

# NPA

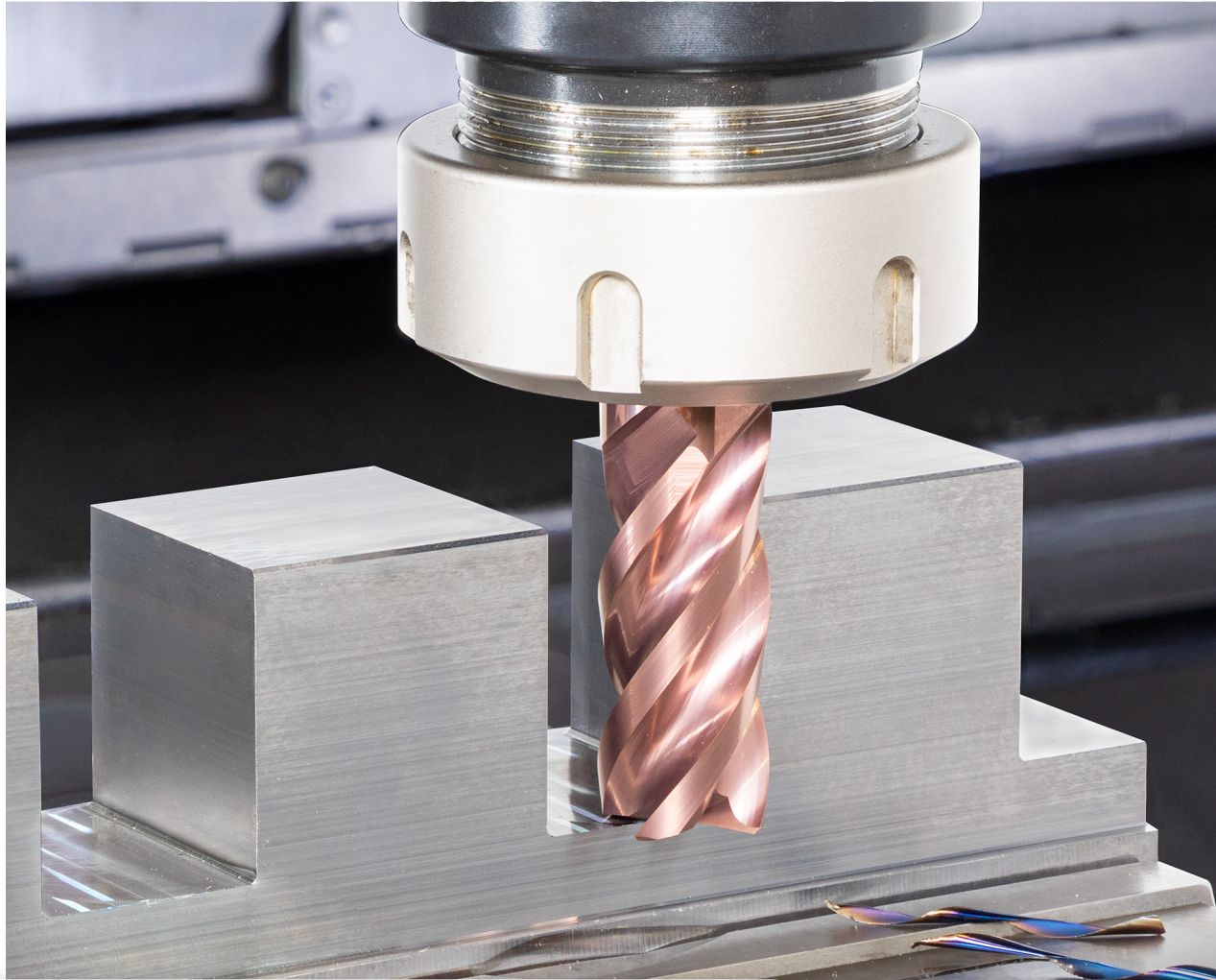
New Product Announcement

MILLING

06-2023

FEBRUARY 2023

IMPERIAL



Higher Productivity



Variable Pitch and Helix Design



PVD Coated



**CHATTERFREE**  
SOLID MILL LINE

**ECI-H4M-CF CHATTERFREE**  
**4 FLUTE, 2xD IC608**

## IMPERIAL



Higher  
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Variable Pitch and  
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New Product Announcement

## **CHATTERFREE**

SOLID MILL LINE

### Highlights

#### **New CHATTERFREE Extension for Four-Flute Solid Carbide Endmills ECI-H4M-CF Made with IC608**

ISCAR expands CHATTERFREE four-flute ECI-H4M-CF endmills with new tools that feature a variable-pitch and different helix design intended for chatter dampening with new coatings for all tool diameters.

The new endmills provide a 2XD maximum depth and made of IC608 carbide grade.

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

#### **Applications:**

Milling stainless steel a 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.

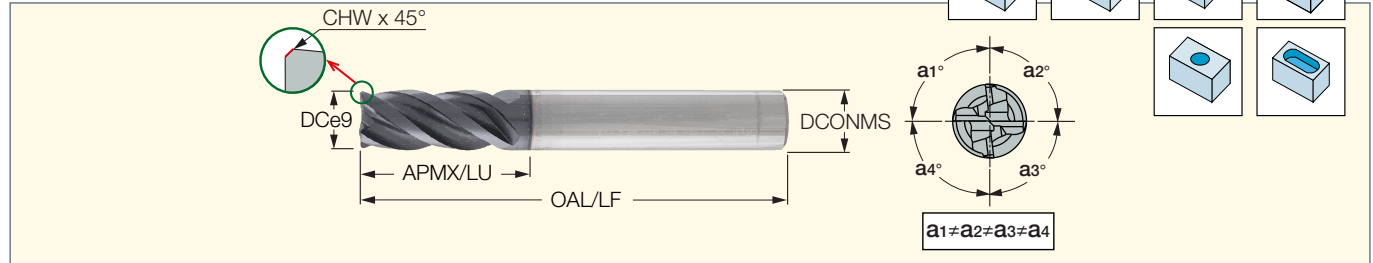
[Click for Short Video](#)

