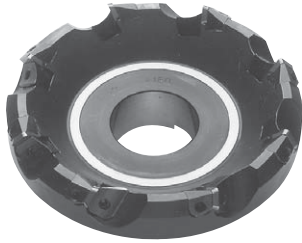
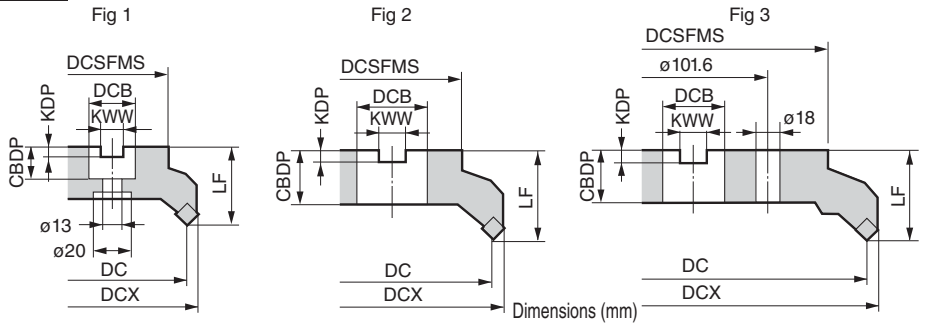


General Milling for Steel and Hard-to-cut Material



Body Inch



Cat. No.	Stock	Diameter		Boss	Height	Hole Size	Grooving Width	Grooving Depth	Mounting Depth	No. of Teeth	Weight (kg)	Fig
		DC	DCX									
EHG 4080R	●	*80	95	60	50	25.4	9.5	6	25	4	1.3	1
4100R	●	100	114	70	50	31.75	12.7	8	32	5	2.0	2
4125R	●	125	138	80	63	38.1	15.9	10	38	6	3.3	2
4160R	●	160	173	100	63	50.8	19.1	11	38	8	4.8	2
4200R	●	200	213	130	63	47.625	25.4	13.5	35	10	7.1	3
EHG 5080R		*80	100	60	50	25.4	9.5	6	25	4	1.5	1
5100R		100	118	70	50	31.75	12.7	8	32	5	2.2	2
5125R		125	143	80	63	38.1	15.9	10	38	6	3.6	2
5160R		160	178	100	63	50.8	19.1	11	38	8	5.2	2
5200R		200	218	130	63	47.625	25.4	13.5	35	10	7.6	3

Inserts are not included.



*Please use JIS B1176 hexagonal bolt (M12x30 to 35mm) for securing ø80 cutter to the arbor.

Insert

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metal S Exotic Alloy H Hardened Steel

Grade	Coated Carbide					Carbide		Cermet	Dimensions		Fig
	High Speed/Light	General Purpose	General Purpose	General Purpose	General Purpose	A30N	G10E	T250A	IC	S	
Application	P	M	K	M		P	K	P			
Application		M	K								
Cat. No.	ACP100	ACP200	ACP300	ACK200	ACK300	EH20Z					
SECN 42MT							●		12.70	3.18	4
42M									12.70	3.18	4
SEEN 42MT	●	●	●						12.70	3.18	6*
SEKN 42MT	●	●	●				●		12.70	3.18	5(6)
42MT-W								●	12.70	3.18	6
42M				●	●	●		●	12.70	3.18	5(6)
*SENN 1203AFTN	●						●		12.70	3.18	6
SEMR 1203AFEN	●						●		12.70	3.18	7
**SEER 1203AFEN	●						●		12.70	3.18	7
SECN 53MT									15.875	4.76	4
53M									15.875	4.76	4
SEKN 53MT	●	●	●				●		15.875	4.76	6
53M				●	●			●	15.875	4.76	6

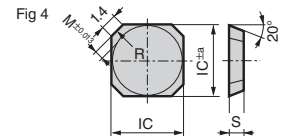
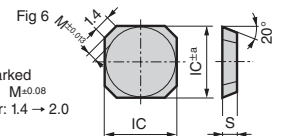
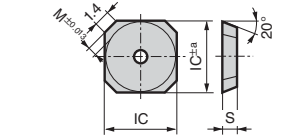
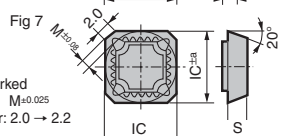


Fig 5 (ACP / ACK Series Grades)



Note: Item marked M±0.08 Chamfer: 1.4 → 2.0

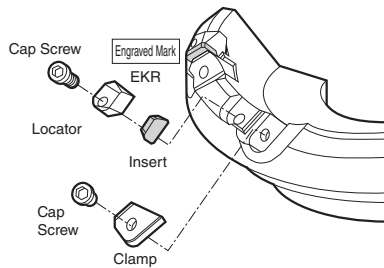


Note: Item marked M±0.025 Chamfer: 2.0 → 2.2

* Shape of E class inserts differ slightly from the above figures.

Applicable Insert

Body	Inserts
EHG4000 Type	SEON42 · · SEON12 · ·
EHG5000 Type	SEON53 · ·



Parts

Applicable Cutters	Locator	Clamp	Cap Screw		Wrench
			Size	Nm	
EHG4000R Type	EHK4R	EHW4R	EHBX0512	M5 5.0	TH040
EHG5000R Type	EHK5R	EHW5R	EHBX0512	M5 5.0	TH040

Recommended Tightening Torque (N·m)

Recommended Cutting Conditions

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min. - Optimum - Max.	Feed Rate f_z (mm/t) Min. - Optimum - Max.	Grade
P	General Steel	180 to 280HB	160-205-250	0.10-0.15-0.20	ACP200
	Soft Steel	≤180HB	160-230-300	0.10-0.18-0.25	ACP200
	Die Steel	200 to 220HB	80-100-120	0.10-0.18-0.25	ACP200
M	Stainless Steel	—	160-180-200	0.10-0.20-0.30	ACP300
K	Cast Iron	250HB	80-100-120	0.10-0.20-0.30	ACK200

Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.