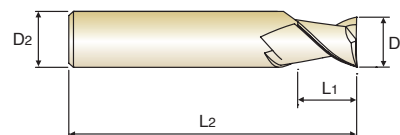
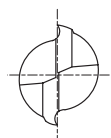


CARBIDE, 2 FLUTE 45° HELIX SHORT LENGTH VOLLHARTMETALL, 2 SCHNEIDEN 45° RECHTSSPIRALE KURZ

- 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 Nicht-eisenmetallen.
- Spiegel-Oberfläche - Hervorragendes Oberflächenfinishing.
- Überlegene Spanabfuhr
- Reduzierung von Schneideckenausbrüchen.



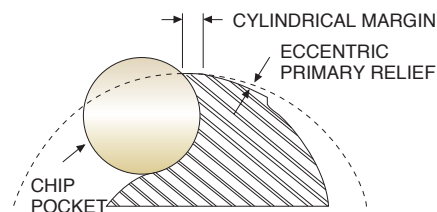
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Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
E5E48030	3.0	6	5	50
E5E48040	4.0	6	8	54
E5E48050	5.0	6	9	54
E5E48060	6.0	6	10	54
E5E48080	8.0	8	12	58
E5E48100	10.0	10	14	66
E5E48120	12.0	12	16	73
E5E48140	14.0	14	18	75
E5E48160	16.0	16	22	82
E5E48180	18.0	18	24	84
E5E48200	20.0	20	26	92

► TiN, TiCN-COATING & TiAlN-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								
								◎					

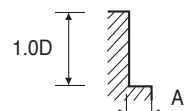
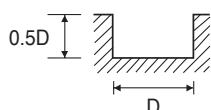


RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

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



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

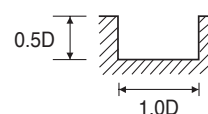
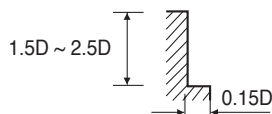
$$\varnothing 12 \sim \varnothing 20 = 0.5 \times D$$

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