

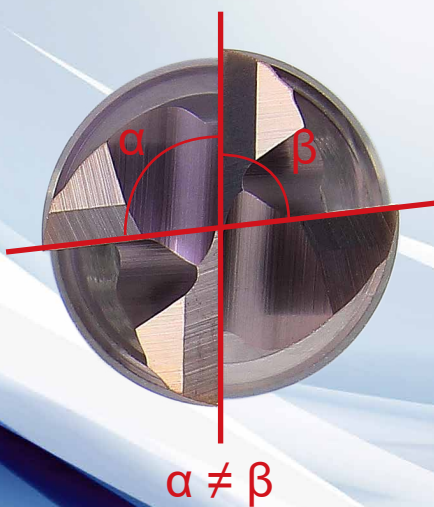
V470 Varix Endmills

High efficiency machining

NEW

- *High removal rate machining for steel.*
- *Unequal Flute Spacing design.*
- *Outstanding Anti-vibrations design.*
- *Low cutting force and burr prevention.*

Excellent chip evacuation



V470 CARBIDE ENDMILLS - VARIX SQUARE TYPE - 4F

EPSSV Series

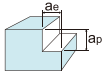


Work Material							
Carbon Steel (S45C, S55C)	Alloy Steel (SK, SCM)	Pre-Hardened Steel / Hardened Steel			Stainless Steel (SUS304, 306)	Cast Iron	Copper Alloy
		~ HRC 40	~ HRC 45	~ HRC 55			
◎	◎	◎	○	◎	◎	○	

Order No.	Dia (d)	Flute Length (L1)	OAL (L)	Shank (D)	Flutes (F)
EPSPV404000U	4	10	50	4	4
EPSSV403000U	3	8	50	6	4
EPSSV404000U	4	10	50	6	4
EPSSV406000U	6	15	50	6	4
EPSSV408000U	8	20	60	8	4
EPSSV410000U	10	25	75	10	4
EPSSV412000U	12	30	75	12	4

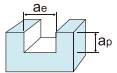
Recommended Cutting Conditions

Side Milling



Material	Carbon Steel / Alloy Steel / Cast iron				Alloy Steel / Tool Steel (SCM, SKT, SKD)				Pre-Hardened Steel (NAK80 CENA1)				Stainless Steel (SUS304, 306)			
Hardness	HB 180~250				HRC 20~30				HRC 30~45							
VC	130 m/min				120 m/min				100 m/min				75 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)	RPM	Feed (mm/min)	ap (mm)	ae (mm)
4mm	10400	1830	6	0.8	9500	1150	6	0.8	8000	800	6	0.8	6000	530	6	0.8
6mm	6900	2070	9	1.2	6400	1540	9	1.2	5300	1060	9	1.2	4000	640	9	1.2
8mm	5200	1770	12	1.6	4800	1540	12	1.6	4000	1040	12	1.6	3000	610	12	1.6
10mm	4100	1640	15	2	3800	1370	15	2	3200	900	15	2	2400	580	15	2

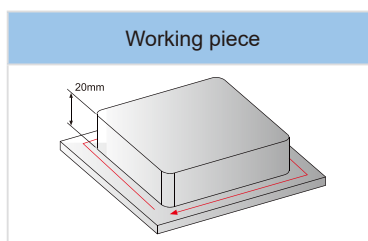
Slotting



Material	Carbon Steel / Alloy Steel / Cast iron				Alloy Steel / Tool Steel (SCM, SKT, SKD)				Pre-Hardened Steel (NAK80 CENA1)				Stainless Steel (SUS304, 306)			
Hardness	HB 180~250				HRC 20~30				HRC 30~45							
VC	100 m/min				90 m/min				80 m/min				60 m/min			
Dia	RPM	Feed (mm/min)	ap (mm)		RPM	Feed (mm/min)	ap (mm)		RPM	Feed (mm/min)	ap (mm)		RPM	Feed (mm/min)	ap (mm)	
4mm	8000	960	4		7200	720	4		6400	510	4		4800	400	2	
6mm	5300	1060	6		4800	900	6		4200	670	6		3200	310	3	
8mm	4000	910	8		3600	720	8		3200	640	8		2400	310	4	
10mm	3200	840	10		2900	700	10		2500	550	10		1900	310	5	

Cutting test studied

Cutting data	
End mill : Ø10mm, 4F	Vc : 314 m/min
Tooling : HSK 50	Vf : 8000 mm/min
Material : S45C	S : 10000 rev/min
	ap : 20 mm
	ae : 1 mm
	Q : 160 cm ³ /min



WINSTAR V470



Youtube



Youku

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