

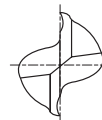


**E2509** SERIES

FLAT SHANK  
SEITLICHE MITNAHMEFLÄCHEN

**HSSCo8, 2 FLUTE 42° HELIX LONG LENGTH**  
**HSSCo8, 2 SCHNEIDEN 42° RECHTSSPIRALE LANG**

**for ALUMINUM**  
**für ALUMINIUM**



HSS Co8
DIN 844
W
2
42°
DIN 1835B
P.1267

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
	e8	h6		
UNCOATED				
E2509020	2.0	6	10	54
E2509030	3.0	6	12	56
E2509040	4.0	6	19	63
E2509050	5.0	6	24	68
E2509060	6.0	6	24	68
E2509070	7.0	10	30	80
E2509080	8.0	10	38	88
E2509090	9.0	10	38	88
E2509100	10.0	10	45	95
E2509110	11.0	12	45	102
E2509120	12.0	12	53	110
E2509130	13.0	12	53	110
E2509140	14.0	12	53	110
E2509150	15.0	12	53	110
E2509160	16.0	16	63	123
E2509180	18.0	16	63	123
E2509200	20.0	20	75	141

- ▶ Other shank design on your request.
- ▶ TIN-COATING & TICN-COATING are available on your request.

**Tolerances according to DIN 7160 & 7161**  
**Toleranzen nach DIN 7160 & 7161**

Tolerance range in $\mu\text{m}$ / Toleranzwerte in $\mu\text{m}$						
Nominal-Diameter in mm / Nennmaßbereich in mm						
	from 1 to 3 von 1 bis 3	over 3 to 6 über 3 bis 6	over 6 to 10 über 6 bis 10	over 10 to 18 über 10 bis 18	over 18 to 30 über 18 bis 30	over 30 to 50 über 30 bis 50
e8	-14 -28	-20 -38	-25 -47	-32 -59	-40 -73	-50 -89
h6	0 -6	0 -8	0 -9	0 -11	0 -13	0 -16

◎ : Excellent ○ : Good

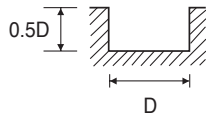
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
○									◎					

**HSSCo8, 2 FLUTE 42° HELIX**  
**HSSCo8, 2 SCHNEIDEN 42° RECHTSSPIRALE**

**E2464, E2509 SERIES**

**SLOTTING**

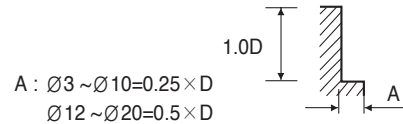
MATERIAL	ALUMINUM NONFERROUS METALS			
	DIAMETER	RPM	FEED	Vc
3.0	8000	560	75	0.035
6.0	7000	700	130	0.050
8.0	6000	850	150	0.071
10.0	5000	1200	155	0.120
12.0	5000	1200	190	0.120
14.0	3500	1240	155	0.177
16.0	3500	1240	175	0.177
18.0	2300	1300	130	0.283
20.0	2300	1300	145	0.283



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

**SIDE CUTTING**

MATERIAL	ALUMINUM NONFERROUS METALS			
	DIAMETER	RPM	FEED	Vc
3.0	8000	730	75	0.046
6.0	7000	900	130	0.064
8.0	6000	1100	150	0.092
10.0	5000	1500	155	0.150
12.0	5000	1500	190	0.150
14.0	3500	1600	155	0.229
16.0	3500	1600	175	0.229
18.0	2300	1700	130	0.370
20.0	2300	1700	145	0.370



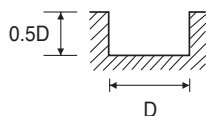
RPM = rev./min.  
FEED = mm/min.  
Vc = m/min.  
fz = mm/t

**HSSCo8, 2 FLUTE 42° HELIX TiCN COATED**  
**HSSCo8, 2 SCHNEIDEN 42° RECHTSSPIRALE TiCN-BESCHICHTET**

**E2464, E2509 SERIES**

**SLOTTING**

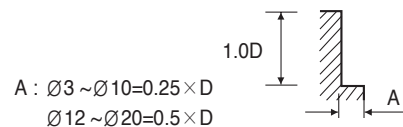
MATERIAL	ALUMINUM NONFERROUS METALS			
	DIAMETER	RPM	FEED	Vc
3.0	10400	730	100	0.035
6.0	9100	910	170	0.050
8.0	7800	1100	195	0.071
10.0	6500	1560	205	0.120
12.0	6500	1560	245	0.120
14.0	4500	1610	200	0.179
16.0	4500	1610	225	0.179
18.0	3000	1700	170	0.283
20.0	3000	1700	190	0.283



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

**SIDE CUTTING**

MATERIAL	ALUMINUM NONFERROUS METALS			
	DIAMETER	RPM	FEED	Vc
3.0	10400	950	100	0.046
6.0	9100	1150	170	0.063
8.0	7800	1400	195	0.090
10.0	6500	1950	205	0.150
12.0	6500	1950	245	0.150
14.0	4500	2080	200	0.231
16.0	4500	2080	225	0.231
18.0	3000	2210	170	0.368
20.0	3000	2210	190	0.368



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