

H680 Pro

2020 NEW

EHBUF Advanced Solid Carbide Ball Nose Endmills

New generation, high performance & high precision

An outstanding milling solution for high hardened materials

▶ **SICO Pro coating**

Improve heat and oxidation resistance.

▶ **Special SR geometry design**

Wear resistance, good chip discharge and high rigidity.

▶ **High precision with small tolerance**

$R \leq 3\text{mm}, \pm 5\mu\text{m}$; $R \geq 4\text{mm}, \pm 7\mu\text{m}$

▶ **For hardened materials from HRC 40 to HRC 60**

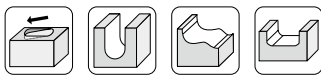
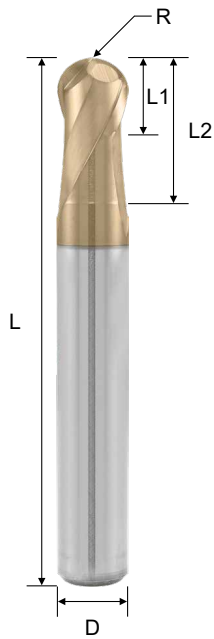
High-efficiency milling from roughing to high feed finishing.



H680 Pro - High Precision · Short with Neck · Ball Nose · 2F

- SICO Pro coating improve heat and oxidation resistance.
- Special SR geometry design with wear resistance, good chip discharge and high rigidity.
- For hardened materials milling from HRC 40 to HRC 60.
- High-efficiency for roughing and high feed finishing.
- SICO Pro coating includes Al, Ti, Si, N elements.

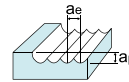
EHBUF



R	Tolerance
≤ R3	± 0.005
≥ R4	± 0.007

Order No.	Radius (R)	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
EHBUF241000PS	0.50R	1.0	1.0	2	50	4	2
EHBUF241500PS	0.75R	1.5	1.5	3	50	4	2
EHBUF242000PS	1.00R	2.0	2.0	4	50	4	2
EHBUF243000PS	1.50R	3.0	3.0	6	50	4	2
EHBUF244000PS	2.00R	4.0	4.0	8	50	4	2
EHBUF206000PS	3.00R	6.0	6.0	12	50	6	2
EHBUF208000PS	4.00R	8.0	8.0	16	60	8	2
EHBUF210000PS	5.00R	10.0	10.0	20	75	10	2
EHBUF212000PS	6.00R	12.0	12.0	24	75	12	2

Recommended Cutting Conditions



Work Material	Condition Range	Cutting Depth	Cutting Condition	Radius (R)						
				0.5R	1R	2R	3R	4R	5R	6R
Pre-Harden Steels (HRC 35~45) NAK80、CENA1	High Speed	ap=0.05~0.1	RPM	50000	32000	22000	16000	12000	10000	8000
		ae=0.02D	Feed(mm/min)	4000	3000	2850	2800	2400	2000	1600
	General	ap=0.05~0.1	RPM	36000	20000	13000	8500	6400	5000	4200
		ae=0.02D	Feed(mm/min)	1600	1500	1500	1400	1200	1060	920
Hardened Steels (HRC 45~55)SKD61、SKT4	High Speed	ap=0.05~0.1	RPM	50000	32000	20000	13000	10000	8000	6600
		ae=0.02D	Feed(mm/min)	3200	2560	2500	2200	1840	1600	1400
	General	ap=0.05~0.1	RPM	36000	20000	10000	6800	5200	4000	3500
		ae=0.02D	Feed(mm/min)	1280	1280	1280	1160	960	820	730
Hardened Steels (HRC 55~60)SKD11、SKH51	High Speed	ap=0.05~0.1	RPM	50000	32000	16000	11000	8000	6400	5300
		ae=0.15D	Feed(mm/min)	2000	2000	1920	1760	1400	1200	1060
	General	ap=0.05~0.1	RPM	25000	15000	9500	6500	4800	3800	3200
		ae=0.15D	Feed(mm/min)	1000	1000	960	960	840	720	640

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