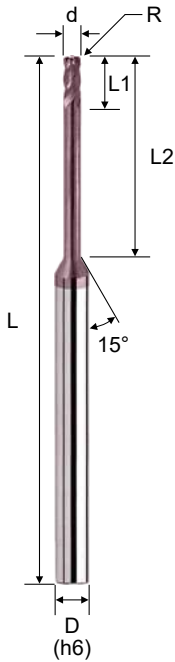
  

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

**G550 - Long Neck · Corner Radius · 4F**

- 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.
- Multiple flutes and ling neck design provides better surface in deep cutting.
- Available in various cut lengths.

**EPCRC**



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EPCRC40300110U	3.0	0.1R	3.0	10	50	6	4
EPCRC40300116U	3.0	0.1R	3.0	16	60	6	4
EPCRC40300120U	3.0	0.1R	3.0	20	60	6	4
EPCRC40300125U	3.0	0.1R	3.0	25	60	6	4
EPCRC40300130U	3.0	0.1R	3.0	30	75	6	4
EPCRC40300135U	3.0	0.1R	3.0	35	75	6	4
EPCRC40300210U	3.0	0.2R	3.0	10	50	6	4
EPCRC40300216U	3.0	0.2R	3.0	16	60	6	4
EPCRC40300220U	3.0	0.2R	3.0	20	60	6	4
EPCRC40300225U	3.0	0.2R	3.0	25	60	6	4
EPCRC40300230U	3.0	0.2R	3.0	30	75	6	4
EPCRC40300235U	3.0	0.2R	3.0	35	75	6	4
EPCRC40300310U	3.0	0.3R	3.0	10	50	6	4
EPCRC40300316U	3.0	0.3R	3.0	16	60	6	4
EPCRC40300320U	3.0	0.3R	3.0	20	60	6	4
EPCRC40300325U	3.0	0.3R	3.0	25	60	6	4
EPCRC40300330U	3.0	0.3R	3.0	30	75	6	4
EPCRC40300335U	3.0	0.3R	3.0	35	75	6	4
EPCRC40300510U	3.0	0.5R	3.0	10	50	6	4
EPCRC40300516U	3.0	0.5R	3.0	16	60	6	4
EPCRC40300520U	3.0	0.5R	3.0	20	60	6	4
EPCRC40300525U	3.0	0.5R	3.0	25	60	6	4
EPCRC40300530U	3.0	0.5R	3.0	30	75	6	4
EPCRC40300535U	3.0	0.5R	3.0	35	75	6	4
EPCRC40301010U	3.0	1.0R	3.0	10	50	6	4
EPCRC40301016U	3.0	1.0R	3.0	16	60	6	4
EPCRC40301020U	3.0	1.0R	3.0	20	60	6	4
EPCRC40301025U	3.0	1.0R	3.0	25	60	6	4
EPCRC40301030U	3.0	1.0R	3.0	30	75	6	4
EPCRC40301035U	3.0	1.0R	3.0	35	75	6	4

Cutting conditions : Table 058

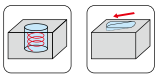
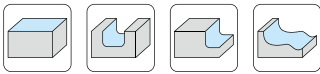
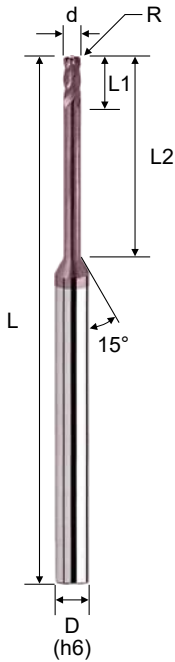
d Tolerance	
d ≤ 6	0 ~ -0.02
6 < d ≤ 12	0 ~ -0.03
d > 12	0 ~ -0.04

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

**G550 - Long Neck · Corner Radius · 4F**

- 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.
- Multiple flutes and ling neck design provides better surface in deep cutting.
- Available in various cut lengths.

**EPCRC**



Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EPCRC40400113U	4.0	0.1R	4.0	13	50	6	4
EPCRC40400116U	4.0	0.1R	4.0	16	60	6	4
EPCRC40400120U	4.0	0.1R	4.0	20	60	6	4
EPCRC40400125U	4.0	0.1R	4.0	25	60	6	4
EPCRC40400130U	4.0	0.1R	4.0	30	75	6	4
EPCRC40400135U	4.0	0.1R	4.0	35	75	6	4
EPCRC40400213U	4.0	0.2R	4.0	13	50	6	4
EPCRC40400216U	4.0	0.2R	4.0	16	60	6	4
EPCRC40400220U	4.0	0.2R	4.0	20	60	6	4
EPCRC40400225U	4.0	0.2R	4.0	25	60	6	4
EPCRC40400230U	4.0	0.2R	4.0	30	75	6	4
EPCRC40400235U	4.0	0.2R	4.0	35	75	6	4
EPCRC40400313U	4.0	0.3R	4.0	13	50	6	4
EPCRC40400316U	4.0	0.3R	4.0	16	60	6	4
EPCRC40400320U	4.0	0.3R	4.0	20	60	6	4
EPCRC40400325U	4.0	0.3R	4.0	25	60	6	4
EPCRC40400330U	4.0	0.3R	4.0	30	75	6	4
EPCRC40400335U	4.0	0.3R	4.0	35	75	6	4
EPCRC40400513U	4.0	0.5R	4.0	13	50	6	4
EPCRC40400516U	4.0	0.5R	4.0	16	60	6	4
EPCRC40400520U	4.0	0.5R	4.0	20	60	6	4
EPCRC40400525U	4.0	0.5R	4.0	25	60	6	4
EPCRC40400530U	4.0	0.5R	4.0	30	75	6	4
EPCRC40400535U	4.0	0.5R	4.0	35	75	6	4
EPCRC40401013U	4.0	1.0R	4.0	13	50	6	4
EPCRC40401016U	4.0	1.0R	4.0	16	60	6	4
EPCRC40401020U	4.0	1.0R	4.0	20	60	6	4
EPCRC40401025U	4.0	1.0R	4.0	25	60	6	4
EPCRC40401030U	4.0	1.0R	4.0	30	75	6	4
EPCRC40401035U	4.0	1.0R	4.0	35	75	6	4

Cutting conditions : Table 058

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

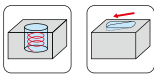
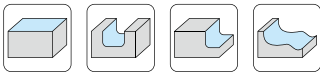
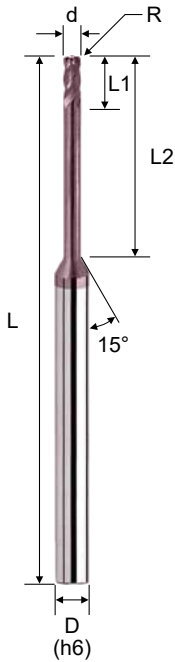
  

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

**G550 - Long Neck · Corner Radius · 4F**

- 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.
- Multiple flutes and ling neck design provides better surface in deep cutting.
- Available in various cut lengths.

**EPCRC**



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

R Tolerance	
R < 2	±0.015
R ≥ 2	±0.020

Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EPCRC40500116U	5.0	0.1R	5.0	16	60	6	4
EPCRC40500130U	5.0	0.1R	5.0	30	75	6	4
EPCRC40500216U	5.0	0.2R	5.0	16	60	6	4
EPCRC40500230U	5.0	0.2R	5.0	30	75	6	4
EPCRC40500316U	5.0	0.3R	5.0	16	60	6	4
EPCRC40500330U	5.0	0.3R	5.0	30	75	6	4
EPCRC40500516U	5.0	0.5R	5.0	16	60	6	4
EPCRC40500530U	5.0	0.5R	5.0	30	75	6	4
EPCRC40501016U	5.0	1.0R	5.0	16	60	6	4
EPCRC40501030U	5.0	1.0R	5.0	30	75	6	4
EPCRC40600120U	6.0	0.1R	7.0	20	60	6	4
EPCRC40600130U	6.0	0.1R	7.0	30	75	6	4
EPCRC40600220U	6.0	0.2R	7.0	20	60	6	4
EPCRC40600230U	6.0	0.2R	7.0	30	75	6	4
EPCRC40600320U	6.0	0.3R	7.0	20	60	6	4
EPCRC40600330U	6.0	0.3R	7.0	30	75	6	4
EPCRC40600520U	6.0	0.5R	7.0	20	60	6	4
EPCRC40600530U	6.0	0.5R	7.0	30	75	6	4
EPCRC40601020U	6.0	1.0R	7.0	20	60	6	4
EPCRC40601030U	6.0	1.0R	7.0	30	75	6	4
EPCRC40601520U	6.0	1.5R	7.0	20	60	6	4
EPCRC40601530U	6.0	1.5R	7.0	30	75	6	4
EPCRC40800522U	8.0	0.5R	9.0	22	60	8	4
EPCRC40801022U	8.0	1.0R	9.0	22	60	8	4
EPCRC40801522U	8.0	1.5R	9.0	22	60	8	4
EPCRC40802022U	8.0	2.0R	9.0	22	60	8	4
EPCRC41000524U	10.0	0.5R	11.0	24	75	10	4
EPCRC41001024U	10.0	1.0R	11.0	24	75	10	4
EPCRC41001524U	10.0	1.5R	11.0	24	75	10	4
EPCRC41002024U	10.0	2.0R	11.0	24	75	10	4
EPCRC41200526U	12.0	0.5R	13.0	26	75	12	4
EPCRC41201026U	12.0	1.0R	13.0	26	75	12	4
EPCRC41201526U	12.0	1.5R	13.0	26	75	12	4
EPCRC41202026U	12.0	2.0R	13.0	26	75	12	4

