MILLING

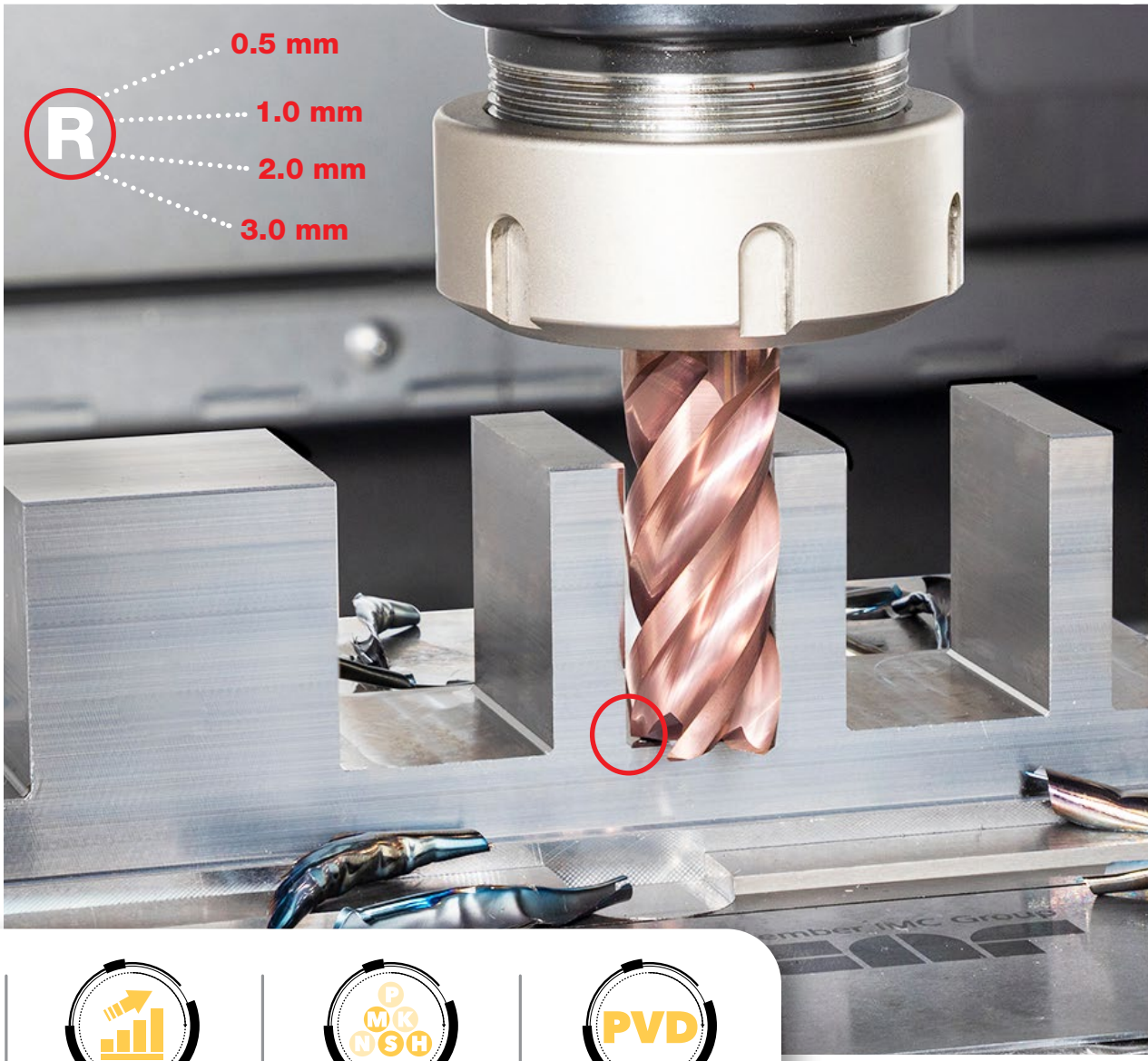
28-2024

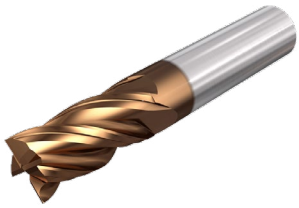
JUNE 2024

METRIC

NPA

New Product Announcement





High Productivity

ISO M, S, H

PVD Coated

Member IMC Group

ISCAR

CHATTERFREE

SOLID MILL LINE

Expanding EC-E4M-CF Solid Carbide Endmills with a New Corner Radius

NPA New Product Announcement

CHATTERFREE
SOLID MILL LINE


High Productivity

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Highlights

EC-E4M-CF Solid Carbide Endmills with A New Corner Radius

As a follow-up to NPA 04-2023, ISCAR is expanding the EC-E4M **CHATTERFREE** line of 2xD endmills with a variety of new corner radii.

The new choice of corner radii expands our market share and makes EC-E4M suitable for more applications. EC-E4M endmill cutters, known to be highly efficient and very popular, have a relatively short neck length that improves performance in shoulder applications with shorter tool overhangs.

The hard-submicron-substrate PVD-coated, bronze-colored IC608 carbide grade, which possesses high resistance to abrasive and oxidation wear, is a first-choice grade for machining ISO S, M, and H material groups.

Applications:

- Milling stainless steel at moderate to high cutting speeds.
- Milling hardened steel (45-60HRc) at moderate to high cutting speeds.
- Milling alloy steel at moderate to high cutting speeds.


