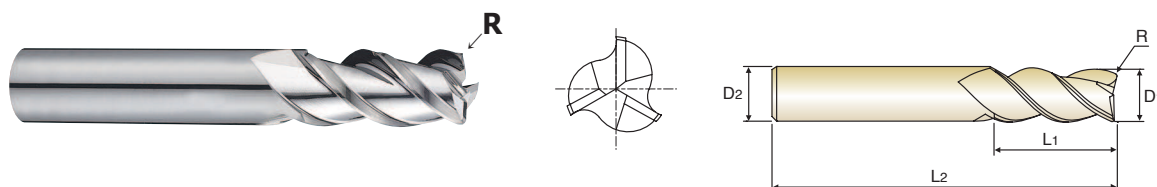


CARBIDE, 3 FLUTE 45° HELIX LONG LENGTH CORNER RADIUS **VOLLHARTMETALL, 3 SCHNEIDEN 45° RECHTSSPIRALE LANG ECKENRADIUS**

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

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

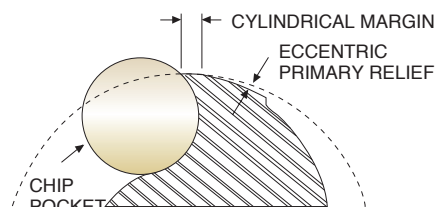


Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Overall Length L2
E5E51030	R0.5	3.0	6	12	57
E5E51901	R1.0	3.0	6	12	57
E5E51040	R0.5	4.0	6	15	57
E5E51902	R1.0	4.0	6	15	57
E5E51050	R0.5	5.0	6	20	57
E5E51903	R1.0	5.0	6	20	57
E5E51060	R0.5	6.0	6	20	65
E5E51904	R1.0	6.0	6	20	65
E5E51080	R0.5	8.0	8	22	65
E5E51905	R1.0	8.0	8	22	65
E5E51100	R0.5	10.0	10	25	70
E5E51906	R1.0	10.0	10	25	70
E5E51907	R2.0	10.0	10	25	70
E5E51120	R0.5	12.0	12	25	75
E5E51908	R1.0	12.0	12	25	75
E5E51909	R2.0	12.0	12	25	75
E5E51160	R0.5	16.0	16	35	90
E5E51910	R1.0	16.0	16	35	90
E5E51911	R2.0	16.0	16	35	90
E5E51200	R0.5	20.0	20	40	100
E5E51912	R1.0	20.0	20	40	100
E5E51913	R2.0	20.0	20	40	100

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

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.015	h6

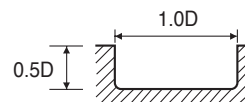
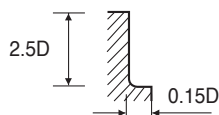


◎ : Excellent ○ : Good

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									
								◎					

CARBIDE, 3 FLUTE 45° HELIX CORNER RADIUS
VOLLHARTMETALL, 3 SCHNEIDEN 45° RECHTSSPIRALE ECKENRADIUS
E5E51 SERIES

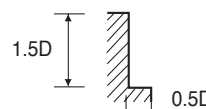
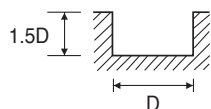
MATERIAL	ALUMINUM LOW SILICON ALUMINUM							
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
3.0	10000	1490	95	0.050	10000	1160	95	0.039
4.0	10000	1820	125	0.061	10000	1490	125	0.050
5.0	10000	2150	155	0.072	10000	1650	155	0.055
6.0	10000	2480	190	0.083	10000	1980	190	0.066
8.0	8000	3000	200	0.125	8000	2310	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