

H680 Series for Hardened steel, up to HRC 65 (High Precision Cutting)



Solid Carbide Endmills

- Ultra grain carbide rods with better abrasion resistance.
- Use SICO-TH coating with anti-high temperature & anti-oxidation.
- Special geometry design, suitable for high hardened working materials.
- Comparable to Europe, America, Japan's tolerance with high precision and high performance on Finishing working situation.
- Long Tool life tools reduce tool costs and working cost effectively.

High Precision
High Speed High Hardened

Appearance	Series	Code No .	Ø Range	Num. of Teeth	Helix Angle	Coating	Working Materials							Page
							P	M	K	N	S	H		

H680 Series

for Hardened steel, up to HRC 65 (High Precision Cutting)

	Square Type - 4F 鎢鋼平銑刀 - 標準型 - 4 刃	EHSFF4, EHSSF4	Ø1~Ø12			SICO-TH	✓	✓	✓				✓	A014
	Long Shank Square Type - 4F 鎢鋼平銑刀 - 長柄型 - 4 刃	EHSLF4, EHSMF4 EHSNF4	Ø4~Ø12			SICO-TH	✓	✓	✓				✓	A015
	Ball Nose Type - 2F 鎢鋼球型銑刀 - 標準型 - 2 刃	EBBFF2, EHBSF2	0.5R~6R			SICO-TH	✓	✓	✓				✓	A016
	Long Shank Ball Nose Type - 2F 鎢鋼球型銑刀 - 長柄型 - 2 刃	EHBLF2, EHBNF2 EHBMF2	2R~6R			SICO-TH	✓	✓	✓				✓	A017
	Short Flute Ball Nose Type - 2F 鎢鋼球型銑刀 - 短刃型 - 2 刃	EBBPF2, EHBUF2	0.5R~6R			SICO-TH	✓	✓	✓				✓	A018
	Corner Radius Type - 4F 鎢鋼圓鼻銑刀 - 標準型 - 4 刃	EHCSF4	Ø3~Ø12			SICO-TH	✓	✓	✓				✓	A019
	Long Shank Corner Radius Type - 4F 鎢鋼圓鼻銑刀 - 長柄型 - 4 刃	EHCLF4, EHCMF4 EHCNF4	Ø4~Ø12			SICO-TH	✓	✓	✓				✓	A020

鎢鋼平銑刀 - 標準型 - 4 刃

- EHSFF4**
EHSSF4



d	Tolerance
$\varnothing \leq 6$	+0 ~ -0.01
$\varnothing \geq 8$	+0 ~ -0.02

鎢鋼平銑刀 - 長柄型 - 4刃

- ## Solid Carbide Endmills

A015

H680 - High Precision Ball Nose Type - 2F

鎢鋼球型銑刀 - 標準型 - 2 刃

- SICO-TH Nano coating provides a superior wear and heat resistance.
- Suitable for HRC 50 and over HRC 50 Hardened Steel, also maximum up to HRC 65.
- Ultra grain carbide rods with better abrasion resistance.
- R tolerance $\pm 5\mu\text{m}$ with high precision and high performance on Finishing working situation.
- Special geometry design, suitable for high hardened working materials.

EHBFF2
EHBSF2

P

M

K

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H

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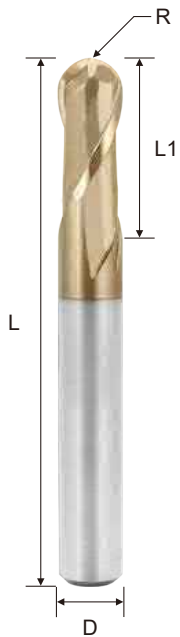
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UMG

SICO-TH

R

30°

HRC 65

Order No.	Radius (R)	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
EHBFF201000S	0.5R	1.0	2	50	4	2
EHBFF202000S	1.0R	2.0	4	50	4	2
EHBFF204000S	2.0R	4.0	8	50	4	2
EHBSF203000S	1.5R	3.0	6	50	6	2
EHBSF204000S	2.0R	4.0	8	50	6	2
EHBSF206000S	3.0R	6.0	12	50	6	2
EHBSF208000S	4.0R	8.0	16	60	8	2
EHBSF210000S	5.0R	10.0	20	75	10	2
EHBSF212000S	6.0R	12.0	24	75	12	2

Cutting conditions (建議切削參數表) : Table 007

R	Tolerance
≦ R3	± 0.005
≧ R4	± 0.007

Solid Carbide Endmills

鎢鋼球型銑刀 - 短刃型 - 2 刃

- EHBPF2**
EHBUF2



Cutting conditions (建議切削參數表): Table 007

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H680 - High Precision Corner Radius Type - 4F

鎢鋼圓鼻銑刀 - 標準型 - 4 刃

- SICO-TH Nano coating provides a superior wear and heat resistance.
- Suitable for HRC 50 and over HRC 50 Hardened Steel, also maximum up to HRC 65.
- Ultra grain carbide rods with better abrasion resistance.
- Special geometry design, suitable for high hardened working materials.

Solid Carbide Endmills

EHCSF4

P

M

K

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✓

✓

✓

□

□

✓



d	R Tolerance
$\varnothing \leq 6$	+0 ~ -0.01
$\varnothing \geq 8$	+0 ~ -0.02
R	± 0.01

Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
EHCSF403005S	3.0	0.5R	6	50	6	4
EHCSF404005S	4.0	0.5R	8	50	6	4
EHCSF404005S	4.0	0.5R	8	50	6	4
EHCSF406005S	6.0	0.5R	12	50	6	4
EHCSF406010S	6.0	1R	12	50	6	4
EHCSF408005S	8.0	0.5R	16	60	8	4
EHCSF408010S	8.0	1R	16	60	8	4
EHCSF410005S	10.0	0.5R	20	75	10	4
EHCSF410010S	10.0	1R	20	75	10	4
EHCSF412005S	12.0	0.5R	24	75	12	4
EHCSF412010S	12.0	1R	24	75	12	4

Cutting conditions (建議切削參數表) : Table 006

H680 - High Precision Long Shank Corner Radius Type - 4F

鎢鋼圓鼻銑刀 - 長柄型 - 4 刃

- SICO-TH Nano coating provides a superior wear and heat resistance.
- Suitable for HRC 50 and over HRC 50 Hardened Steel, also maximum up to HRC 65.
- Ultra grain carbide rods with better abrasion resistance.
- Special geometry design, suitable for high hardened working materials.

EHCLF4

EHCNF4

EHCMF4

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SICO-TH







Order No.	Dia. (d)	Corner Radius (R)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
EHCLF404005S	4	0.5R	8	75	6	4
EHCLF406005S	6	0.5R	12	75	6	4
EHCNF406005S	6	0.5R	12	100	6	4
EHCMF408005S	8	0.5R	16	75	8	4
EHCLF408005S	8	0.5R	16	100	8	4
EHCLF410005S	10	0.5R	20	100	10	4
EHCLF412005S	12	0.5R	24	100	12	4

Cutting conditions (建議切削參數表) : Table 006

d	R Tolerance
Ø ≤ 6	+0 ~ -0.02
Ø ≥ 8	+0 ~ -0.03
R	± 0.015