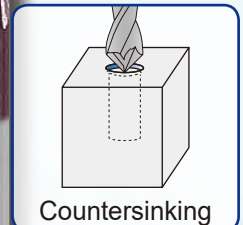
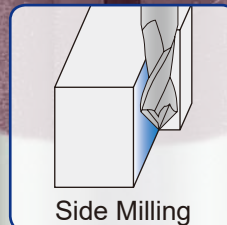
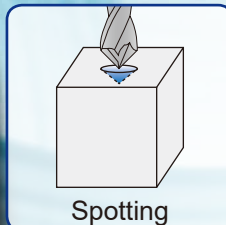
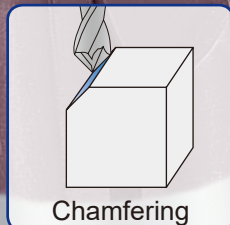
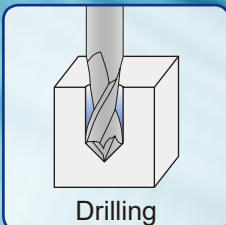
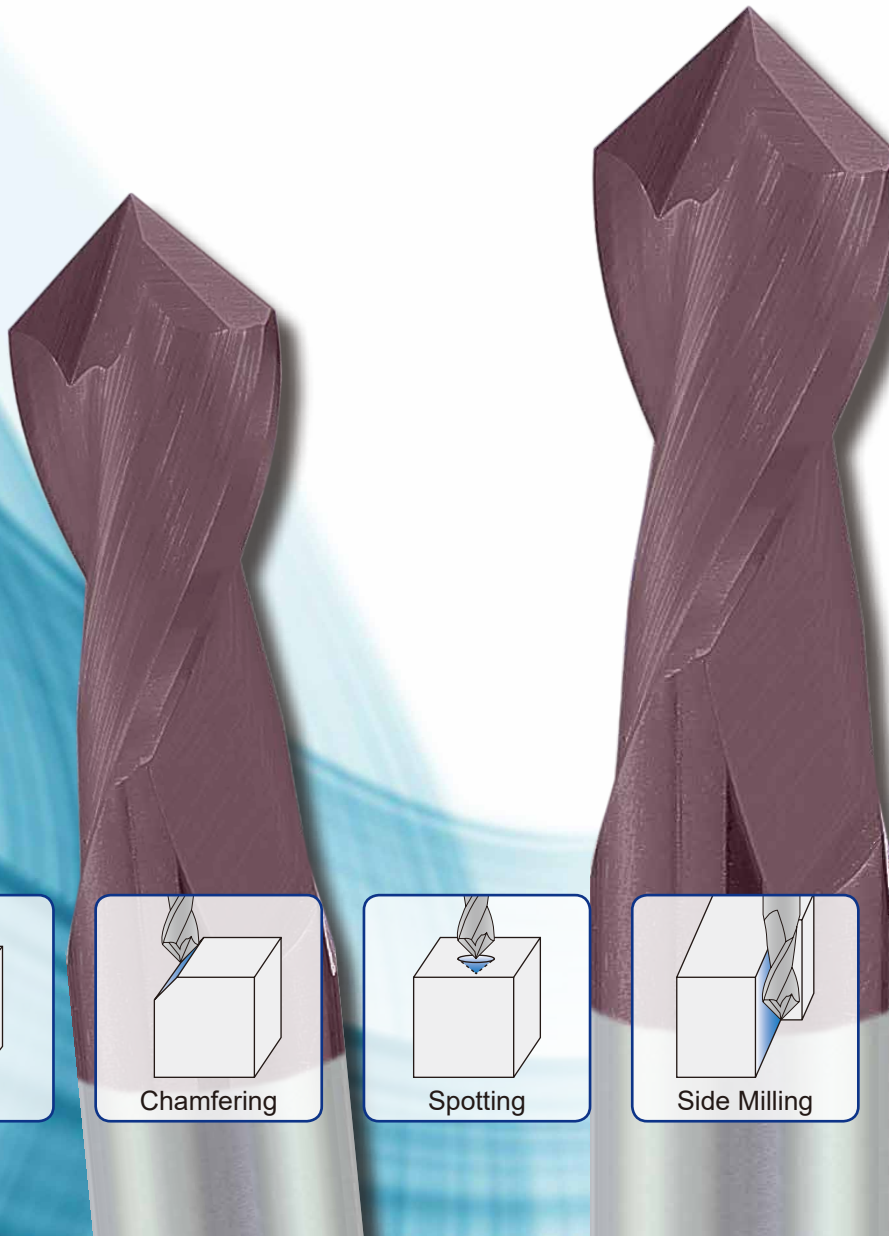


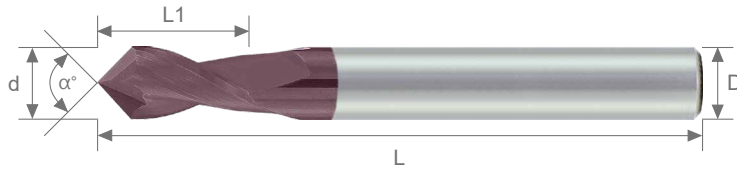
# EPFSC Series Solid Carbide Drill Mills

- **Multiple application :**  
*Drilling, Chamfering, Spotting, Side Milling, Countersinking.*
- **Suitable for Steel, Stainless steel and Aluminum alloy machining.**



## Solid Carbide Drill Mills - 2F

### EPFSC Series



Dia (d)	Tolerance
$\varnothing < 3$	0 ~ -0.02
$3 \leq \varnothing \leq 10$	0 ~ -0.03
$\varnothing > 10$	0 ~ -0.04

Order No.	Dia (d)	Flute Length (L1)	OAL (L)	Shank (D)	$\alpha^\circ$	Flutes (F)
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

### Recommended Cutting Conditions

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

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