



EDHT0402ER-CM

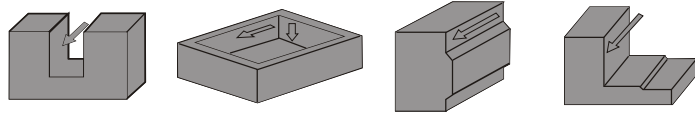


Endmill diameters:
8,8.5,9.0,9.5,10,10.5,11,11.5,12,12.5,13,13.5,14,16





EDHT High feed milling insert



Feature:

Sharp edged, perfect abrasive resistance, high stability and efficiency.

Performance exceed famous brand.

Application:

Stainless steel, Superalloy, low-carbon steel .

1. Compared with traditional EP and ED blades, the cutting strength of the CM groove type is small.
Specially for processing high-temperature alloys, stainless steel, alloys and soft steels.
2. Suitable for conditions where the power of the machine tool is relatively small.
3. CP2430 is suitable for type cutting or air cooling.



A-02

		PVD			parameters		
		CP2630TN	CP2430	CP1130FH			
					V _c (mm/min)		
Material group	P Steel	✳	✳		120-160-250		
	P P20,718,SKD11,S136H	✳	✳		100-130-160		
	P HRC40-63 Steel	✳		●	50-80-120		
	M Stainless steel	✳	✳	●	60-110-150		
	K Cast iron		✳	●	150-180-220		
	S Titanium alloy	✳	✳		40-60-80		
	S Superalloy	✳	✳	●	40-70-100		
Model specifications		Use			Ap(mm)	f (mm/ t)	
EDHT0402ER-CM		Stainless steel	✳	✳	●	0.15-0.4	0.2-0.5
		Ferroalloy					
		Superalloy					

EDHT0402ER-CM programming R angle is **R=1.5**

CP2430 Suitable For Dry Or Air-cooled Cutting



EDHT EPMT

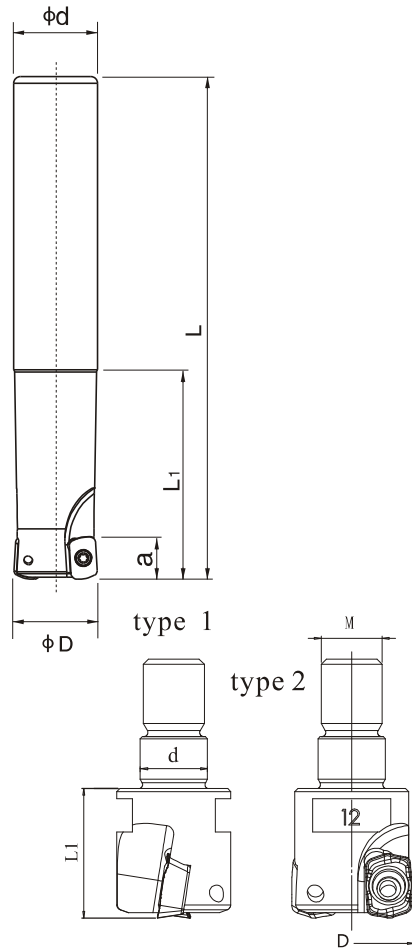


Material examples	Hardness	Grade	V _c m/min	fz mm/t / Ap mm
				EDHT0402
S45C, S50C	~220HB	CP2630TN CP2430	100-250	fz=0.15-0.4 Ap=0.2-0.5
20CrMoTi, 42CrMo	~200HB	CP2630TN CP2430	100-200	fz=0.15-0.4 Ap=0.2-0.5
SKD61 (H13), SKD11	350HB	CP2630TN CP1120H	100-150	fz=0.15-0.35 Ap=0.2-0.4
P20, 718, 738	HRC28-32	CP2630TN CP2430	100-180	fz=0.15-0.35 Ap=0.2-0.4
S136H, NAK80, 4Cr13	HRC30-40	CP2630TN CP2430	100-150	fz=0.1-0.3 Ap=0.2-0.4
SKD61 (H13)	HRC40-52	CP2630TN CP1130FH	80-120	fz=0.15-0.35 Ap=0.2-0.4
SKD11 (Cr12MoV)	HRC55-62	CP1120FH	50-80	fz=0.05-0.1 Ap=0.05-0.15
304, 316	200HB	CP2630TN CP2430 CP1130H	100-150	fz=0.2-0.5 Ap=0.2-0.4
718	HRC38-45	CP2630TN CP2430 CP1130FH	60-120	fz=0.1-0.3 Ap=0.2-0.35
Ti-6Al-4V (Tc4)	HRC40	CP2630TN CP2430	30-80	fz=0.3-0.6 Ap=0.2-0.4
FC250, HT250	~200HB	CP1130FH CP2430	100-220	fz=0.3-0.6 Ap=0.2-0.4
FCD400, QT300, 400, 500, 600	~200HB	CP1130FH CP2430	100-200	fz=0.3-0.6 Ap=0.2-0.4

CP2430 Suitable For Dry Or Air-cooled Cutting



Cutter tool ASR EDHT0402



Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

Designation	Z	type	mm					MS2040 MS2050	T6	EDHT0402	
			D	d	L	L1	M				
type 1	ASR-8X80-ED04-1T	1	1	8	8	80	16	MS2040 MS2050	T6	EDHT0402	
	ASR-10X80-ED04-2T	2	1	10	10	80	20				
	ASR-12X90-ED04-2T	2	1	12	12	90	25				
	ASR-14X100-ED04-3T-C16	3	1	14	16	100	35				
	ASR-16X100-ED04-4T	4	1	16	16	100	35				
type 2	ASR-8-ED04-1T-M4	1	2	8	4.5		11.5				M4
	ASR-8.5-ED04-1T-M4	1	2	8.5	4.5		11.5				M4
	ASR-9-ED04-1T-M4	1	2	9	4.5		11.5				M4
	ASR-9.5-ED04-1T-M4	1	2	9.5	4.5		11.5				M4
	ASR-10-ED04-2T-M5	2	2	10	5.5		12.5				M5
	ASR-10.5-ED04-2T-M5	2	2	10.5	5.5		12.5				M5
	ASR-11-ED04-2T-M5	2	2	11	5.5		12.5				M5
	ASR-11.5-ED04-2T-M5	2	2	11.5	5.5		12.5				M5
	ASR-12-ED04-2T-M6	2	2	12	6.5		12.5				M6
	ASR-12.5-ED04-2T-M6	2	2	12.5	6.5		12.5				M6
	ASR-13-ED04-2T-M6	2	2	13	6.5		14				M6
	ASR-13.5-ED04-2T-M6	2	2	13.5	6.5		14	M6			
	ASR-14-ED04-3T-M6	3	2	14	6.5		14	M6			
	ASR-15-ED04-4T-M6	4	2	15	6.5		14	M6			
	ASR-16-ED04-4T-M8	4	2	16	8.5		16.5	M8			