Cutting conditions : Table O58

Recommended Cutting Conditions

Table 025

**H600 Seires EHSSC2** (H600 Series, vc, rpm and feed increase 20%)

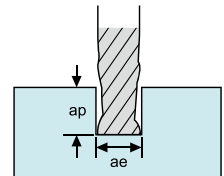
**G550 Seires EPSSC2**

**G450 Seires EPSSA2**

Material	CARBON STEEL / ALLOY STEEL				ALLOY STEEL / TOOL STEEL SCM, SKT, SKD				PREHARDENED STEEL NAK80 CENA1			
Hardness	HB180~250				HRC25~35				HRC35~45			
Vc	120(m/min)				95(m/min)				79(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	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 SKD61, SKD11				STAINLESS STEEL SUS304 316				CAST IRON FC / FCD			
Hardness	HRC 40~55)											
Vc	48(m/min)				79(m/min)				120(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	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.



Recommended Cutting Conditions

Table 026

**H600 Seires EHSSC4, ESHC4** (H600 Series, vc, rpm and feed increase 20%)

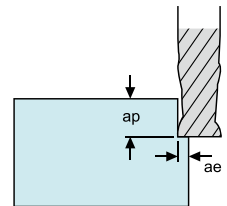
**G550 Seires EPSSC3, EPSSC4, EPSSA4**

**G450 Seires EPSSA4**

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)			
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	12700	762	3	0.15	10000	600	3	0.15	8386	503	3	0.15
4mm	9550	764	4	0.2	7560	604	4	0.2	6290	503	4	0.2
6mm	6370	890	6	0.3	5040	705	6	0.3	4200	588	6	0.3
8mm	4770	668	8	0.4	3780	529	8	0.4	3140	440	8	0.4
10mm	3820	458	10	0.5	3020	362	10	0.5	2515	301	10	0.5
12mm	3180	380	12	0.6	2520	302	12	0.6	2100	252	12	0.6

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)			
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	5095	305	3	0.15	8386	503	3	0.15	12700	503	3	0.15
4mm	3820	305	4	0.2	6290	503	4	0.2	9550	503	4	0.2
6mm	2548	356	6	0.3	4200	588	6	0.3	6370	588	6	0.3
8mm	1910	267	8	0.4	3140	440	8	0.4	4770	440	8	0.4
10mm	1528	183	10	0.5	2515	301	10	0.5	3820	301	10	0.5
12mm	1274	152	12	0.6	2100	252	12	0.6	3180	252	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.





Recommended Cutting Conditions

Table 027

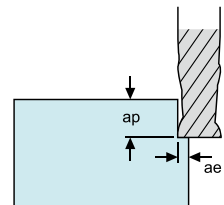
H600 Seires EHSSD4 (H600 Series, vc, rpm and feed increase 20%)

G550 Seires EPSSH4, EPSCH6

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)			
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	12700	762	4.5	0.15	10000	600	4.5	0.15	8386	503	4.5	0.15
4mm	9550	764	6	0.2	7560	604	6	0.2	6290	503	6	0.2
6mm	6370	890	9	0.3	5040	705	9	0.3	4200	588	9	0.3
8mm	4770	668	12	0.4	3780	529	12	0.4	3140	440	12	0.4
10mm	3820	458	15	0.5	3020	362	15	0.5	2515	301	15	0.5
12mm	3180	380	18	0.6	2520	302	18	0.6	2100	252	18	0.6

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)			
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	5095	305	4.5	0.15	7430	743	4.5	0.15	12700	503	4.5	0.15
4mm	3820	305	6	0.2	5570	577	6	0.2	9550	503	6	0.2
6mm	2548	356	9	0.3	3720	595	9	0.3	6370	588	9	0.3
8mm	1910	267	12	0.4	2780	556	12	0.4	4770	440	12	0.4
10mm	1528	183	15	0.5	2230	535	15	0.5	3820	301	15	0.5
12mm	1274	152	18	0.6	1860	484	18	0.6	3180	252	18	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.



Recommended Cutting Conditions

Table 028

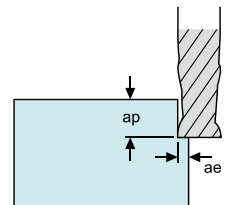
H600 Seires EHSCC4, EHSC4 (H600 Series, vc, rpm and feed increase 20%)

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.



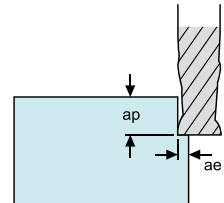
Recommended Cutting Conditions

**Table 029**  
**G550 Seires EPSSH4, EPSCH6**

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	4.5	0.15	8000	480	4.5	0.15	67010	402	4.5	0.15
4mm	7640	611	6	0.2	6048	483	6	0.2	5032	402	6	0.2
6mm	5096	712	9	0.3	4032	564	9	0.3	3360	470	9	0.3
8mm	3816	534	12	0.4	3024	423	12	0.4	2512	352	12	0.4
10mm	3056	366	15	0.5	2416	290	15	0.5	2012	241	15	0.5
12mm	2544	304	18	0.6	2016	242	18	0.6	1680	202	18	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	4.5	0.15	5944	594	4.5	0.15	10160	402	4.5	0.15
4mm	3056	244	6	0.2	4456	462	6	0.2	7640	402	6	0.2
6mm	2040	285	9	0.3	2976	476	9	0.3	5096	470	9	0.3
8mm	1528	214	12	0.4	2224	445	12	0.4	3816	352	12	0.4
10mm	1220	146	15	0.5	1784	428	15	0.5	3056	241	15	0.5
12mm	1020	122	18	0.6	1488	387	18	0.6	2544	202	18	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.



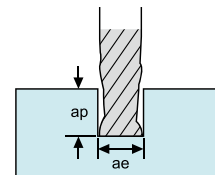
## Recommended Cutting Conditions

**Table 030**  
**G550 Seires EPSLC2**

Material	CARBON STEEL / ALLOY STEEL				ALLOY STEEL / TOOL STEEL SCM, SKT, SKD				PREHARDENED STEEL NAK80 CENA1			
Hardness	HB180~250				HRC25~35				HRC35~45			
Vc	102 (m/min)				80 (m/min)				67 (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	10800	323	1.5	3	8500	255	0.9	3	7128	213	0.15	3
4mm	8118	324	2	4	4626	256	1.2	4	5346	213	0.2	4
6mm	5414	378	3	6	4284	300	1.8	6	3570	250	0.3	6
8mm	4054	283	4	8	3210	224	2.4	8	2670	187	0.4	8
10mm	3248	195	5	10	2568	154	3	10	2138	127	0.5	10
12mm	2700	160	6	12	2142	128	3.6	12	1785	107	0.6	12

Material	HARDENED STEEL SKD61, SKD11				STAINLESS STEEL SUS304 316				CAST IRON FC / FCD			
Hardness	HRC 40~55)											
Vc	40 (m/min)				67 (m/min)				102 (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	4330	130	0.15	3	7128	213	0.15	3	10800	323	1.5	3
4mm	3247	130	0.2	4	5346	213	0.2	4	8118	324	2	4
6mm	2165	151	0.3	6	3570	250	0.3	6	5414	378	3	6
8mm	1624	113	0.4	8	2670	187	0.4	8	4054	283	4	8
10mm	1298	78	0.5	10	2138	127	0.5	10	3248	195	5	10
12mm	1082	65	0.6	12	1785	107	0.6	12	2700	160	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.



