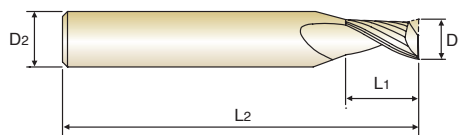
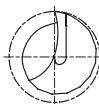



**ALU-POWER
END MILLS**
E5E47 SERIES
**PLAIN SHANK
GLATTER ZYLINDERSCHAFT**

CARBIDE, 1 FLUTE VOLLHARTMETALL, 1 SCHNEIDEN

- Designed to non-ferrous material and non-metal like aluminum and acrylic
- 1 Flute allows for excellent workpiece finishes and chip evacuation

- Entwickelt für NE-Metalle und nichtmetallische Werkstoffe wie Aluminium und Acryl
- 1 Spannute ermöglicht hervorragende Werkstückoberflächen und Spanabfuhr



P.976

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
E5E47020	2.0	3	8	50
E5E47030	3.0	3	12	50
E5E47040	4.0	4	15	60
E5E47050	5.0	5	17	60
E5E47060	6.0	6	20	65
E5E47080	8.0	8	22	65
E5E47100	10.0	10	25	75
E5E47120	12.0	12	30	80

- TiN, TiCN-COATING & TiAIN-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									
								◎				◎	

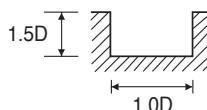


RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 1 FLUTE VOLLHARTMETALL, 1 SCHNEIDEN

E5E47 SERIES

MATERIAL	ACRYLIC				ALUMINUM ALUMINUM ALLOY			
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
2.0	32000	2200	200	0.069	23000	1500	145	0.065
3.0	25000	2400	235	0.096	18000	1700	170	0.094
4.0	20000	2400	250	0.120	15000	1800	190	0.120
5.0	15000	2200	235	0.147	12000	1800	190	0.150
6.0	13500	2300	255	0.170	10000	1800	190	0.180
8.0	10000	2400	250	0.240	7800	1900	195	0.244
10.0	8000	2400	250	0.300	6000	2000	190	0.333
12.0	6700	2300	255	0.343	5000	2200	190	0.440

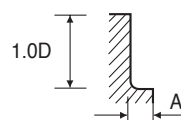
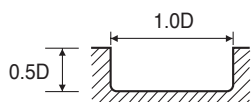


RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

CARBIDE, 2FLUTE 25° HELIX CORNER RADIUS with NECK VOLLHARTMETALL, 2 SCHNEIDEN 25° RECHTSSPIRALE ECKENRADIUS mit ABGESETZTEM SCHAFTTETEL

E5930 SERIES

MATERIAL	ALUMINUM ALUMINUM ALLOY							
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
2.0	10400	460	65	0.022	10400	810	65	0.039
3.0	10400	720	100	0.035	10400	960	100	0.046
4.0	10400	960	130	0.046	10400	1120	130	0.054
5.0	10400	1040	165	0.050	10400	1360	165	0.065
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



A : $\varnothing 2 \sim \varnothing 10 = 0.25 \times D$
 $\varnothing 12 \sim \varnothing 20 = 0.5 \times D$

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