

HSSCo8, 2 FLUTE EXTRA LONG LENGTH
HSSCo8, 2 SCHNEIDEN EXTRA LANG



P.1231, 1232

Unit : mm

EDP No.	ITEM No.	EDP No.	ITEM No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	UNCOATED	TiAIN	TiAIN	e8	h6		
E2510025	C2GXS-025AF	EQ510025	R2GXS-025AF	2.5	6	8	56
E2510030	C2GXS-030AF	EQ510030	R2GXS-030AF	3.0	6	8	56
E2510035	C2GXS-035AF	EQ510035	R2GXS-035AF	3.5	6	10	59
E2510040	C2GXS-040AF	EQ510040	R2GXS-040AF	4.0	6	11	63
E2510045	C2GXS-045AF	EQ510045	R2GXS-045AF	4.5	6	11	63
E2510050	C2GXS-050AF	EQ510050	R2GXS-050AF	5.0	6	13	68
E2510055	C2GXS-055AF	EQ510055	R2GXS-055AF	5.5	6	13	68
E2510060	C2GXS-060AF	EQ510060	R2GXS-060AF	6.0	6	13	68
E2510065	C2GXS-065TF	EQ510065	R2GXS-065TF	6.5	10	16	80
E2510070	C2GXS-070TF	EQ510070	R2GXS-070TF	7.0	10	16	80
E2510080	C2GXS-080TF	EQ510080	R2GXS-080TF	8.0	10	19	88
E2510085	C2GXS-085TF	EQ510085	R2GXS-085TF	8.5	10	19	88
E2510090	C2GXS-090TF	EQ510090	R2GXS-090TF	9.0	10	19	88
E2510100	C2GXS-100TF	EQ510100	R2GXS-100TF	10.0	10	22	95
E2510120	C2GXS-120DF	EQ510120	R2GXS-120DF	12.0	12	26	110
E2510140	C2GXS-140DF	EQ510140	R2GXS-140DF	14.0	12	26	110
E2510160	C2GXS-160EF	EQ510160	R2GXS-160EF	16.0	16	32	123
E2510180	C2GXS-180EF	EQ510180	R2GXS-180EF	18.0	16	32	123
E2510200	C2GXS-200FF	EQ510200	R2GXS-200FF	20.0	20	38	141
E2510220	C2GXS-220FF	EQ510220	R2GXS-220FF	22.0	20	38	141
E2510240	C2GXS-240GF	EQ510240	R2GXS-240GF	24.0	25	45	166
E2510250	C2GXS-250GF	EQ510250	R2GXS-250GF	25.0	25	45	166
E2510260	C2GXS-260GF	EQ510260	R2GXS-260GF	26.0	25	45	166
E2510280	C2GXS-280GF	EQ510280	R2GXS-280GF	28.0	25	45	166
E2510300	C2GXS-300GF	EQ510300	R2GXS-300GF	30.0	25	45	166
E2510320	C2GXS-320HF	EQ510320	R2GXS-320HF	32.0	32	53	186
E2510360	C2GXS-360HF	EQ510360	R2GXS-360HF	36.0	32	53	186
E2510400	C2GXS-400HF	EQ510400	R2GXS-400HF	40.0	32	63	207
E2510940	C2GXS-400IF	EQ510940	R2GXS-400IF	40.0	40	63	217

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

Tolerance range in μm / Toleranzwerte in μm						
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

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

◎ : 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									
◎	◎	○							○					

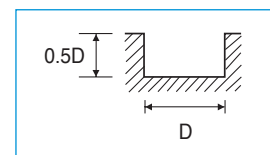
HSSCo8, 2 FLUTE - SLOTTING
HSSCo8, 2 SCHNEIDEN - NUTENFRÄSEN
E2570, E2571, E2510 SERIES

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS			
HARDNESS					~ HRC20				HRc20 ~ HRc30			
STRENGTH	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	5600	40	35	0.004	4500	30	30	0.003	4000	30	25	0.004
3.0	3500	55	35	0.008	3200	45	30	0.007	2500	40	25	0.008
4.0	2800	70	35	0.013	2200	55	30	0.013	1800	45	25	0.013
5.0	2200	90	35	0.020	1800	70	30	0.019	1600	60	25	0.019
6.0	1800	90	35	0.025	1600	80	30	0.025	1200	60	25	0.025
8.0	1400	100	35	0.036	1100	90	30	0.041	900	70	25	0.039
10.0	1100	100	35	0.045	900	90	30	0.050	800	80	25	0.050
12.0	900	110	35	0.061	800	100	30	0.063	630	80	25	0.063
14.0	800	110	35	0.069	700	90	30	0.064	560	80	25	0.071
16.0	700	110	35	0.079	560	90	30	0.080	450	70	25	0.078
18.0	630	100	35	0.079	500	90	30	0.090	400	70	25	0.088
20.0	560	100	35	0.089	450	90	30	0.100	400	70	25	0.088
22.0	500	100	35	0.100	450	90	30	0.100	350	70	25	0.100
25.0	450	90	35	0.100	400	80	30	0.100	310	60	25	0.097
28.0	400	80	35	0.100	350	70	30	0.100	280	55	25	0.098
30.0	350	70	35	0.100	310	60	30	0.097	250	50	25	0.100
32.0	350	70	35	0.100	280	55	30	0.098	220	45	20	0.102
36.0	310	60	35	0.097	250	50	30	0.100	200	40	25	0.100
40.0	280	60	35	0.107	220	50	30	0.114	180	40	25	0.111