Recommended Cutting Conditions

Table 031

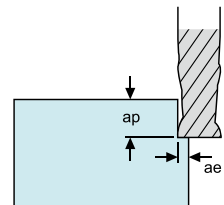
H600 Seires EHSLC4 (H600 Series, vc, rpm and feed increase 20%)

G550 Seires EPSLC4

Material	CARBON STEEL / ALLOY STEEL				ALLOY STEEL / TOOL STEEL SCM, SKT, SKD				PREHARDENED STEEL NAK80 CENA1			
Hardness	HB180~250				HRC25~35				HRC35~45			
Vc	102 (m/min)				80 (m/min)				67 (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	10800	647	3	0.15	8500	510	3	0.15	7128	427	3	0.15
4mm	8118	649	4	0.2	4626	513	4	0.2	5346	427	4	0.2
6mm	5414	756	6	0.3	4284	600	6	0.3	3570	500	6	0.3
8mm	4054	568	8	0.4	3210	450	8	0.4	2670	340	8	0.4
10mm	3248	389	10	0.5	2568	307	10	0.5	2138	255	10	0.5
12mm	2700	323	12	0.6	2142	256	12	0.6	1785	214	12	0.6

Material	HARDENED STEEL SKD61, SKD11				STAINLESS STEEL SUS304 316				CAST IRON FC / FCD			
Hardness	HRC 40~55)											
Vc	40 (m/min)				67 (m/min)				102 (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	4330	260	3	0.15	7128	427	3	0.15	10800	647	3	0.15
4mm	3247	260	4	0.2	5346	427	4	0.2	8118	649	4	0.2
6mm	2165	302	6	0.3	3570	500	6	0.3	5414	756	6	0.3
8mm	1624	226	8	0.4	2670	340	8	0.4	4054	568	8	0.4
10mm	1298	155	10	0.5	2138	255	10	0.5	3248	389	10	0.5
12mm	1082	129	12	0.6	1785	214	12	0.6	2700	323	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.



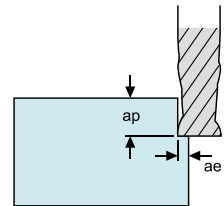
Recommended Cutting Conditions

**Table 032**  
**G550 Seires EPSRR4**

Material	CARBON STEEL / ALLOY STEEL				ALLOY STEEL / TOOL STEEL SCM, SKT, SKD				PREHARDENED STEEL NAK80 CENA1			
Hardness	HB 180~250				HRC 25~35				HRC 35~45			
Vc	68 (m/min)				54 (m/min)				45 (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)
6mm	3600	430	6	0.6	2880	295	6	0.6	2340	200	6	0.6
8mm	2700	430	8	0.8	2160	295	8	0.8	1800	200	8	0.8
10mm	2160	430	10	1	1710	295	10	1	1440	200	10	1
12mm	1800	430	12	1.2	1440	295	12	1.2	1200	200	12	1.2

Material	HARDENED STEEL SKD61, SKD11				STAINLESS STEEL SUS304 316				CAST IRON FC / FCD			
Hardness	HRC 40~55											
Vc	27 (m/min)				54 (m/min)				79 (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)
6mm	1440	85	6	0.3	2880	295	6	0.6	4320	520	6	0.6
8mm	1080	85	8	0.4	2160	295	8	0.8	3240	520	8	0.8
10mm	860	85	10	0.5	1710	295	10	1	2520	520	10	1
12mm	720	85	12	0.6	1440	295	12	1.2	2160	520	12	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.



## Recommended Cutting Conditions

### Table 033

### G550 Seires EPSHC2, EPSHC4

Working Material	Cutting Application	ae (mm)	ap (mm)	Vc (m/min)	fz (mm/z)					
					1mm	2mm	3mm	4mm	5mm	6mm
Carbon steel (S45C, S50C)	Slot milling	1×d	≤ 0.5×d	50 ~ 90	0.007	0.013	0.018	0.024	0.030	0.036
	Side milling	≤ 0.3×d	≤ 0.3×d	55 ~ 100	0.007	0.013	0.018	0.024	0.030	0.036
	Profile milling	≤ 0.3×d	≤ 0.1×d	80 ~ 135	0.007	0.013	0.018	0.024	0.030	0.036
Alloy steel & Tool steel (SCM, SKT, SKD)	Slot milling	1×d	≤ 0.5×d	40 ~ 70	0.006	0.012	0.017	0.022	0.028	0.033
	Side milling	≤ 0.3×d	≤ 0.3×d	40 ~ 80	0.006	0.012	0.017	0.022	0.028	0.033
	Profile milling	≤ 0.3×d	≤ 0.1×d	55 ~ 100	0.006	0.012	0.017	0.022	0.028	0.033
Stainless steel (SUS304, SUS316)	Slot milling	1×d	≤ 0.5×d	30 ~ 40	0.006	0.011	0.015	0.020	0.025	0.030
	Side milling	≤ 0.3×d	≤ 0.3×d	40 ~ 60	0.006	0.011	0.015	0.020	0.025	0.030
	Profile milling	≤ 0.3×d	≤ 0.1×d	50 ~ 70	0.006	0.011	0.015	0.020	0.025	0.030
Hardened steel & High temperature alloy	Slot milling	1×d	≤ 0.5×d	20 ~ 40	0.005	0.010	0.014	0.018	0.023	0.027
	Side milling	≤ 0.3×d	≤ 0.3×d	30 ~ 55	0.005	0.010	0.014	0.018	0.023	0.027
	Profile milling	≤ 0.3×d	≤ 0.1×d	40 ~ 70	0.005	0.010	0.014	0.018	0.023	0.027

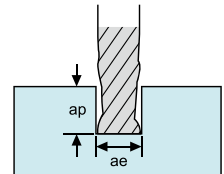
1. Use as highly rigid and accurate machine as possible.
2. If the rpm available is lower than the recommend condition, please reduce the feed rate to the same ratio.
3. Use long shank type please reduce the rpm and feed rate.
4. The Feed and RPM may be changed depending on the M/C conditions ,lubricating and cooling system.

Recommended Cutting Conditions

**Table 034**  
**G550 Seires EPSST2**

WORKING MATERIAL	ALLOY STEEL / TOOL STEEL		ALLOY STEEL / TOOL STEEL		ALLOY STEEL / TOOL STEEL		HARDENED STEEL		STAINLESS STEEL		CAST IRON	
CODE	45C,S50C,SCM		SCM,SKT,SKD		SCM,SKT,SKD		SKT, SKD		SUS 304		FC / FCD	
HARDNESS	HRC < 20		HRC 20 ~ 30		HRC 30 ~ 40		HRC 45~45		-		-	
Vc	88 M/min		71 M/min		59 M/min		35 M/min		71 M/min		103 M/min	
DIAMETER	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)
1MM	26,000	190	22,230	140	18,720	100	10,400	40	22,230	165	32,760	240
2MM	14,040	235	11,232	160	9,360	110	5,616	45	11,232	185	16,380	270
3MM	9,828	270	7,488	175	6,084	120	3,900	55	7,488	205	11,232	310
4MM	7,020	260	5,616	175	4,680	120	2,808	50	5,616	205	8,424	310
5MM	5,850	270	4,446	175	3,744	120	2,340	55	4,446	205	6,552	300
6MM	4,680	260	3,744	175	3,042	120	1,872	50	3,744	205	5,616	310
8MM	3,510	260	2,808	175	2,340	120	1,404	50	2,808	205	4,212	310
10MM	2,808	260	2,223	175	1,872	120	1,131	50	2,223	205	3,276	300
Milling Amount (mm)							$Ad = 0.1D$ $(D < 3,$ $Ad \leq 0.05D)$		$Ad = 0.5D$ $(D < 3, Ad \leq 0.25D)$			

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.





Recommended Cutting Conditions

Table 035

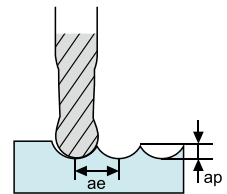
H600 Seires EHBSC2 (H600 Series, vc, rpm and feed increase 20%)

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.



