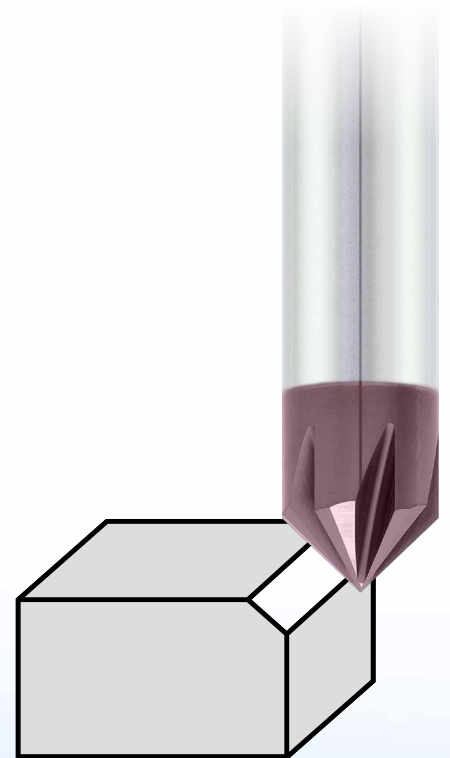


# G550 Solid Carbide Endmill for Chamfering

## EPFSA Series

## 整體硬質合金倒角銑刀

- **Designed for chamfer milling**  
專為倒角加工設計
- **Chamfering angle can be divided into 30° or 45°**  
倒角加工角度可分為 30° 或 45°



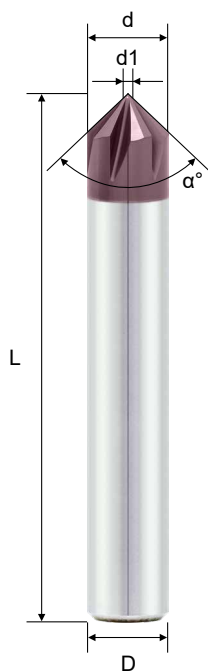
**Chamfering** 倒角加工

## G550 Carbide Endmills - Chamfer Type

硬質合金銑刀 - 倒角型

- Designed for chamfer milling.
- Chamfering angle can be divided into 30° or 45°.
- UNICO Coating provides superior wear resistance and reduces the coefficient of friction.
- Suitable for Steel, Alloy steel, Stainless steel, Cast iron, & Hardened steel.

### EPFSA

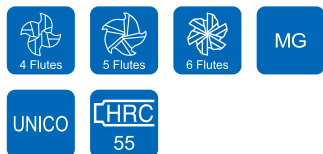
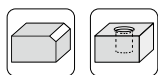


		Work Material 加工材料				
Carbon Steel 碳素鋼 (S45C, S55C)	Alloy Steel 合金鋼 (SK, SCM)	Hardened Steel 硬度鋼			Stainless Steel 不鏽鋼 (SUS304, 306)	Superalloy 高溫合金
		~ HRC 40	~ HRC 45	~ HRC 55		
◎	◎	◎	◎	◎	◎	◎

Order No. 訂購編碼	Dia. (d)	(d1)	OAL (L)	Shank (D)	α°	Flutes (F)
EPFSA404060U	4	0.5	50	4	60°	4
EPFSA406060U	6	1.0	60	6	60°	4
EPFSA508060U	8	1.5	60	8	60°	5
EPFSA610060U	10	1.5	75	10	60°	6
EPFSA612060U	12	2.0	75	12	60°	6
EPFSA404090U	4	0.5	50	4	90°	4
EPFSA406090U	6	1.0	60	6	90°	4
EPFSA508090U	8	1.5	60	8	90°	5
EPFSA610090U	10	1.5	75	10	90°	6
EPFSA612090U	12	2.0	75	12	90°	6

※ Use uncoating tools for **N** material machining. 若加工鋁料，請選擇無塗層刀具

### Recommended Cutting Conditions 建議切削參數



Material	Carbon Steel / Alloy Steel / Cast Iron 碳素鋼 / 合金鋼 / 鑄鐵		Alloy Steel / Tool Steel / Pre-Hardened Steel 合金鋼 / 工具鋼 / 預硬鋼 (SCM, SKT, SKD)				Stainless Steel 不鏽鋼 (SUS304, SUS316)				Hardened Steel 硬度鋼				
	HRC < 30		HRC 30 ~ 40				-				HRC 40 ~ 55				
VC	80 ~ 230 m/min		60 ~ 180 m/min				45 ~ 140 m/min				25 ~ 30 m/min				
d (mm)	fz (mm)	α = 60°		α = 90°		fz (mm)	α = 60°		α = 90°		fz (mm)	α = 60°		α = 90°	
		ap (mm)	ae (mm)	ap (mm)	ae (mm)		ap (mm)	ae (mm)	ap (mm)	ae (mm)		ap (mm)	ae (mm)	ap (mm)	ae (mm)
4	0.04	0.30	0.2	0.2	0.2	0.04	0.30	0.2	0.2	0.2	0.04	0.30	0.2	0.2	0.2
6	0.04	0.45	0.3	0.3	0.3	0.04	0.45	0.3	0.3	0.3	0.04	0.45	0.3	0.3	0.3
8	0.05	0.60	0.4	0.4	0.4	0.05	0.60	0.4	0.4	0.4	0.05	0.60	0.4	0.4	0.4
10	0.06	0.75	0.5	0.5	0.5	0.06	0.75	0.5	0.5	0.5	0.06	0.75	0.5	0.5	0.5
12	0.07	0.90	0.6	0.6	0.6	0.07	0.90	0.6	0.6	0.6	0.07	0.90	0.6	0.6	0.6

※ Effective Cutter Diameter = (d + d1)/2  
 For machining on two sides, Feed rate reduce 20~30%.  
 For vertical plunging, Feed rate reduce 30~40%.

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