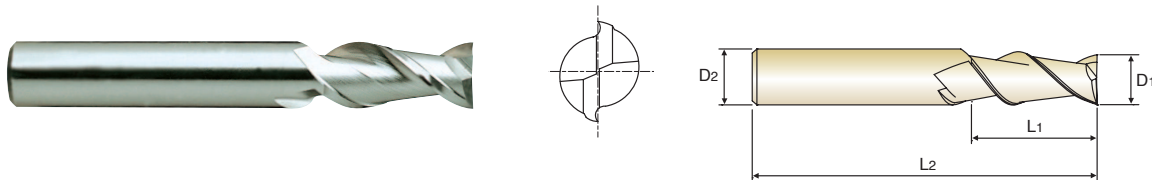


CARBIDE, 2 FLUTE 45° HELIX LONG LENGTH
VOLLHARTMETALL, 2 SCHNEIDEN 45° RECHTSSPIRALE LANG

- ▶ Suitable for high speed machining in aluminum and other non-ferrous materials
- ▶ Mirror surface - Excellent surface finishes
- ▶ Superior chip evacuation
- ▶ Reduces chipping of corner edges

- ▶ Zur HSC-Bearbeitung von Aluminium und anderen Nichteisenmetallen.
- ▶ Spiegel-Oberfläche - Hervorragendes Oberflächenfinishing.
- ▶ Überlegene Spanabfuhr
- ▶ Reduzierung von Schneideckenausbrüchen.

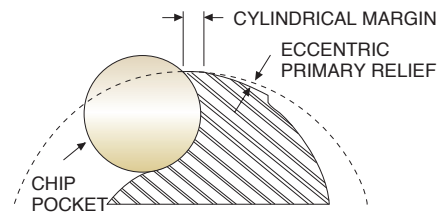


Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT	D1	D2	L1	L2
E5522030	E5521030	3.0	6	8	57
E5522040	E5521040	4.0	6	11	57
E5522050	E5521050	5.0	6	13	57
E5522060	E5521060	6.0	6	13	57
E5522080	E5521080	8.0	8	19	63
E5522100	E5521100	10.0	10	22	72
E5522120	E5521120	12.0	12	26	83
E5522140	E5521140	14.0	14	26	83
E5522160	E5521160	16.0	16	32	92
E5522180	E5521180	18.0	18	32	92
E5522200	E5521200	20.0	20	38	104

▶ TiN, TiCN-COATING & TiAIN-COATING are available on your request.

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.015	h6



◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
									◎					

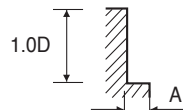
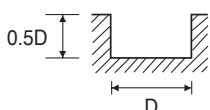


RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 2 FLUTE 45° HELIX
VOLLHARTMETALL, 2 SCHNEIDEN 45° RECHTSSPIRALE

E5E48, E5522, E5521 SERIES

MATERIAL	ALUMINUM ALUMINUM ALLOY								
	DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
3.0	10000	700	95	0.035	10000	900	95	0.045	
4.0	10000	900	125	0.045	10000	1100	125	0.055	
5.0	10000	1000	155	0.050	10000	1300	155	0.065	
6.0	10000	1200	190	0.060	10000	1500	190	0.075	
8.0	8000	1400	200	0.088	8000	1800	200	0.113	
10.0	8000	1700	250	0.106	8000	2100	250	0.131	
12.0	8000	2100	300	0.131	8000	2600	300	0.163	
14.0	6000	1800	265	0.150	6000	2200	265	0.183	
16.0	6000	1900	300	0.158	6000	2400	300	0.200	
18.0	4000	1400	225	0.175	4000	1800	225	0.225	
20.0	4000	1600	250	0.200	4000	1900	250	0.238	



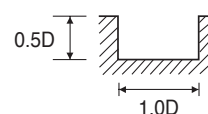
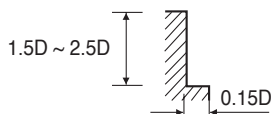
A : $\varnothing 3 \sim \varnothing 10 = 0.25 \times D$
 $\varnothing 12 \sim \varnothing 20 = 0.5 \times D$

RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

CARBIDE, 3 FLUTE 45° HELIX
VOLLHARTMETALL, 3 SCHNEIDEN 45° RECHTSSPIRALE

E5E49, E5E50 SERIES

MATERIAL	ALUMINUM LOW SILICON ALUMINUM								
	DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
3.0	7000	940	65	0.045	7000	730	65	0.035	
4.0	7000	1150	90	0.055	7000	940	90	0.045	
5.0	7000	1360	110	0.065	7000	1050	110	0.050	
6.0	7000	1580	130	0.075	7000	1250	130	0.060	
8.0	5600	1900	140	0.113	5600	1470	140	0.088	
9.0	5600	2050	160	0.122	5600	1630	160	0.097	
10.0	5600	2200	175	0.131	5600	1780	175	0.106	
12.0	5600	2740	210	0.163	5600	2200	210	0.131	
16.0	4200	2520	210	0.200	4200	1990	210	0.158	
20.0	2800	2000	175	0.238	2800	1680	175	0.200	



RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t