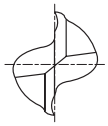
HSS END MILLS

E2570 SERIES FLAT SHANK / SEITLICHE MITNAHMEFLÄCHEN

EQ570 SERIES FLAT SHANK / SEITLICHE MITNAHMEFLÄCHEN

HSSCo8, 2 FLUTE SHORT LENGTH
HSSCo8, 2 SCHNEIDEN KURZ



HSS Co8 | DIN 327 | N | 2 | 30° | DIN 1835B

P.1231, 1232

Unit : mm

EDP No. UNCOATED	ITEM No. UNCOATED	EDP No. TiAlN	ITEM No. TiAlN	Mill Diameter e8	Shank Diameter h6	Length of Cut	Overall Length
E2570010	C2GRS-010AF	EQ570010	R2GRS-010AF	1.0	6	2.5	47
E2570015	C2GRS-015AF	EQ570015	R2GRS-015AF	1.5	6	3	47
E2570020	C2GRS-020AF	EQ570020	R2GRS-020AF	2.0	6	4	48
E2570025	C2GRS-025AF	EQ570025	R2GRS-025AF	2.5	6	5	49
E2570028	C2GRS-028AF	EQ570028	R2GRS-028AF	2.8	6	5	49
E2570030	C2GRS-030AF	EQ570030	R2GRS-030AF	3.0	6	5	49
E2570035	C2GRS-035AF	EQ570035	R2GRS-035AF	3.5	6	6	50
E2570038	C2GRS-038AF	EQ570038	R2GRS-038AF	3.8	6	7	51
E2570040	C2GRS-040AF	EQ570040	R2GRS-040AF	4.0	6	7	51
E2570045	C2GRS-045AF	EQ570045	R2GRS-045AF	4.5	6	7	51
E2570048	C2GRS-048AF	EQ570048	R2GRS-048AF	4.8	6	8	52
E2570050	C2GRS-050AF	EQ570050	R2GRS-050AF	5.0	6	8	52
E2570055	C2GRS-055AF	EQ570055	R2GRS-055AF	5.5	6	8	52
E2570957	C2GRS-0575AF	EQ570957	R2GRS-0575AF	5.75	6	8	52
E2570060	C2GRS-060AF	EQ570060	R2GRS-060AF	6.0	6	8	52
E2570065	C2GRS-065TF	EQ570065	R2GRS-065TF	6.5	10	10	60
E2570967	C2GRS-0675TF	EQ570967	R2GRS-0675TF	6.75	10	10	60
E2570070	C2GRS-070TF	EQ570070	R2GRS-070TF	7.0	10	10	60
E2570075	C2GRS-075TF	EQ570075	R2GRS-075TF	7.5	10	10	60
E2570977	C2GRS-0775TF	EQ570977	R2GRS-0775TF	7.75	10	11	61
E2570080	C2GRS-080TF	EQ570080	R2GRS-080TF	8.0	10	11	61
E2570085	C2GRS-085TF	EQ570085	R2GRS-085TF	8.5	10	11	61
E2570087	C2GRS-087TF	EQ570087	R2GRS-087TF	8.7	10	11	61
E2570090	C2GRS-090TF	EQ570090	R2GRS-090TF	9.0	10	11	61
E2570095	C2GRS-095TF	EQ570095	R2GRS-095TF	9.5	10	11	61
E2570097	C2GRS-097TF	EQ570097	R2GRS-097TF	9.7	10	13	63
E2570100	C2GRS-100TF	EQ570100	R2GRS-100TF	10.0	10	13	63

◎ : Excellent ○ : Good

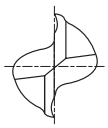
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
◎	◎	○							○					