Click for Short Video

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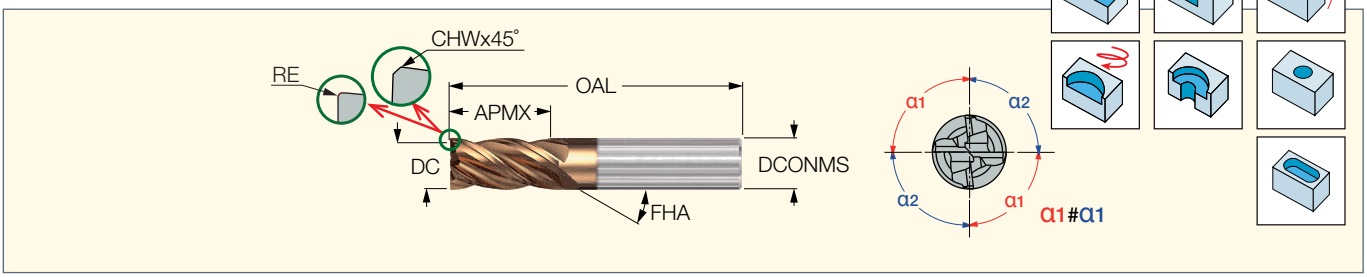
CHATTERFREE
SOLID MILL LINE

EC-E4M-CF

4 Flute, 38° Helix Endmills, up to 2XD depth of cut with Variable Pitch for Chatter Dampening
https://www.iscar.com/eCatalog/Family.aspx?fnum=4805&mapp=ML&GFSTYP=M&srch=1



Designation	Dimensions DC	DCONMS	APMX	OAL	NOF(1)	FHA	RMPX°(2)	Shank	CHW	KCH	RE	IC608	Recommended Machining Data f_z (mm/t)
EC-E4M 06-12C06CF-57	6.00	6.00	12.00	50.00	4	38.0	5.0	C	0.25	45.0	-	●	0.03-0.07
New EC-E4M 06-12C06CFR0.5-57	6.00	6.00	12.00	50.00	4	38.0	5.0	C	-	-	0.50	●	0.03-0.07
New EC-E4M 06-12C06CFR1-57	6.00	6.00	12.00	50.00	4	38.0	5.0	C	-	-	1.00	●	0.03-0.07
EC-E4M 08-16C08CF-63	8.00	8.00	16.00	63.00	4	38.0	5.0	C	0.30	45.0	-	●	0.03-0.09
New EC-E4M 08-16C08CFR0.5-63	8.00	8.00	16.00	63.00	4	38.0	5.0	C	-	-	0.50	●	0.03-0.09
New EC-E4M 08-16C08CFR1-63	8.00	8.00	16.00	63.00	4	38.0	5.0	C	-	-	1.00	●	0.03-0.09
EC-E4M 10-20C10CF-72	10.00	10.00	20.00	72.00	4	38.0	5.0	C	0.40	45.0	-	●	0.03-0.10
New EC-E4M 10-20C10CFR0.5-72	10.00	10.00	20.00	72.00	4	38.0	5.0	C	-	-	0.50	●	0.03-0.10
New EC-E4M 10-20C10CFR1-72	10.00	10.00	20.00	72.00	4	38.0	5.0	C	-	-	1.00	●	0.03-0.10
New EC-E4M 10-20C10CFR2-72	10.00	10.00	20.00	72.00	4	38.0	5.0	C	-	-	2.00	●	0.03-0.10
New EC-E4M 10-20C10CFR3-72	10.00	10.00	20.00	72.00	4	38.0	5.0	C	-	-	3.00	●	0.03-0.10
EC-E4M 12-24C12CF-83	12.00	12.00	24.00	83.00	4	38.0	5.0	C	0.50	45.0	-	●	0.04-0.11
New EC-E4M 12-24C12CFR0.5-83	12.00	12.00	24.00	83.00	4	38.0	5.0	C	-	-	0.50	●	0.04-0.11
New EC-E4M 12-24C12CFR1-83	12.00	12.00	24.00	83.00	4	38.0	5.0	C	-	-	1.00	●	0.04-0.11
New EC-E4M 12-24C12CFR2-83	12.00	12.00	24.00	83.00	4	38.0	5.0	C	-	-	2.00	●	0.04-0.11
New EC-E4M 12-24C12CFR3-83	12.00	12.00	24.00	83.00	4	38.0	5.0	C	-	-	3.00	●	0.04-0.11
EC-E4M 12-24W12CF-83	12.00	12.00	24.00	83.00	4	38.0	5.0	W	0.50	45.0	-	●	0.04-0.11
EC-E4M 16-32C16CF-100	16.00	16.00	32.00	100.00	4	38.0	5.0	C	0.60	45.0	-	●	0.05-0.13
New EC-E4M 16-32C16CFR1-100	16.00	16.00	32.00	100.00	4	38.0	5.0	C	-	-	1.00	●	0.05-0.13
New EC-E4M 16-32C16CFR2-100	16.00	16.00	32.00	100.00	4	38.0	5.0	C	-	-	2.00	●	0.05-0.13
New EC-E4M 16-32C16CFR3-100	16.00	16.00	32.00	100.00	4	38.0	5.0	C	-	-	3.00	●	0.05-0.13
EC-E4M 16-32W16CF-100	16.00	16.00	32.00	100.00	4	38.0	5.0	W	0.60	45.0		●	0.05-0.13

(1) Number of flutes
(2) Maximum ramping angle