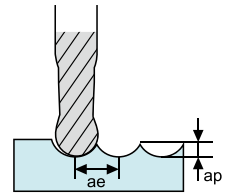
Recommended Cutting Conditions

**Table 036**  
**G550 Seires EPBSC4**

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.



Recommended Cutting Conditions

Table 037

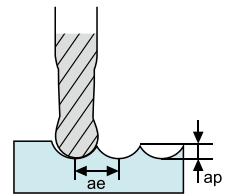
H600 Seires EHBLC2 (H600 Series, vc, rpm and feed increase 20%)

G550 Seires EPBLC2

Material	CARBON STEEL / ALLOY STEEL				ALLOY STEEL / TOOL STEEL SCM, SKT, SKD				PREHARDENED STEEL NAK80 CENA1			
Hardness	HB180~250				HRC25~35				HRC35~45			
Vc	102 (m/min)				80 (m/min)				67 (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	31850	796	0.14	0.2	25210	629	0.14	0.2	20960	524	0.14	0.2
2R	15920	952	0.28	0.4	12606	757	0.28	0.4	10480	629	0.28	0.4
3R	10620	796	0.42	0.6	8400	629	0.42	0.6	6990	524	0.42	0.6
4R	7960	638	0.56	0.8	6300	504	0.56	0.8	5244.5	420	0.56	0.8
5R	6370	540	0.7	1	5040	428	0.7	1	4190	357	0.7	1
6R	5308	476	0.84	1.2	4200	377	0.84	1.2	3495	315	0.84	1.2

Material	HARDENED STEEL SKD61, SKD11				STAINLESS STEEL SUS304 316				CAST IRON FC / FCD			
Hardness	HRC 40~55)				HRC25~35				HRC35~45			
Vc	40 (m/min)				67 (m/min)				102 (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	12740	318	0.14	0.2	20960	524	0.14	0.2	31850	796	0.14	0.2
2R	6370	383	0.28	0.4	10480	629	0.28	0.4	15920	952	0.28	0.4
3R	4245.8	318	0.42	0.6	6990	524	0.42	0.6	10620	796	0.42	0.6
4R	3187.5	255	0.56	0.8	5244.5	420	0.56	0.8	7960	638	0.56	0.8
5R	2550	217	0.7	1	4190	357	0.7	1	6370	540	0.7	1
6R	2125	191	0.84	1.2	3495	315	0.84	1.2	5308	476	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.



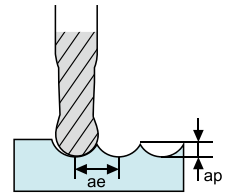
Recommended Cutting Conditions

**Table 038**  
**G550 Seires EPBLC4**

Material	CARBON STEEL / ALLOY STEEL				ALLOY STEEL / TOOL STEEL SCM, SKT, SKD				PREHARDENED STEEL NAK80 CENA1			
Hardness	HB180~250				HRC25~35				HRC35~45			
Vc	102 (m/min)				80 (m/min)				67 (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	31850	796	0.14	0.2	25210	629	0.14	0.2	20960	524	0.14	0.2
2R	15920	952	0.28	0.4	12606	757	0.28	0.4	10480	629	0.28	0.4
3R	10620	796	0.42	0.6	8400	629	0.42	0.6	6990	524	0.42	0.6
4R	7960	638	0.56	0.8	6300	504	0.56	0.8	5245	420	0.56	0.8
5R	6370	540	0.7	1	5040	428	0.7	1	4190	357	0.7	1
6R	5308	476	0.84	1.2	4200	377	0.84	1.2	3495	315	0.84	1.2

Material	HARDENED STEEL SKD61, SKD11				STAINLESS STEEL SUS304 316				CAST IRON FC / FCD			
Hardness	HRC 40~55)				HRC25~35				HRC35~45			
Vc	40 (m/min)				67 (m/min)				102 (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	12740	318	0.14	0.2	20960	524	0.14	0.2	31850	796	0.14	0.2
2R	6370	383	0.28	0.4	10480	629	0.28	0.4	15920	952	0.28	0.4
3R	4246	318	0.42	0.6	6990	524	0.42	0.6	10620	796	0.42	0.6
4R	3188	255	0.56	0.8	5245	420	0.56	0.8	7960	638	0.56	0.8
5R	2550	217	0.7	1	4190	357	0.7	1	6370	540	0.7	1
6R	2125	191	0.84	1.2	3495	315	0.84	1.2	5308	476	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.

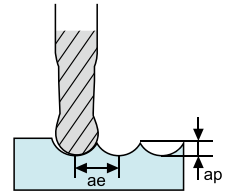


Recommended Cutting Conditions

**Table 039**  
**G550 Seires EPBHC2**

Working Material	Cutting Application	ae (mm)	ap (mm)	Vc (m/min)	fz (mm/z)					
					1mm	2mm	3mm	4mm	5mm	6mm
Carbon steel (S45C, S50C)	Slot milling	1×d	≤ 0.5×d	50 ~ 90	0.007	0.013	0.018	0.024	0.030	0.036
	Side milling	≤ 0.3×d	≤ 0.3×d	55 ~ 100	0.007	0.013	0.018	0.024	0.030	0.036
	Profile milling	≤ 0.3×d	≤ 0.1×d	80 ~ 135	0.007	0.013	0.018	0.024	0.030	0.036
Alloy steel & Tool steel (SCM, SKT, SKD)	Slot milling	1×d	≤ 0.5×d	40 ~ 70	0.006	0.012	0.017	0.022	0.028	0.033
	Side milling	≤ 0.3×d	≤ 0.3×d	40 ~ 80	0.006	0.012	0.017	0.022	0.028	0.033
	Profile milling	≤ 0.3×d	≤ 0.1×d	55 ~ 100	0.006	0.012	0.017	0.022	0.028	0.033
Stainless steel (SUS304, SUS316)	Slot milling	1×d	≤ 0.5×d	30 ~ 40	0.006	0.011	0.015	0.020	0.025	0.030
	Side milling	≤ 0.3×d	≤ 0.3×d	40 ~ 60	0.006	0.011	0.015	0.020	0.025	0.030
	Profile milling	≤ 0.3×d	≤ 0.1×d	50 ~ 70	0.006	0.011	0.015	0.020	0.025	0.030
Hardened steel & High temperature alloy	Slot milling	1×d	≤ 0.5×d	20 ~ 40	0.005	0.010	0.014	0.018	0.023	0.027
	Side milling	≤ 0.3×d	≤ 0.3×d	30 ~ 55	0.005	0.010	0.014	0.018	0.023	0.027
	Profile milling	≤ 0.3×d	≤ 0.1×d	40 ~ 70	0.005	0.010	0.014	0.018	0.023	0.027

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.



**Table 040**  
**G550 Seires EPBST2, EPBRT2**

WORKING MATERIAL	ALLOY STEEL / TOOL STEEL		ALLOY STEEL / TOOL STEEL		ALLOY STEEL / TOOL STEEL		HARDENED STEEL		STAINLESS STEEL		CAST IRON					
	CODE	HARDNESS	Vc	DIAMETER	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)				
ALLOY STEEL / TOOL STEEL	45C,S50C,SCM	HRC < 20	94 M/min	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)			
ALLOY STEEL / TOOL STEEL	SCM,SKT,SKD	HRC 20 ~ 30	71 M/min	1.0R	26,676	700	21,060	470	15,210	280	10,660	140	21,060	555	29,718	780
ALLOY STEEL / TOOL STEEL	SCM,SKT,SKD	HRC 30 ~ 40	34 M/min	2.0R	14,976	875	11,232	560	8,190	335	5,980	175	11,232	655	14,976	875
HARDENED STEEL	SKT, SKD	HRC 45~45	38 M/min	3.0R	9,828	860	7,488	560	4,914	300	3,926	170	7,488	655	9,828	860
STAINLESS STEEL	SUS 304	-	71 M/min	Milling Amount (mm)	Ad = 0.05D Pf = 0.1D 											
CAST IRON	FC / FCD	-	94 M/min													

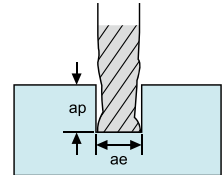
Recommended Cutting Conditions

**Table 041**  
**G550 Seires EPCSC2**

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)			
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	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 SKD61, SKD11				STAINLESS STEEL SUS304 316				CAST IRON FC / FCD			
Hardness	HRC 40~55)											
Vc	48 (m/min)				79 (m/min)				120 (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	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.



