

MILLING

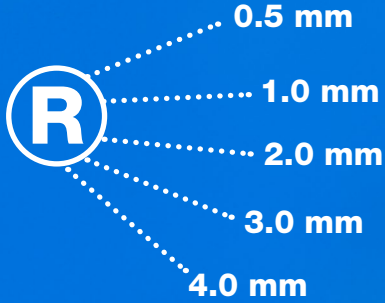
54-2024

OCTOBER 2024

METRIC

NPA

New Product Announcement



PVD Coating



High Productivity



ISO S



CHATTERFREE **Ti-TURBO**
 SOLID MILL LINE SOLID MILL LINE

Expanding ECK-H4M-CFR Solid Carbide Endmills Line with New Corner Radius for Several Diameters



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Highlights

ECK-H4M-CFR Solid Carbide Endmills with New Corner Radii and a Variety of Radii Options.

ISCAR is expanding the ECK-H4M-CFR CHATTERFREE line 2xD endmills. The endmills dedicated for machining titanium with high removal rates are now available with a variety of new corner radii. The new choice of corner radii expands ISCAR's market share and makes ECK-H4R-CF suitable for more applications.

Features

- Unique geometry
- Best chatter free tools for high removal rates when machining titanium (up to 2xD full slotting).
- 4 flute endmills with different helix and variable pitch.
- Large variety of corner radii.
- Grade IC900.

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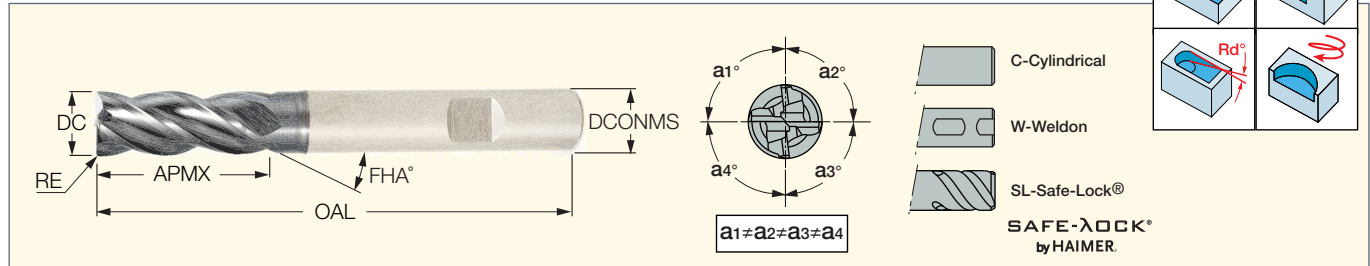
CHATTERFREE SOLID MILL LINE

TI-TURBO SOLID MILL LINE

ECK-H4M-CFR

Endmills with Different Helix, Chamfered Edges and Variable Pitch for Chatter Dampening on Titanium