### CHATTERFREE SOLID MILL LINE

#### ECI-H4M-CF-E

4 Flute Endmills with Different Helix and Variable Pitch, for Chatter Dampening

<https://www.iscar.com/eCatalog/Family.aspx?fnm=3737&mapp=ML&GFSTYP=I>



Designation	Dimensions									Tough ↔ Hard		Recommended Machining Data  f <sub>z</sub> (inch/t)
	DC	DCONMS	LU	OAL	NOF <sup>(1)</sup>	CHW	KCH	RMPX <sup>(2)</sup>	Shank <sup>(3)</sup>	IC900	IC608	
ECI-H4M 125-250C125CFE1.5	.125	.125	.250	1.500	4	.006	45.00	5.0	C	●		.0010-.0020
<b>NEW</b> ECI-H4M125-250C125E1.5IC6	.125	.125	.250	1.500	4	.006	45.00	5.0	C		●	.0010-.0020
ECI-H4M 188-375C188CFE2.	.188	.188	.375	2.000	4	.008	45.00	5.0	C	●		.0010-.0020
<b>NEW</b> ECI-H4M188-375C188E2.IC6	.188	.188	.375	2.000	4	.008	45.00	5.0	C		●	.0010-.0020
ECI-H4M 250-500C250CFE2.5	.250	.250	.500	2.500	4	.010	45.00	5.0	C	●		.0010-.0020
<b>NEW</b> ECI-H4M250-500C250E2.5IC6	.250	.250	.500	2.500	4	.010	45.00	5.0	C		●	.0010-.0020
ECI-H4M 312-625C312CFE2.5	.312	.312	.625	2.500	4	.012	45.00	5.0	C	●		.0010-.0040
<b>NEW</b> ECI-H4M312-625C312E2.5IC6	.312	.312	.625	2.500	4	.012	45.00	5.0	C		●	.0010-.0040
ECI-H4M 375-750C375CFE3.	.375	.375	.750	3.000	4	.016	45.00	5.0	C	●		.0010-.0040
ECI-H4M 375-750W375CFE3.	.375	.375	.750	3.000	4	.016	45.00	5.0	W	●		.0010-.0040
<b>NEW</b> ECI-H4M375-750C375E3.IC6	.375	.375	.750	3.000	4	.016	45.00	5.0	C		●	.0010-.0040
<b>NEW</b> ECI-H4M375-750W375E3.IC6	.375	.375	.750	3.000	4	.016	45.00	5.0	W		●	.0010-.0040
ECI-H4M 500-1.0C500CFE3.5	.500	.500	1.000	3.500	4	.020	45.00	5.0	C	●		.0020-.0040
ECI-H4M 500-1.0W500CFE3.5	.500	.500	1.000	3.500	4	.020	45.00	5.0	W	●		.0020-.0040
<b>NEW</b> ECI-H4M500-1.0C500E3.5IC6	.500	.500	1.000	3.500	4	.020	45.00	5.0	C		●	.0020-.0040
<b>NEW</b> ECI-H4M500-1.0W500E3.5IC6	.500	.500	1.000	3.500	4	.020	45.00	5.0	W		●	.0020-.0040
ECI-H4M 625-1.25C625CFE4.	.625	.625	1.250	4.000	4	.024	45.00	5.0	C	●		.0020-.0050
ECI-H4M 625-1.25W625CFE4.	.625	.625	1.250	4.000	4	.024	45.00	5.0	W	●		.0020-.0050
<b>NEW</b> ECI-H4M625-1.25C625E4.IC6	.625	.625	1.250	4.000	4	.024	45.00	5.0	C		●	.0020-.0050
<b>NEW</b> ECI-H4M625-1.25W625E4.IC6	.625	.625	1.250	4.000	4	.024	45.00	5.0	W		●	.0020-.0050
ECI-H4M 750-1.5C750CFE5.	.750	.750	1.500	5.000	4	.024	45.00	5.0	C	●		.0020-.0070
ECI-H4M 750-1.5W750CFE5.	.750	.750	1.500	5.000	4	.024	45.00	5.0	W	●		.0020-.0070
<b>NEW</b> ECI-H4M750-1.5C750E5.IC6	.750	.750	1.500	5.000	4	.024	45.00	5.0	C		●	.0020-.0070
<b>NEW</b> ECI-H4M750-1.5W750E5.IC6	.750	.750	1.500	5.000	4	.024	45.00	5.0	W		●	.0020-.0070
ECI-H4M 1.0-2.0C1.0CFE5.	1.000	1.000	2.000	5.000	4	.024	45.00	5.0	C	●		.0020-.0070
ECI-H4M 1.0-2.0W1.0CFE5.	1.000	1.000	2.000	5.000	4	.024	45.00	5.0	W	●		.0020-.0070
<b>NEW</b> ECI-H4M1.0-2.0C1.0E5.IC6	1.000	1.000	2.000	5.000	4	.024	45.00	5.0	C		●	.0020-.0070
<b>NEW</b> ECI-H4M1.0-2.0W1.0E5.IC6	1.000	1.000	2.000	5.000	4	.024	45.00	5.0	W		●	.0020-.0070

(1) Number of flutes

(2) Maximum ramping angle

(3) C-Cylindrical, W-Weldon