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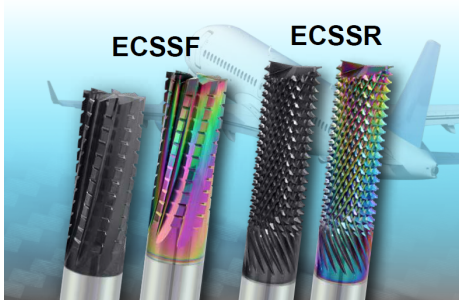
A300 Series



- For CFRP & GFRP composite material.
- ECSSF for finish machining.
- ECSSR for rough machining.
- Provide Diamond or NDLC coating.

- 適用於 CFRP & GFRP 複合材料
- ECSSF 適合精加工
- ECSSR 適合粗加工
- 提供鑽石或彩鑽塗層

A300 Series for CFRP/GFRP 適用 CFRP/GFRP 複合材料加工

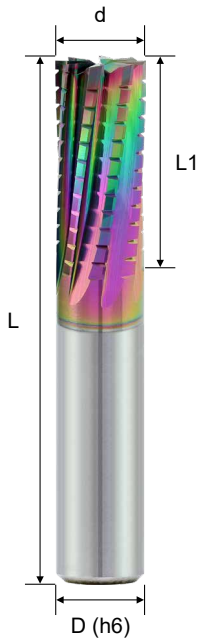
Appearance 外觀	Name 名稱	Code No. 編碼	Diameter 外徑	Helix 螺旋角	Coating 塗層	P	M	K	N	S	H	Page 頁碼
	Square · Finishing · 6F / 8F 平銑刀 - 精銑用・6 刃 / 8 刃	ECSSF	Ø6~Ø12	8°	NDLC				●			B199
	Square · Roughing · 8~17F 平銑刀 - 粗銑用・8~17 刃	ECSSR	Ø4~Ø12	±25°	NDLC				●			B200

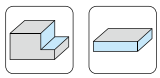
A300 - Square · Finishing · 6F / 8F 平銑刀 - 精銑用・6 刃 / 8 刃

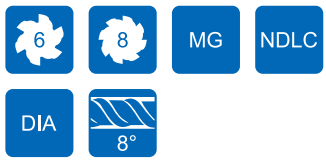
- For CFRP/GFRP multi-purpose finish milling.
- Multi flutes and fine nick geometry design.
- NDLC - Nano DLC coating provides exceptional wear resistance and good tool life.
- DIA - Diamond coating provides exceptional wear resistance and good tool life.

ECSSF

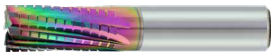
P	M	K	N	S	H
			●		







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

Order No. 訂購編碼	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (Z)
 NDLC Nano DLC coating					
ECSSF606000L	6	15	60	6	6
ECSSF608000L	8	20	75	8	6
ECSSF810000L	10	25	75	10	8
ECSSF812000L	12	30	100	12	8
DIA Diamond Coating					
ECSSF606000D	6	15	60	6	6
ECSSF608000D	8	20	75	8	6
ECSSF810000D	10	25	75	10	8
ECSSF812000D	12	30	100	12	8

Cutting conditions：Page B275

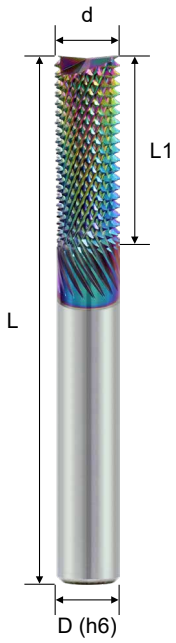
A300 - Square · Roughing · 8~17F

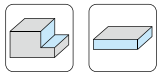
平銑刀 - 粗銑用 · 8~17 刃

- For CFRP/GFRP rough milling.
- Right helix and left helix design.
- NDLC - Nano DLC coating provides exceptional wear resistance and good tool life.
- DIA - Diamond coating provides exceptional wear resistance and good tool life.

ECSSR

P	M	K	N	S	H
			●		





MG NDLC DIA ±25°

Order No. 訂購編碼	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (Z)
NDLC Nano DLC coating					
ECSSR804000L	4	12	60	6	8
ECSSR106000L	6	18	60	6	11
ECSSR408000L	8	24	60	8	14
ECSSR610000L	10	30	75	10	16
ECSSR712000L	12	36	100	12	17
DIA Diamond Coating					
ECSSR804000D	4	12	60	6	8
ECSSR106000D	6	18	60	6	11
ECSSR408000D	8	24	60	8	14
ECSSR610000D	10	30	75	10	16
ECSSR712000D	12	36	100	12	17

Cutting conditions：Page B275

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

Recommended Cutting Conditions 建議切削參數

A300 Seires ECSSF

Material	CFRP		GFRP	
Vc	160 ~ 220 m/min		100 ~ 160 m/min	
Dia. (d)	RPM	fz (mm/tooth)	RPM	fz (mm/tooth)
6	10080	0.020	6900	0.020
8	7560	0.030	5170	0.030
10	6050	0.030	4140	0.030
12	5040	0.035	3450	0.035
	ap = 1.5d ae ≤ 0.35d			

A300 Seires ECSSR

Material	CFRP		GFRP	
Vc	140 ~ 200 m/min		90 ~ 140 m/min	
Dia. (d)	RPM	fz (mm/tooth)	RPM	fz (mm/tooth)
6	9020	0.020	6100	0.020
8	6760	0.030	4570	0.030
10	5410	0.030	3660	0.030
12	4510	0.035	3050	0.035
	ap = 2d ae ≤ 0.35d			

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.