Recommended Cutting Conditions

Table 042

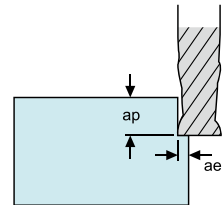
H600 Seires EHCSC4 (H600 Series, vc, rpm and feed increase 20%)

G550 Seires EPCSC4

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)			
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	12700	762	3	0.15	10000	600	3	0.15	8386	503	3	0.15
4mm	9550	764	4	0.2	7560	604	4	0.2	6290	503	4	0.2
6mm	6370	890	6	0.3	5040	705	6	0.3	4200	588	6	0.3
8mm	4770	668	8	0.4	3780	529	8	0.4	3140	440	8	0.4
10mm	3820	458	10	0.5	3020	362	10	0.5	2515	301	10	0.5
12mm	3180	380	12	0.6	2520	302	12	0.6	2100	252	12	0.6

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)			
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	5095	305	3	0.15	8386	503	3	0.15	12700	503	3	0.15
4mm	3820	305	4	0.2	6290	503	4	0.2	9550	503	4	0.2
6mm	2548	356	6	0.3	4200	588	6	0.3	6370	588	6	0.3
8mm	1910	267	8	0.4	3140	440	8	0.4	4770	440	8	0.4
10mm	1528	183	10	0.5	2515	301	10	0.5	3820	301	10	0.5
12mm	1274	152	12	0.6	2100	252	12	0.6	3180	252	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.



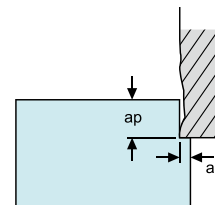
**Recommended Cutting Conditions**

**Table 043**  
**G550 Seires EPCSH4**

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)			
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	12700	762	3	0.15	10000	600	3	0.15	8386	503	3	0.15
4mm	9550	764	4	0.2	7560	604	4	0.2	6290	503	4	0.2
6mm	6370	890	6	0.3	5040	705	6	0.3	4200	588	6	0.3
8mm	4770	668	8	0.4	3780	529	8	0.4	3140	440	8	0.4
10mm	3820	458	10	0.5	3020	362	10	0.5	2515	301	10	0.5
12mm	3180	380	12	0.6	2520	302	12	0.6	2100	252	12	0.6

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)			
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	5095	305	3	0.15	8386	503	3	0.15	12700	503	3	0.15
4mm	3820	305	4	0.2	6290	503	4	0.2	9550	503	4	0.2
6mm	2548	356	6	0.3	4200	588	6	0.3	6370	588	6	0.3
8mm	1910	267	8	0.4	3140	440	8	0.4	4770	440	8	0.4
10mm	1528	183	10	0.5	2515	301	10	0.5	3820	301	10	0.5
12mm	1274	152	12	0.6	2100	252	12	0.6	3180	252	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.





Recommended Cutting Conditions

Table 044

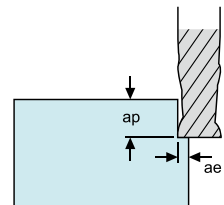
H600 Seires EHCLC4 (H600 Series, vc, rpm and feed increase 20%)

G550 Seires EPCLC4

Material	CARBON STEEL / ALLOY STEEL				ALLOY STEEL / TOOL STEEL SCM, SKT, SKD				PREHARDENED STEEL NAK80 CENA1			
Hardness	HB180~250				HRC25~35				HRC35~45			
Vc	102 (m/min)				80 (m/min)				67 (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	10800	647	3	0.15	8500	510	3	0.15	7128	427	3	0.15
4mm	8118	649	4	0.2	4626	513	4	0.2	5346	427	4	0.2
6mm	5414	756	6	0.3	4284	600	6	0.3	3570	500	6	0.3
8mm	4054	568	8	0.4	3210	450	8	0.4	2670	340	8	0.4
10mm	3248	389	10	0.5	2568	307	10	0.5	2138	255	10	0.5
12mm	2700	323	12	0.6	2142	256	12	0.6	1785	214	12	0.6

Material	HARDENED STEEL SKD61, SKD11				STAINLESS STEEL SUS304 316				CAST IRON FC / FCD			
Hardness	HRC 40~55)											
Vc	40 (m/min)				67 (m/min)				102 (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	4330	260	3	0.15	7128	427	3	0.15	10800	647	3	0.15
4mm	3247	260	4	0.2	5346	427	4	0.2	8118	649	4	0.2
6mm	2165	302	6	0.3	3570	500	6	0.3	5414	756	6	0.3
8mm	1624	226	8	0.4	2670	340	8	0.4	4054	568	8	0.4
10mm	1298	155	10	0.5	2138	255	10	0.5	3248	389	10	0.5
12mm	1082	129	12	0.6	1785	214	12	0.6	2700	323	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.

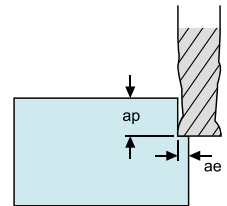


Recommended Cutting Conditions

**Table 045**  
**G550 Seires EPCHC2, EPCHC4**

Working Material	Cutting Application	ae (mm)	ap (mm)	Vc (m/min)	fz (mm/z)					
					1mm	2mm	3mm	4mm	5mm	6mm
Carbon steel (S45C, S50C)	Slot milling	1×d	≤ 0.5×d	50 ~ 90	0.007	0.013	0.018	0.024	0.030	0.036
	Side milling	≤ 0.3×d	≤ 0.3×d	55 ~ 100	0.007	0.013	0.018	0.024	0.030	0.036
	Profile milling	≤ 0.3×d	≤ 0.1×d	80 ~ 135	0.007	0.013	0.018	0.024	0.030	0.036
Alloy steel & Tool steel (SCM, SKT, SKD)	Slot milling	1×d	≤ 0.5×d	40 ~ 70	0.006	0.012	0.017	0.022	0.028	0.033
	Side milling	≤ 0.3×d	≤ 0.3×d	40 ~ 80	0.006	0.012	0.017	0.022	0.028	0.033
	Profile milling	≤ 0.3×d	≤ 0.1×d	55 ~ 100	0.006	0.012	0.017	0.022	0.028	0.033
Stainless steel (SUS304, SUS316)	Slot milling	1×d	≤ 0.5×d	30 ~ 40	0.006	0.011	0.015	0.020	0.025	0.030
	Side milling	≤ 0.3×d	≤ 0.3×d	40 ~ 60	0.006	0.011	0.015	0.020	0.025	0.030
	Profile milling	≤ 0.3×d	≤ 0.1×d	50 ~ 70	0.006	0.011	0.015	0.020	0.025	0.030
Hardened steel & High temperature alloy	Slot milling	1×d	≤ 0.5×d	20 ~ 40	0.005	0.010	0.014	0.018	0.023	0.027
	Side milling	≤ 0.3×d	≤ 0.3×d	30 ~ 55	0.005	0.010	0.014	0.018	0.023	0.027
	Profile milling	≤ 0.3×d	≤ 0.1×d	40 ~ 70	0.005	0.010	0.014	0.018	0.023	0.027

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.



Recommended Cutting Conditions

**Table 046**  
**G550 Seires EPISA2, EPISA4**

WORKING MATERIAL	CARBON STEEL			ALLOY STEEL / TOOL STEEL			HARDENED STEEL		
CODE	S50C			SCM, SKD			SKT, SKD		
HARDNESS	HRC < 20			HRC 30 ~ 40			HRC 40~50		
Vc	30~40 M/min			20~30 M/min			15~25 M/min		
DIAMETER	R.P.M	ROUGHING FEED (mm/min)	FINISHING FEED (mm/min)	R.P.M	ROUGHING FEED (mm/min)	FINISHING FEED (mm/min)	R.P.M	ROUGHING FEED (mm/min)	FINISHING FEED (mm/min)
0.50R	8,800	50	80	6,400	40	55	5,100	30	50
0.75R	7,200	50	80	5,100	40	55	4,100	30	50
1.00R	5,000	50	80	3,500	40	55	3,400	30	50
1.25R	4,300	50	80	3,100	40	55	2,900	30	50
1.50R	3,000	50	80	2,200	40	55	2,600	30	50
2.00R	2,600	50	80	1,900	40	55	2,200	30	50
2.50R	2,200	50	80	1,800	40	55	2,000	30	50
3.00R	2,000	50	80	1,600	40	55	1,700	30	50
4.00R	1,500	50	80	1,200	40	55	1,300	30	50
5.00R	1,300	50	80	960	40	55	1,000	30	50
6.00R	1,200	50	80	880	40	55	900	30	50
Milling Amount (mm)							<ul style="list-style-type: none"> <li>· Divide the cutting depth into several time paths.</li> <li>· Use cutting fluid.</li> </ul>		

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.

