ALU-POWER END MILLS

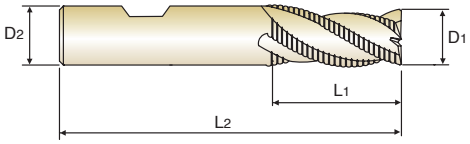
E5742 SERIES PLAIN SHANK / GLATTER ZYLINDERSCHAFT

E5711 SERIES FLAT SHANK / SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 3 FLUTE LONG LENGTH ROUGHING
VOLLHARTMETALL, 3 SCHNEIDEN LANG SCHRUPPFRÄSER

- Excellent cutting qualities on aluminum, copper
- Increased tool life and superior chip evacuation
- Reduces chipping of corner edges

- Ausgezeichnete Schneideigenschaften in Aluminium, Kupfer
- Verbesserte Standzeiten und höhere Fräsgenauigkeit.
- Reduzierung von Schneideckenausbrüchen.



MG HM | YG STD | WR | ALU | 3 | 30° | DIN 6535HA | DIN 6535HB

P.979

Unit : mm

EDP No. PLAIN	EDP No. FLAT	Mill Diameter D1(h10)	Shank Diameter D2(h6)	Length of Cut L1	Overall Length L2
E5742060	E5711060	6.0	6	16	57
E5742070	E5711070	7.0	8	16	63
E5742080	E5711080	8.0	8	16	63
E5742090	E5711090	9.0	10	19	72
E5742100	E5711100	10.0	10	22	72
E5742120	E5711120	12.0	12	26	83
E5742140	E5711140	14.0	14	26	83
E5742160	E5711160	16.0	16	32	92
E5742180	E5711180	18.0	18	32	92
E5742200	E5711200	20.0	20	38	104
E5742250	E5711250	25.0	25	45	121

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

Tolerances according to DIN 7160 & 7161
Toleranzen nach DIN 7160 & 7161

Tolerance range in μm / Toleranzwerte in μm Nominal-Diameter in mm / Nennmaßbereich in mm					
	from 1 to 3 von 1 bis 3	over 3 to 6 über 3 bis 6	over 6 to 10 über 6 bis 10	over 10 to 18 über 10 bis 18	over 18 to 30 über 18 bis 30
h10	0 — 40	0 — 48	0 — 58	0 — 70	0 — 84
h6	0 — 6	0 — 8	0 — 9	0 — 11	0 — 13

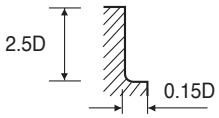
◎ : Excellent ○ : Good

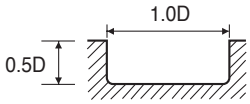
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
○	○							○	◎					

CARBIDE, 3 FLUTE 45° HELIX CORNER RADIUS
VOLLHARTMETALL, 3 SCHNEIDEN 45° RECHTSSPIRALE ECKENRADIUS

E5E51 SERIES

MATERIAL	ALUMINUM LOW SILICON ALUMINUM							
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
3.0	10000	1490	95	0.050	10000	1160	95	0.039
4.0	10000	1820	125	0.061	10000	1490	125	0.050
5.0	10000	2150	155	0.072	10000	1650	155	0.055
6.0	10000	2480	190	0.083	10000	1980	190	0.066
8.0	8000	3000	200	0.125	8000	2310	200	0.096
10.0	8000	3470	250	0.145	8000	2810	250	0.117
12.0	8000	4290	300	0.179	8000	3470	300	0.145
16.0	6000	3960	300	0.220	6000	3140	300	0.174
20.0	4000	3140	250	0.262	4000	2640	250	0.220



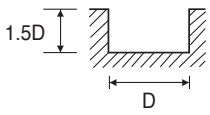


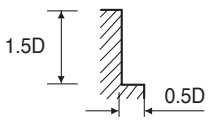
RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

CARBIDE, 3 FLUTE ROUGHING
VOLLHARTMETALL, 3 SCHNEIDEN SCHRUPPFRÄSER

E5E39, E5E40, E5742, E5711 SERIES

MATERIAL	ALUMINUM							
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
6.0	13500	6800	200	0.168	10500	5300	198	0.168
8.0	10500	5300	200	0.168	8000	4000	201	0.167
10.0	8500	4300	205	0.169	6500	3500	204	0.179
12.0	8500	4200	320	0.165	6400	3200	241	0.167
16.0	6400	3200	322	0.167	4800	2400	241	0.167
20.0	5100	2500	320	0.163	3850	1900	242	0.165





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