



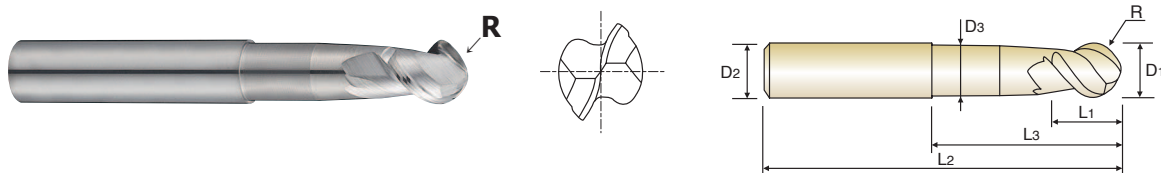
E5910 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

CARBIDE, 2 FLUTE 50° HELIX BALL NOSE with NECK
VOLLHARTMETALL, 2 SCHNEIDEN 50° RECHTSSPIRALE STIRNRADIUS mit ABGESETZTEM SCHAFTTETEL

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

- ▶ Ausgezeichnete Schneideigenschaften in Aluminium, Kupfer
- ▶ Verbesserte Standzeiten und höhere Fräsgenauigkeit.



Unit : mm

EDP No.	Radius of Ball Nose R (±0.01)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
E5910060	R3.0	6.0	6	5.5	25	55	5.4
E5910080	R4.0	8.0	8	7	30	65	7.2
E5910100	R5.0	10.0	10	8.5	35	75	9
E5910120	R6.0	12.0	12	10.5	40	75	11
E5910160	R8.0	16.0	16	14	50	90	14.5
E5910200	R10.0	20.0	20	17	50	100	18

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

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
±0.02	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									
						○			◎					

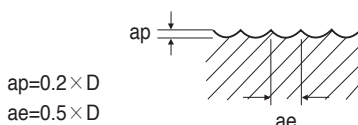


RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 2 FLUTE 50° HELIX BALL NOSE
VOLLHARTMETALL, 2 SCHNEIDEN 50° RECHTSSPIRALE STIRNRADIUS

E5910 SERIES

MATERIAL	ALUMINUM ALUMINUM ALLOY				COPPER ALLOY			
	DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc
R3.0 × 6.0	14400	1400	270	0.049	4400	350	85	0.040
R4.0 × 8.0	11200	1600	280	0.071	3360	400	85	0.060
R5.0 × 10.0	11200	1880	350	0.084	3360	465	105	0.069
R6.0 × 12.0	11200	2400	420	0.107	3360	600	125	0.089
R8.0 × 16.0	8800	2160	440	0.123	2640	535	135	0.101
R10.0 × 20.0	5600	1760	350	0.157	1680	440	105	0.131

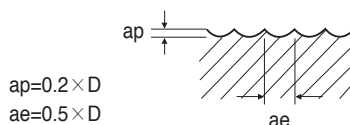


RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

CARBIDE, 3 FLUTE 40° HELIX BALL NOSE
VOLLHARTMETALL, 3 SCHNEIDEN 40° RECHTSSPIRALE STIRNRADIUS

E5908 SERIES

MATERIAL	ALUMINUM ALUMINUM ALLOY				COPPER ALLOY			
	DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc
R1.0 × 2.0	21600	760	135	0.018	6400	190	40	0.015
R1.25 × 2.5	17600	760	140	0.022	5200	190	40	0.018
R1.5 × 3.0	14400	760	135	0.026	4400	190	40	0.022
R1.75 × 3.5	14400	800	160	0.028	4400	190	50	0.022
R2.0 × 4.0	14400	1000	180	0.035	4400	250	55	0.028
R2.5 × 5.0	14400	1080	225	0.038	4400	270	70	0.031
R3.0 × 6.0	14400	1400	270	0.049	4400	350	85	0.040
R4.0 × 8.0	11200	1600	280	0.071	3360	400	85	0.060
R5.0 × 10.0	11200	1880	350	0.084	3360	465	105	0.069
R6.0 × 12.0	11200	2400	420	0.107	3360	600	125	0.089
R8.0 × 16.0	8800	2160	440	0.123	2640	535	135	0.101



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