Recommended Cutting Conditions

Table 047

G550 Seires EPFSA4, EPFSA5, EPFSA6

Material	Carbon Steel / Alloy Steel / Cast iron					Alloy Steel / Tool Steel / Pre-Hardened Steel (SCM, SKT, SKD)					Stainless Steel (SUS304, SUS316)				Hardened Steel					
Hardness	HRC < 30					HRC 30 ~ 40					-				HRC 40 ~ 55					
Vc	80 ~ 230 m/min					60 ~ 180 m/min					45 ~ 140 m/min				25 ~ 30 m/min					
d (mm)	fz (mm)	α = 60°		α = 90°		fz (mm)	α = 60°		α = 90°		fz (mm)	α = 60°		α = 90°		fz (mm)	α = 60°		α = 90°	
		ap (mm)	ae (mm)	ap (mm)	ae (mm)		ap (mm)	ae (mm)	ap (mm)	ae (mm)		ap (mm)	ae (mm)	ap (mm)	ae (mm)		ap (mm)	ae (mm)	ap (mm)	ae (mm)
4	0.04	0.30	0.2	0.2	0.2	0.04	0.30	0.2	0.2	0.2	0.04	0.30	0.2	0.2	0.2	0.04	0.30	0.2	0.2	0.2
6	0.04	0.45	0.3	0.3	0.3	0.04	0.45	0.3	0.3	0.3	0.04	0.45	0.3	0.3	0.3	0.04	0.45	0.3	0.3	0.3
8	0.05	0.60	0.4	0.4	0.4	0.05	0.60	0.4	0.4	0.4	0.05	0.60	0.4	0.4	0.4	0.05	0.60	0.4	0.4	0.4
10	0.06	0.75	0.5	0.5	0.5	0.06	0.75	0.5	0.5	0.5	0.06	0.75	0.5	0.5	0.5	0.06	0.75	0.5	0.5	0.5
12	0.07	0.90	0.6	0.6	0.6	0.07	0.90	0.6	0.6	0.6	0.07	0.90	0.6	0.6	0.6	0.07	0.90	0.6	0.6	0.6

※ Effective Cutter Diameter = (d + d1)/2  
 For machining on two sides, Feed rate reduce 20~30%.  
 For vertical plunging, Feed rate reduce 30~40%.

Table 048

G550 Seires EPFSC2

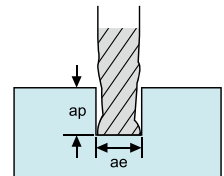
Working Material	Normal Steel (S45C)			Alloy Steel / Tool Steel (SCM, SKT, SKD)			Stainless Steel (SUS304)			Aluminum Alloy		
Hardness	HRC < 20			HRC < 30~40			-			-		
Vc	60 m/min			50 m/min			40 m/min			100 m/min		
Dia	RPM	Feed (mm/min)		RPM	Feed (mm/min)		RPM	Feed (mm/min)		RPM	Feed (mm/min)	
		Vertical	Horizontal		Vertical	Horizontal		Vertical	Horizontal		Vertical	Horizontal
3 mm	6400	25	50	5300	20	40	4200	20	40	10600	40	80
4 mm	4800	25	55	4000	20	45	3200	20	45	8000	40	85
6 mm	3200	25	60	2650	20	50	2100	20	50	5300	40	90
8 mm	2400	25	65	2000	20	55	1600	20	55	4000	40	110
10 mm	1900	25	70	1600	20	60	1300	20	60	3200	40	110
12 mm	1600	25	70	1350	20	60	1050	20	60	2700	40	120

Recommended Cutting Conditions

**Table 049**  
**G550 Seires EPSRC2**

Material		Carbon Steels/Cast iron/Alloy Steels S50C/FC250/SCM/NAK		
Hardness		HRC 35~45		
Dia	EFF-L	RPM	Feed (mm/min)	ap (mm)
0.2mm	1	40000	400	0.001
	2	40000	200	0.005
0.3mm	1	40000	650	0.007
	2	40000	550	0.004
	3	40000	500	0.002
	4	30000	200	0.001
0.4mm	2	40000	800	0.007
	4	40000	800	0.003
	6	28000	350	0.001
	8	20000	200	0.001
	10	17000	150	0.001
0.5mm	4	40000	850	0.003
	6	40000	700	0.003
	8	30000	500	0.002
	12	20000	300	0.001
	14	14000	150	0.001
0.6mm	4	40000	950	0.010
	8	35000	500	0.004
	10	25000	450	0.003
	12	20000	300	0.002
	16	12000	150	0.001
0.7mm	4	40000	950	0.015
	8	30000	700	0.005
	12	9000	200	0.002
0.8mm	4	40000	1100	0.015
	8	40000	1000	0.010
	12	25000	400	0.030
	14	20000	300	0.020
0.9mm	6	40000	1300	0.020
	8	38000	1200	0.010
	10	35000	1000	0.010

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.

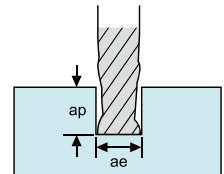


## Recommended Cutting Conditions

**Table 050**  
**G550 Seires EPSRC2**

Material		Carbon Steels/Cast iron/Alloy Steels S50C/FC250/SCM/NAK		
Hardness		HRC 35~45		
Dia	EFF-L	RPM	Feed (mm/min)	ap (mm)
1.0mm	6	40000	1600	0.040
	8	40000	1600	0.030
	10	38000	1300	0.025
	12	30000	1000	0.02
	16	23000	600	0.010
	20	15000	400	0.005
1.2mm	6	40000	1900	0.060
	10	35000	1500	0.040
	16	15000	500	0.020
	20	6500	150	0.01
1.4mm	6	40000	1900	0.060
	10	35000	1500	0.040
	16	15000	500	0.02
	20	6500	150	0.01
1.5mm	6	40000	2400	0.1
	10	30000	1800	0.05
	12	28000	1300	0.04
	16	20000	800	0.02
	20	15000	600	0.02
1.6mm	10	30000	1800	0.07
	14	25000	1500	0.05
	18	20000	1000	0.04
1.8mm	10	30000	1800	0.07
	14	25000	1500	0.05
	18	20000	1000	0.04
2.0mm	6	40000	2400	0.18
	10	30000	1800	0.1
	12	25000	1500	0.08
	16	20000	1000	0.06
	20	12000	800	0.05
	25	9000	600	0.04
	30	8000	500	0.04
	35	6500	300	0.02

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.

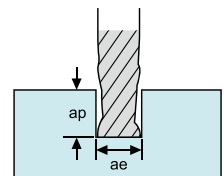


Recommended Cutting Conditions

**Table 051**  
**G550 Seires EPSRC2**

Material		Carbon Steels/Cast iron/Alloy Steels S50C/FC250/SCM/NAK		
Hardness		HRC 35~45		
Dia	EFF-L	RPM	Feed (mm/min)	ap (mm)
2.5mm	8	25000	2500	0.2
	12	20000	2000	0.15
	16	18000	1700	0.1
	20	12000	1000	0.08
	25	10000	700	0.07
	30	9000	600	0.06
3.0mm	8	20000	2000	0.3
	12	20000	1500	0.18
	16	15000	1400	0.15
	20	10000	800	0.1
	25	8000	600	0.08
	30	7000	450	0.06
	35	6000	300	0.05
4.0mm	10	20000	3200	0.3
	16	13000	2500	0.25
	20	11000	2200	0.22
	25	8000	1500	0.15
	30	6400	1200	0.12
	35	5000	700	0.08
5.0mm	16	12000	2500	0.35
	20	10000	1200	0.3
	25	8000	1000	0.25
	30	6000	900	0.2
	35	5100	750	0.15
6.0mm	20	10000	2000	0.4
	30	6000	1200	0.3
8.0mm	20	3200	910	0.18
	30	3000	800	0.15
	40	2600	600	0.12
10.0mm	25	2900	890	0.20
	35	2500	700	0.16
	45	2200	580	0.14
12.0mm	30	2500	710	0.22
	40	2300	500	0.18
	50	1900	420	0.16

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.