<https://www.iscar.com/eCatalog/Family.aspx?fnum=3655&mapp=ML&GFSTYP=M&srch=1>



Designation	Dimensions											IC900	Recommended Machining Data f _z (mm/t)
	DC	DCONMS	APMX	OAL	NOF ⁽²⁾	RE	FHA	RMPX ⁽³⁾	Shank ⁽⁴⁾	CSP ⁽⁵⁾			
ECK-H4M 04-08C06CFR0.2-57	4.00	6.00	8.00	57.00	4	0.20	36.0	5.0	C	0	●	0.02-0.05	
NEW ECK-H4M 04-08C06CFR0.5-57	4.00	6.00	8.00	57.00	4	0.50	36.0	5.0	C	0	●	0.02-0.05	
ECK-H4M 05-10C06CFR0.2-57	5.00	6.00	10.00	57.00	4	0.20	36.0	5.0	C	0	●	0.02-0.05	
NEW ECK-H4M 06-12C06CFR0.2-57	6.00	6.00	12.00	57.00	4	0.20	36.0	5.0	C	0	●	0.03-0.06	
NEW ECK-H4M 06-12C06CFR0.5-57	6.00	6.00	12.00	57.00	4	0.50	36.0	5.0	C	0	●	0.03-0.06	
NEW ECK-H4M 06-12C06CFR1-57	6.00	6.00	12.00	57.00	4	1.00	36.0	5.0	C	0	●	0.03-0.06	
ECK-H4M 06-12W06CFR0.2-57	6.00	6.00	12.00	57.00	4	0.20	36.0	5.0	W	0	●	0.03-0.06	
ECK-H4M 08-16C08CFR0.4-63	8.00	8.00	16.00	63.00	4	0.40	36.0	5.0	C	0	●	0.03-0.06	
NEW ECK-H4M 08-16C08CFR0.5-63	8.00	8.00	16.00	63.00	4	0.50	36.0	5.0	C	0	●	0.03-0.06	
NEW ECK-H4M 08-16C08CFR1-63	8.00	8.00	16.00	63.00	4	1.00	36.0	5.0	C	0	●	0.03-0.06	
ECK-H4M 08-16W08CFR0.4-63	8.00	8.00	16.00	63.00	4	0.40	36.0	5.0	W	0	●	0.03-0.06	
ECK-H4 10-20SL10CFR.5-72C ⁽¹⁾	10.00	10.00	20.00	72.00	4	0.50	36.0	5.0	SL	1	●	0.03-0.07	
ECK-H4 10-20SL10CFR0.5-72 ⁽¹⁾	10.00	10.00	20.00	72.00	4	0.50	36.0	5.0	SL	0	●	0.03-0.07	
ECK-H4M 10-20C10CFR0.5-72	10.00	10.00	20.00	72.00	4	0.50	36.0	5.0	C	0	●	0.03-0.07	
NEW ECK-H4M 10-20C10CFR1-72	10.00	10.00	20.00	72.00	4	1.00	36.0	5.0	C	0	●	0.03-0.07	
NEW ECK-H4M 10-20C10CFR2-72	10.00	10.00	20.00	72.00	4	2.00	36.0	5.0	C	0	●	0.03-0.07	
NEW ECK-H4M 10-20C10CFR3-72	10.00	10.00	20.00	72.00	4	3.00	36.0	5.0	C	0	●	0.03-0.07	
ECK-H4M 10-20W10CFR0.5-72	10.00	10.00	20.00	72.00	4	0.50	36.0	5.0	W	0	●	0.03-0.07	
ECK-H4 12-24SL12CFR0.6-83 ⁽¹⁾	12.00	12.00	24.00	83.00	4	0.60	36.0	5.0	SL	0	●	0.04-0.08	
ECK-H4M 12-24C12CFR0.6-83	12.00	12.00	24.00	83.00	4	0.60	36.0	5.0	C	0	●	0.04-0.08	
NEW ECK-H4M 12-24C12CFR1-83	12.00	12.00	24.00	83.00	4	1.00	36.0	5.0	C	0	●	0.04-0.08	
NEW ECK-H4M 12-24C12CFR2-83	12.00	12.00	24.00	83.00	4	2.00	36.0	5.0	C	0	●	0.04-0.08	
NEW ECK-H4M 12-24C12CFR3-83	12.00	12.00	24.00	83.00	4	3.00	36.0	5.0	C	0	●	0.04-0.08	
ECK-H4M 12-24W12CFR0.6-83	12.00	12.00	24.00	83.00	4	0.60	36.0	5.0	W	0	●	0.04-0.08	
ECK-H4 16-32SL16CFR.8-92C ⁽¹⁾	16.00	16.00	32.00	92.00	4	0.80	36.0	5.0	SL	1	●	0.05-0.08	
ECK-H4 16-32SL16CFR0.8-92 ⁽¹⁾	16.00	16.00	32.00	92.00	4	0.80	36.0	5.0	SL	0	●	0.05-0.08	
ECK-H4M 16-32C16CFR0.8-92	16.00	16.00	32.00	92.00	4	0.80	36.0	5.0	C	0	●	0.05-0.08	
NEW ECK-H4M 16-32C16CFR1-92	16.00	16.00	32.00	92.00	4	1.00	36.0	5.0	C	0	●	0.05-0.08	
NEW ECK-H4M 16-32C16CFR2-92	16.00	16.00	32.00	92.00	4	2.00	36.0	5.0	C	0	●	0.05-0.08	
NEW ECK-H4M 16-32C16CFR3-92	16.00	16.00	32.00	92.00	4	3.00	36.0	5.0	C	0	●	0.05-0.08	
NEW ECK-H4M 16-32C16CFR4-92	16.00	16.00	32.00	92.00	4	4.00	36.0	5.0	C	0	●	0.05-0.08	
ECK-H4M 16-32W16CFR0.8-92	16.00	16.00	32.00	92.00	4	0.80	36.0	5.0	W	0	●	0.05-0.08	
ECK-H4 20-40SL20CFR1.-104 ⁽¹⁾	20.00	20.00	40.00	104.00	4	1.00	36.0	5.0	SL	0	●	0.05-0.08	
ECK-H4M 20-40C20CFR1.-104	20.00	20.00	40.00	104.00	4	1.00	36.0	5.0	C	0	●	0.05-0.08	
ECK-H4M 20-40W20CFR1.-104	20.00	20.00	40.00	104.00	4	1.00	36.0	5.0	W	0	●	0.05-0.08	

⁽¹⁾ With Safe-Lock® (by Haimer) pull-out prevention helical grooves

⁽²⁾ Number of flutes

⁽³⁾ Maximum ramping angle

⁽⁴⁾ C-Cylindrical, W-Weldon, SL-Safe-Lock® (by Haimer)

⁽⁵⁾ 0 - Without coolant supply, 1 - With coolant supply