HSS END MILLS

E2570 SERIES FLAT SHANK SEITLICHE MITNAHMEFLÄCHEN

EQ570 SERIES FLAT SHANK SEITLICHE MITNAHMEFLÄCHEN

HSSCo8, 2 FLUTE SHORT LENGTH
HSSCo8, 2 SCHNEIDEN KURZ



HSS Co8 | DIN 327 | N | 2 | ≈30° | DIN 1835B

P.1231, 1232

Unit : mm

EDP No. UNCOATED	ITEM No. UNCOATED	EDP No. TiAlN	ITEM No. TiAlN	Mill Diameter e8	Shank Diameter h6	Length of Cut	Overall Length
E2570105	C2GRS-105DF	EQ570105	R2GRS-105DF	10.5	12	13	70
E2570107	C2GRS-107DF	EQ570107	R2GRS-107DF	10.7	12	13	70
E2570110	C2GRS-110DF	EQ570110	R2GRS-110DF	11.0	12	13	70
E2570115	C2GRS-115DF	EQ570115	R2GRS-115DF	11.5	12	13	70
E2570117	C2GRS-117DF	EQ570117	R2GRS-117DF	11.7	12	16	73
E2570120	C2GRS-120DF	EQ570120	R2GRS-120DF	12.0	12	16	73
E2570125	C2GRS-125DF	EQ570125	R2GRS-125DF	12.5	12	16	73
E2570127	C2GRS-127DF	EQ570127	R2GRS-127DF	12.7	12	16	73
E2570130	C2GRS-130DF	EQ570130	R2GRS-130DF	13.0	12	16	73
E2570135	C2GRS-135DF	EQ570135	R2GRS-135DF	13.5	12	16	73
E2570137	C2GRS-137DF	EQ570137	R2GRS-137DF	13.7	12	16	73
E2570140	C2GRS-140DF	EQ570140	R2GRS-140DF	14.0	12	16	73
E2570147	C2GRS-147DF	EQ570147	R2GRS-147DF	14.7	12	16	73
E2570150	C2GRS-150DF	EQ570150	R2GRS-150DF	15.0	12	16	73
E2570157	C2GRS-157EF	EQ570157	R2GRS-157EF	15.7	16	19	79
E2570160	C2GRS-160EF	EQ570160	R2GRS-160EF	16.0	16	19	79
E2570167	C2GRS-167EF	EQ570167	R2GRS-167EF	16.7	16	19	79
E2570170	C2GRS-170EF	EQ570170	R2GRS-170EF	17.0	16	19	79
E2570177	C2GRS-177EF	EQ570177	R2GRS-177EF	17.7	16	19	79
E2570180	C2GRS-180EF	EQ570180	R2GRS-180EF	18.0	16	19	79
E2570190	C2GRS-190EF	EQ570190	R2GRS-190EF	19.0	16	19	79
E2570197	C2GRS-197FF	EQ570197	R2GRS-197FF	19.7	20	22	88
E2570920	C2GRS-200EF	EQ570920	R2GRS-200EF	20.0	16	22	82
E2570200	C2GRS-200FF	EQ570200	R2GRS-200FF	20.0	20	22	88
E2570210	C2GRS-210FF	EQ570210	R2GRS-210FF	21.0	20	22	88
E2570220	C2GRS-220FF	EQ570220	R2GRS-220FF	22.0	20	22	88
E2570922	C2GRS-220GF	EQ570922	R2GRS-220GF	22.0	25	22	98

◎ : Excellent ○ : Good

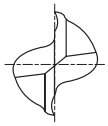
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
◎	◎	○							○					

HSS END MILLS

E2570 SERIES FLAT SHANK / SEITLICHE MITNAHMEFLÄCHEN

EQ570 SERIES FLAT SHANK / SEITLICHE MITNAHMEFLÄCHEN

HSSCo8, 2 FLUTE SHORT LENGTH
HSSCo8, 2 SCHNEIDEN KURZ



HSS Co8 | DIN 327 | N | 2 | 30° | DIN 1835B

P.1231, 1232

Unit : mm

EDP No. UNCOATED	ITEM No. UNCOATED	EDP No. TiAlN	ITEM No. TiAlN	Mill Diameter e8	Shank Diameter h6	Length of Cut	Overall Length
E2570240	C2GRS-240GF	EQ570240	R2GRS-240GF	24.0	25	26	102
E2570250	C2GRS-250GF	EQ570250	R2GRS-250GF	25.0	25	26	102
E2570260	C2GRS-260GF	EQ570260	R2GRS-260GF	26.0	25	26	102
E2570270	C2GRS-270GF	EQ570270	R2GRS-270GF	27.0	25	26	102
E2570280	C2GRS-280GF	EQ570280	R2GRS-280GF	28.0	25	26	102
E2570290	C2GRS-290GF	EQ570290	R2GRS-290GF	29.0	25	26	102
E2570300	C2GRS-300GF	EQ570300	R2GRS-300GF	30.0	25	26	102
E2570320	C2GRS-320HF	EQ570320	R2GRS-320HF	32.0	32	32	112
E2570340	C2GRS-340HF	EQ570340	R2GRS-340HF	34.0	32	32	112
E2570350	C2GRS-350HF	EQ570350	R2GRS-350HF	35.0	32	32	112
E2570360	C2GRS-360HF	EQ570360	R2GRS-360HF	36.0	32	32	112
E2570380	C2GRS-380HF	EQ570380	R2GRS-380HF	38.0	32	38	118
E2570938	C2GRS-380IF	EQ570938	R2GRS-380IF	38.0	40	38	130
E2570400	C2GRS-400HF	EQ570400	R2GRS-400HF	40.0	32	38	118
E2570903	C2GRS-400IF	EQ570903	R2GRS-400IF	40.0	40	38	130

▶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 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

◎ : Excellent ○ : Good

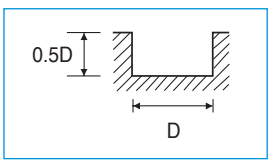
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
◎	◎	○							○					

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/mm²				500 ~ 800N/mm²				800 ~ 1000N/mm²			
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/mm²							
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

HSS END MILLS

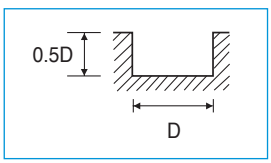
RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

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			
HARDNESS					~ HRc20				HRc20 ~ HRc30			
STRENGTH	~ 500N/mm²				500 ~ 800N/mm²				800 ~ 1000N/mm²			
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			
HARDNESS	HRc30 ~ HRc40							
STRENGTH	1000 ~ 1300N/mm²							
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



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