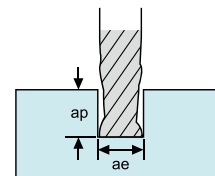


**Recommended Cutting Conditions**

**Table 052**  
**G550 Seires EPSRC4**

Material		Carbon Steels/Cast iron/Alloy Steels S50C/FC250/SCM/NAK		
Hardness		HRC 35~45		
Dia	EFF-L	RPM	Feed (mm/min)	ap (mm)
1.0mm	4	40000	3000	0.040
	8	36000	2400	0.030
	10	30000	1500	0.025
	12	20000	1000	0.020
	16	10000	500	0.005
1.5mm	6	40000	3200	0.060
	10	35000	2500	0.050
	12	32000	2400	0.050
	16	16000	1100	0.030
	20	10000	600	0.010
	25	9000	500	0.009
2.0mm	6	40000	4000	0.100
	10	35000	3500	0.080
	12	32000	3200	0.070
	16	24000	2400	0.050
	20	12000	1200	0.030
	25	10000	800	0.020
	30	5000	500	0.010
2.5mm	10	32000	4000	0.200
	12	28000	2500	0.120
	16	23000	1800	0.100
	20	20000	1500	0.060
	25	9000	1100	0.040
	30	2500	300	0.005
3.0mm	10	25000	3600	0.400
	12	23000	3000	0.300
	16	18000	2500	0.200
	20	15000	2000	0.150
	25	12000	1700	0.100
	30	7000	800	0.050
	35	5000	300	0.030

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.



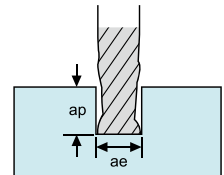


Recommended Cutting Conditions

**Table 053**  
**G550 Seires EPSRC4**

Material		Carbon Steels/Cast iron/Alloy Steels S50C/FC250/SCM/NAK		
Hardness		HRC 35~45		
Dia	EFF-L	RPM	Feed (mm/min)	ap (mm)
4mm	10	20000	3200	1.200
	12	18000	3000	1.000
	16	15000	2500	1.000
	20	12000	2000	0.500
	25	10000	1800	0.400
	30	8000	1300	0.200
5mm	20	12000	2300	1.000
	25	9500	1800	0.500
	30	6400	1200	0.200
6mm	20	11000	2200	1.200
	30	8000	1600	0.600
8mm	20	8000	1600	1.000
	30	4000	800	0.500
	40	4000	800	0.500
10mm	25	6400	1300	1.000
	35	3200	640	0.600
	45	3200	640	0.600
12mm	30	6000	1200	2.000
	40	3200	640	0.600
	50	3200	640	0.600

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.

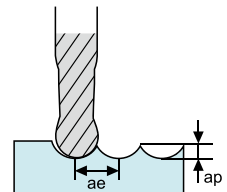


Recommended Cutting Conditions

**Table 054**  
**G550 Seires EPBRC2**

Material		PREHARDENED STEELS NAK80 CENA1				HARDENED STEELS SKD61,SKD11				Copper			
Hardness		HRC 35~45				HRC 40~55							
Radius	EFF-L	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)
R0.15	1.5	48000	480	0.010	0.010	41000	370	0.009	0.010	54000	640	0.014	0.015
	2	43000	370	0.008	0.008	37000	270	0.008	0.008	49000	530	0.011	0.011
	3	38000	320	0.007	0.006	32000	240	0.006	0.006	43000	460	0.009	0.010
	4	28000	200	0.003	0.004	24000	160	0.003	0.004	37000	300	0.004	0.006
	5	26000	125	0.001	0.003	18000	110	0.002	0.003	31000	200	0.002	0.004
R0.2	2	48000	590	0.018	0.024	37000	400	0.015	0.020	54000	790	0.022	0.036
	4	38000	400	0.009	0.012	30000	270	0.009	0.012	50000	640	0.012	0.018
	6	29000	260	0.005	0.006	26000	200	0.004	0.006	37000	360	0.006	0.010
	8	27000	170	0.003	0.003	23000	150	0.002	0.003	27000	200	0.003	0.006
R0.25	2	42000	750	0.022	0.036	32000	500	0.018	0.036	57000	1250	0.028	0.054
	4	38000	580	0.017	0.024	31000	400	0.014	0.024	55000	1010	0.021	0.036
	6	28000	400	0.008	0.012	27000	330	0.005	0.012	36000	610	0.009	0.018
	10	28000	400	0.008	0.012	27000	330	0.005	0.012	36000	460	0.009	0.018
R0.3	2	37000	770	0.027	0.144	37000	770	0.027	0.096	57000	1540	0.034	0.144
	4	35000	600	0.020	0.108	35000	600	0.020	0.072	54000	1130	0.026	0.108
	6	28000	460	0.016	0.072	28000	460	0.016	0.048	46000	960	0.019	0.072
	8	24000	400	0.009	0.054	24000	400	0.009	0.036	30000	570	0.010	0.054
	10	24000	330	0.006	0.036	24000	330	0.006	0.024	30000	490	0.007	0.036
	12	24000	330	0.006	0.036	24000	330	0.006	0.024	30000	490	0.007	0.036
R0.35	4	33000	600	0.035	0.042	26500	410	0.029	0.096	54500	1500	0.045	0.063
	8	12215	420	0.020	0.048	22500	355	0.012	0.048	32000	800	0.019	0.072
	10	22500	380	0.014	0.042	21500	330	0.011	0.042	26500	540	0.017	0.063
	12	21500	380	0.012	0.032	21500	320	0.010	0.042	23000	420	0.017	0.063
R0.4	4	31000	600	0.050	0.012	27000	440	0.041	0.120	55000	1860	0.063	0.018
	8	21000	430	0.021	0.060	22000	390	0.018	0.060	34000	1040	0.027	0.090
	12	19000	430	0.018	0.040	20000	350	0.016	0.060	16000	350	0.027	0.090
	16	16000	430	0.013	0.018	20000	310	0.014	0.060	7600	115	0.027	0.090
R0.45	4	32000	685	0.054	0.130	24500	460	0.043	0.180	50500	1900	0.067	0.190
R0.5	4	32000	770	0.057	0.240	22000	480	0.045	0.240	46000	2000	0.071	0.360
	6	26000	760	0.055	0.120	17600	480	0.009	0.120	39000	1500	0.071	0.180
	8	26000	760	0.034	0.120	17600	480	0.027	0.120	39000	1500	0.043	0.180
	12	17600	530	0.024	0.060	16500	420	0.018	0.060	18700	660	0.027	0.090
	16	15400	440	0.018	0.060	14300	360	0.014	0.060	18700	640	0.022	0.090
	22	14300	360	0.013	0.036	13200	300	0.009	0.036	18700	540	0.017	0.054

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.

