



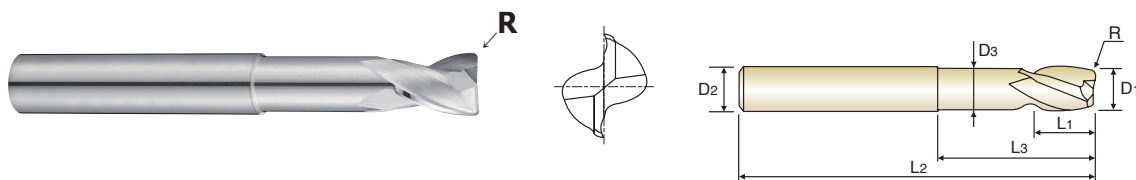
**E5909** SERIES

PLAIN SHANK  
GLATTER ZYLINDERSCHAFT

**CARBIDE, 2 FLUTE CORNER RADIUS with NECK**  
**VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS mit ABGESETZTEM SCHAFTTETTEL**

- ▶ Excellent cutting qualities on aluminum, copper
- ▶ Increased tool life and higher cutting accuracy
- ▶ Mirror surface - Excellent surface finishes

- ▶ Ausgezeichnete Schneideigenschaften in Aluminium, Kupfer
- ▶ Verbesserte Standzeiten und höhere Fräsgenauigkeit.
- ▶ Spiegel-Oberfläche - Hervorragendes Oberflächenfinishing.



Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
<b>E5909040</b>	RO.3	<b>4.0</b>	6	5	10	50	3.6
<b>E5909060</b>	RO.5	<b>6.0</b>	6	8	20	60	5.4
<b>E5909080</b>	RO.6	<b>8.0</b>	8	10	30	70	7.2
<b>E5909100</b>	RO.8	<b>10.0</b>	10	12	36	80	9
<b>E5909120</b>	R1.0	<b>12.0</b>	12	14	40	90	11
<b>E5909160</b>	R1.3	<b>16.0</b>	16	18	45	100	14.5
<b>E5909200</b>	R1.6	<b>20.0</b>	20	24	45	100	18

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

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6

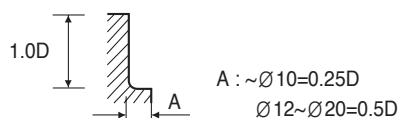
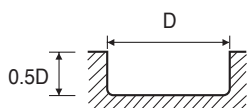
◎ : Excellent ○ : Good

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									
						○			◎					

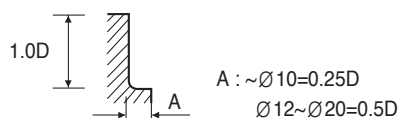
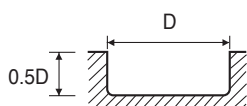
**CARBIDE, 2 FLUTE CORNER RADIUS with NECK**  
**VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS mit ABGESETZTEM SCHAFTTETL**

**E5909** SERIES

MATERIAL	ALUMINUM ALUMINUM ALLOY							
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
4.0	10400	960	130	0.046	10400	1120	130	0.054
6.0	10400	1200	195	0.058	10400	1600	195	0.077
8.0	8000	1440	200	0.090	8000	1840	200	0.115
10.0	8000	1760	250	0.110	8000	2160	250	0.135
12.0	8000	2160	300	0.135	8000	2720	300	0.170
16.0	6400	2000	320	0.156	6400	2480	320	0.194
20.0	4000	1600	250	0.200	4000	2000	250	0.250



MATERIAL	COPPER ALLOY							
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
4.0	3120	240	40	0.038	3120	280	40	0.045
6.0	3120	305	60	0.049	3120	400	60	0.064
8.0	2400	360	60	0.075	2400	465	60	0.097
10.0	2400	440	75	0.092	2400	545	75	0.114
12.0	2400	545	90	0.114	2400	680	90	0.142
16.0	1920	505	95	0.132	1920	625	95	0.163
20.0	1200	400	75	0.167	1200	505	75	0.210



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