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				ALUMINUM ALUMINUM ALLOYS			
HARDNESS	HRc30 ~ HRc40							
STRENGTH	1000 ~ 1300N/mm ²							
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	2200	15	15	0.003	12000	160	75	0.007
3.0	1600	20	15	0.006	11000	250	105	0.011
4.0	1100	30	15	0.014	8000	290	100	0.018
5.0	900	35	15	0.019	6300	310	100	0.025
6.0	800	40	15	0.025	5600	310	105	0.028
8.0	560	45	15	0.040	4000	390	100	0.049
10.0	450	45	15	0.050	3100	400	95	0.065
12.0	400	50	15	0.063	2500	380	95	0.076
14.0	350	50	15	0.071	2200	350	95	0.080
16.0	280	45	15	0.080	2000	350	100	0.088
18.0	250	45	15	0.090	1800	350	100	0.097
20.0	220	45	15	0.102	1600	320	100	0.100
22.0	220	45	15	0.102	1400	300	95	0.107
25.0	180	35	15	0.097	1200	280	95	0.117
28.0	160	30	15	0.094	1100	270	95	0.123
30.0	160	30	15	0.094	1100	270	105	0.123
32.0	140	30	15	0.107	1000	240	100	0.120
36.0	120	25	15	0.104	900	220	100	0.122
40.0	110	25	15	0.114	800	200	100	0.125

※ The FEED, in long & extra long types, should be reduced by around 50%

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

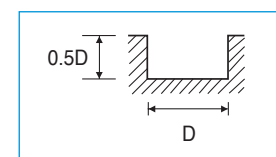


HSSCo8, 2 FLUTE TiAlN COATED - SLOTTING
HSSCo8, 2 SCHNEIDEN TiAlN-BESCHICHTET - NUTENFRÄSEN

E2570, E2571, E2510 SERIES

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS			
	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²			
HARDNESS					~ HRC20				HRC20 ~ HRC30			
STRENGTH												
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	7850	55	50	0.004	6300	40	40	0.003	5600	40	35	0.004
3.0	4900	75	45	0.008	4500	65	40	0.007	3500	55	35	0.008
4.0	3900	100	50	0.013	3100	75	40	0.012	2500	65	30	0.013
5.0	3100	125	50	0.020	2500	100	40	0.020	2250	85	35	0.019
6.0	2500	125	45	0.025	2250	110	40	0.024	1700	85	30	0.025
8.0	1950	140	50	0.036	1550	125	40	0.040	1250	100	30	0.040
10.0	1550	140	50	0.045	1250	125	40	0.050	1100	110	35	0.050
12.0	1250	155	45	0.062	1100	140	40	0.064	900	110	35	0.061
14.0	1100	155	50	0.070	1000	125	45	0.063	800	110	35	0.069
16.0	1000	155	50	0.078	800	125	40	0.078	650	100	35	0.077
18.0	900	140	50	0.078	700	125	40	0.089	550	100	30	0.091
20.0	800	140	50	0.088	650	125	40	0.096	550	100	35	0.091
22.0	700	140	50	0.100	650	125	45	0.096	500	100	35	0.100
25.0	650	125	50	0.096	550	110	45	0.100	450	85	35	0.094
28.0	550	110	50	0.100	500	100	45	0.100	400	75	35	0.094
30.0	500	100	45	0.100	450	85	40	0.094	350	70	35	0.100
32.0	500	100	50	0.100	400	75	40	0.094	300	65	30	0.108
36.0	450	85	50	0.094	350	70	40	0.100	300	55	35	0.092
40.0	400	85	50	0.106	300	70	40	0.117	250	55	30	0.110

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				ALUMINUM ALUMINUM ALLOYS			
	HRc30 ~ HRc40							
STRENGTH	1000 ~ 1300N/mm ²							
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	3100	20	20	0.003	16800	225	105	0.007
3.0	2250	30	20	0.007	15400	350	145	0.011
4.0	1550	40	20	0.013	11200	405	140	0.018
5.0	1250	50	20	0.020	8800	435	140	0.025
6.0	1100	55	20	0.025	7850	435	150	0.028
8.0	800	65	20	0.041	5600	545	140	0.049
10.0	650	65	20	0.050	4350	560	135	0.064
12.0	550	70	20	0.064	3500	530	130	0.076
14.0	500	70	20	0.070	3100	490	135	0.079
16.0	400	65	20	0.081	2800	490	140	0.088
18.0	350	65	20	0.093	2500	490	140	0.098
20.0	300	65	20	0.108	2250	450	140	0.100
22.0	300	65	20	0.108	1950	420	135	0.108
25.0	250	50	20	0.100	1700	390	135	0.115
28.0	200	40	20	0.100	1550	380	135	0.123
30.0	200	40	20	0.100	1550	380	145	0.123
32.0	200	40	20	0.100	1400	335	140	0.120
36.0	150	35	15	0.117	1250	310	140	0.124
40.0	150	35	20	0.117	1100	280	140	0.127



*The FEED, in long & extra long types, should be reduced by around 50%

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