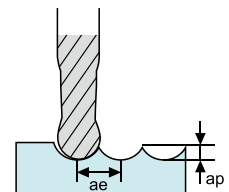


Recommended Cutting Conditions

**Table 055**  
**G550 Seires EPBRC2**

Material		PREHARDENED STEELS NAK80 CENA1				HARDENED STEELS SKD61,SKD11				Copper			
Hardness		HRC 35~45				HRC 40~55							
Radius	EFF-L	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)
R0.6	6	26000	770	0.068	0.240	18200	480	0.054	0.240	38000	2000	0.085	0.360
	10	16400	530	0.027	0.120	15100	420	0.022	0.120	24000	1080	0.036	0.180
	12	15300	530	0.027	0.120	14100	420	0.022	0.120	24000	1080	0.036	0.180
	16	13100	460	0.019	0.096	11900	380	0.016	0.096	15400	580	0.024	0.144
	20	12100	380	0.013	0.060	11000	320	0.009	0.096	15400	580	0.017	0.090
R0.7	24	11100	320	0.009	0.040	9800	290	0.070	0.040	15400	580	0.010	0.060
	6	17600	680	0.076	0.180	13600	440	0.063	0.180	28000	1470	0.099	0.270
	8	17600	680	0.079	0.180	13600	440	0.063	0.180	28000	1470	0.099	0.270
	12	13800	530	0.033	0.180	13600	420	0.027	0.180	19800	1080	0.042	0.270
R0.75	16	13100	480	0.027	0.120	11900	390	0.021	0.120	13200	620	0.033	0.180
	4	21000	1060	0.137	0.216	14800	660	0.110	0.216	30000	2200	0.171	0.324
	8	16300	700	0.084	0.180	12100	450	0.069	0.180	26000	1500	0.106	0.270
	12	16300	700	0.084	0.180	12100	450	0.069	0.180	26000	1500	0.106	0.270
	16	12400	480	0.027	0.120	11600	390	0.022	0.120	12100	620	0.036	0.180
	20	12400	480	0.016	0.060	11600	390	0.012	0.060	12100	620	0.019	0.090
R0.8	25	12400	440	0.016	0.060	11000	390	0.012	0.060	11000	500	0.019	0.090
	30	10900	400	0.016	0.060	11000	390	0.012	0.060	10700	450	0.019	0.090
	8	18900	940	0.126	0.216	13800	580	0.102	0.216	26000	1970	0.157	0.324
	12	15100	700	0.09	0.120	11500	440	0.072	0.120	25000	1490	0.112	0.180
R0.9	16	12300	530	0.036	0.096	11400	440	0.030	0.096	17600	110	0.046	0.144
	20	11500	480	0.030	0.060	10900	400	0.024	0.060	11000	630	0.036	0.090
	6	18400	1200	0.185	0.320	18400	738	0.150	0.320	32000	2600	0.230	0.021
R0.9	12	13800	700	0.094	0.180	10300	440	0.077	0.180	21000	1480	0.120	0.270
	16	10800	530	0.039	0.120	9900	420	0.031	0.120	15400	1080	0.048	0.180
	20	10200	480	0.031	0.060	9700	400	0.025	0.060	10500	630	0.039	0.090
	6	18500	1260	0.185	0.360	13200	960	0.150	0.360	22000	2140	0.232	0.540
R1.0	10	18500	1120	0.147	0.240	13200	870	0.120	0.240	22000	1920	0.185	0.360
	12	16000	990	0.133	0.240	11700	780	0.107	0.240	18700	1470	0.166	0.360
	16	16000	990	0.118	0.240	11700	780	0.090	0.240	18700	1470	0.148	0.360
	18	14700	580	0.074	0.120	11600	580	0.061	0.120	14300	1070	0.093	0.180
	20	14700	580	0.074	0.120	11600	580	0.061	0.120	14300	1070	0.093	0.180
	25	10600	450	0.058	0.120	10200	450	0.045	0.120	9500	630	0.074	0.180

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.



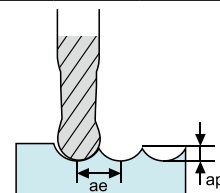
## Recommended Cutting Conditions

Table 056

## G550 Seires EPBRC2

Material		PREHARDENED STEELS NAK80 CENA1				HARDENED STEELS SKD61,SKD11				Copper				
Hardness		HRC 35~45				HRC 40~55								
Radius	EFF-L	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)	RPM	Feed (mm/min)	ap (mm)	ae (mm)	
R1.25	8	14500	1400	0.185	0.240	9700	1080	0.150	0.240	18400	2400	0.232	0.360	
	10	14500	1400	0.185	0.240	9700	1080	0.150	0.240	18400	2400	0.232	0.360	
	16	13500	1230	0.166	0.240	8400	980	0.135	0.240	16100	1810	0.208	0.360	
	20	10200	950	0.093	0.120	8400	980	0.074	0.120	11500	1330	0.116	0.180	
	25	8400	540	0.074	0.120	8400	560	0.061	0.120	6900	770	0.093	0.180	
R1.5	30	8400	540	0.033	0.060	8400	560	0.026	0.060	6900	770	0.040	0.090	
	8	12900	1680	0.222	0.360	9200	1300	0.180	0.360	15000	2890	0.278	0.540	
	12	12900	1510	0.222	0.360	9200	1170	0.180	0.360	15000	2600	0.278	0.540	
	16	11300	1330	0.166	0.360	8100	1040	0.135	0.360	12700	1970	0.029	0.504	
	20	11300	1330	0.166	0.360	8100	1040	0.135	0.360	12700	1970	0.029	0.504	
	25	8800	1040	0.111	0.180	8100	1040	0.090	0.180	10100	1450	0.139	0.270	
	30	8800	780	0.111	0.180	8100	780	0.090	0.180	10100	1450	0.139	0.270	
R2.0	35	7900	62	0.055	0.180	7500	650	0.045	0.180	6600	840	0.073	0.270	
	8	9700	1560	0.297	0.600	6800	1210	0.241	0.600	11500	2710	0.370	0.900	
	12	9700	1560	0.297	0.600	6800	1210	0.241	0.600	11500	2710	0.390	0.900	
	16	9700	1560	0.297	0.600	6800	1210	0.241	0.600	11500	2710	0.390	0.900	
	20	9700	1560	0.297	0.600	6800	1210	0.241	0.600	11500	2710	0.390	0.900	
	25	8400	1250	0.223	0.360	6000	980	0.180	0.36	10300	1850	0.279	0.540	
	30	8400	1250	0.223	0.360	6000	980	0.180	0.361	10300	1850	0.279	0.540	
R2.5	35	6600	950	0.148	0.360	6000	700	0.120	0.360	7500	1360	0.185	0.540	
	15	7800	1350	0.324	0.800	5600	1050	0.252	0.800	9600	2590	0.406	0.900	
	20	7800	1240	0.324	0.600	5600	950	0.252	0.600	9600	2100	0.406	0.900	
	25	7800	1240	0.324	0.600	5600	950	0.252	0.600	9600	2100	0.406	0.900	
R3.0	30	7800	760	0.243	0.600	4800	600	0.197	0.600	8200	1320	0.305	0.900	
	R3.0	15	7400	1670	0.443	1.200	5200	1300	0.360	1.200	8000	2530	0.555	1.800
	R4.0	25	7200	1200	0.5	1.000	5200	920	0.350	1.000	9000	2400	0.600	1.500
R5.0	30	6800	720	0.23	0.600	4600	570	0.190	0.570	7800	1300	0.300	0.900	
R6.0	30	6350	684	0.210	0.570	4370	541.5	0.181	0.550	7410	1235	0.285	0.855	

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.



## Recommended Cutting Conditions

Table 057

## G550 Seires EPCRC2

Material	CARBON STEEL / ALLOY STEEL SCM, SNCM, S45		ALLOY STEEL / TOOL STEEL SCM, SKT, SKD		PREHARDENED STEEL NAK80 CENA1	
	~HRC35		HRC35~45		HRC45~55	
Hardness	~HRC35		HRC35~45		HRC45~55	
Dia	RPM	Feed (mm/min)	RPM	Feed (mm/min)	RPM	Feed (mm/min)
1.0mm	33100	280	21600	120	13200	70
1.2mm	30000	300	18000	125	12000	70
1.5mm	26400	300	16200	130	10200	70
2.0mm	21600	310	13800	140	8640	80
2.5mm	18000	320	11400	150	7320	80
3.0mm	15900	330	10300	160	6300	80
4.0mm	12800	400	8200	200	5150	95
5.0mm	11000	500	7000	240	4560	120
6.0mm	9500	600	6000	300	3930	140
8.0mm	7200	640	4550	300	3020	140
10.0mm	6000	640	4000	300	2420	140
12.0mm	5000	500	3340	270	2000	120

Table 058

## G550 Seires EPCRC4

Material	CARBON STEEL / ALLOY STEEL SCM, SNCM, S45		ALLOY STEEL / TOOL STEEL SCM, SKT, SKD		PREHARDENED STEEL NAK80 CENA1	
	~HRC35		HRC35~45		HRC45~55	
Hardness	~HRC35		HRC35~45		HRC45~55	
Dia	RPM	Feed (mm/min)	RPM	Feed (mm/min)	RPM	Feed (mm/min)
2mm	21600	380	13800	280	8640	150
2.5mm	18000	390	11400	300	7320	150
3mm	15900	400	10300	310	6300	150
4mm	12800	500	8200	360	5150	160
5mm	11000	510	7000	430	4560	200
6mm	9500	510	6000	430	3930	200
8mm	7200	550	4550	430	3020	200
10mm	6000	550	4000	430	2420	200
12mm	5000	430	3340	380	2000	160

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.