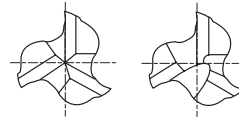


HSSCo8, 3 FLUTE STUB LENGTH
HSSCo8, 3 SCHNEIDEN EXTRA KURZ



Up to Ø2.5mm Over Ø2.5mm



P.1234, 1235, 1236, 1237

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 | | |
| E2572015 | C3GSC-015AF | EQ572015 | R3GSC-015AF | 1.5 | 6 | 3 | 47 |
| E2572020 | C3GSC-020AF | EQ572020 | R3GSC-020AF | 2.0 | 6 | 4 | 48 |
| E2572025 | C3GSC-025AF | EQ572025 | R3GSC-025AF | 2.5 | 6 | 5 | 49 |
| E2572030 | C3GSC-030AF | EQ572030 | R3GSC-030AF | 3.0 | 6 | 5 | 49 |
| E2572035 | C3GSC-035AF | EQ572035 | R3GSC-035AF | 3.5 | 6 | 6 | 50 |
| E2572040 | C3GSC-040AF | EQ572040 | R3GSC-040AF | 4.0 | 6 | 7 | 51 |
| E2572045 | C3GSC-045AF | EQ572045 | R3GSC-045AF | 4.5 | 6 | 7 | 51 |
| E2572050 | C3GSC-050AF | EQ572050 | R3GSC-050AF | 5.0 | 6 | 8 | 52 |
| E2572055 | C3GSC-055AF | EQ572055 | R3GSC-055AF | 5.5 | 6 | 8 | 52 |
| E2572060 | C3GSC-060AF | EQ572060 | R3GSC-060AF | 6.0 | 6 | 8 | 52 |
| E2572065 | C3GSC-065TF | EQ572065 | R3GSC-065TF | 6.5 | 10 | 10 | 60 |
| E2572070 | C3GSC-070TF | EQ572070 | R3GSC-070TF | 7.0 | 10 | 10 | 60 |
| E2572075 | C3GSC-075TF | EQ572075 | R3GSC-075TF | 7.5 | 10 | 10 | 60 |
| E2572080 | C3GSC-080TF | EQ572080 | R3GSC-080TF | 8.0 | 10 | 11 | 61 |
| E2572085 | C3GSC-085TF | EQ572085 | R3GSC-085TF | 8.5 | 10 | 11 | 61 |
| E2572100 | C3GSC-100TF | EQ572100 | R3GSC-100TF | 10.0 | 10 | 13 | 63 |
| E2572120 | C3GSC-120DF | EQ572120 | R3GSC-120DF | 12.0 | 12 | 16 | 73 |
| E2572140 | C3GSC-140DF | EQ572140 | R3GSC-140DF | 14.0 | 12 | 16 | 73 |
| E2572150 | C3GSC-150DF | EQ572150 | R3GSC-150DF | 15.0 | 12 | 16 | 73 |
| E2572160 | C3GSC-160EF | EQ572160 | R3GSC-160EF | 16.0 | 16 | 19 | 79 |
| E2572180 | C3GSC-180EF | EQ572180 | R3GSC-180EF | 18.0 | 16 | 19 | 79 |
| E2572200 | C3GSC-200FF | EQ572200 | R3GSC-200FF | 20.0 | 20 | 22 | 88 |
| E2572220 | C3GSC-220FF | EQ572220 | R3GSC-220FF | 22.0 | 20 | 22 | 88 |
| E2572240 | C3GSC-240GF | EQ572240 | R3GSC-240GF | 24.0 | 25 | 26 | 102 |
| E2572250 | C3GSC-250GF | EQ572250 | R3GSC-250GF | 25.0 | 25 | 26 | 102 |
| E2572260 | C3GSC-260GF | EQ572260 | R3GSC-260GF | 26.0 | 25 | 26 | 102 |
| E2572280 | C3GSC-280GF | EQ572280 | R3GSC-280GF | 28.0 | 25 | 26 | 102 |
| E2572300 | C3GSC-300GF | EQ572300 | R3GSC-300GF | 30.0 | 25 | 26 | 102 |
| E2572320 | C3GSC-320HF | EQ572320 | R3GSC-320HF | 32.0 | 32 | 32 | 112 |

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 | | | | | | | | | |
| ◎ | ◎ | ○ | | | | | | | ○ | | | | | |



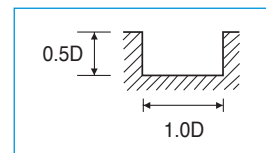
RECOMMENDED CUTTING CONDITIONS
EMPHOHLENE SCHNEIDKONDITIONEN

HSSCo8, 3 FLUTE - SLOTTING
HSSCo8, 3 SCHNEIDEN - NUTENFRÄSEN

E2572, E2573, E2516, E2553, E2554, E2551, E2552 SERIES

| MATERIAL | CARBON STEELS ALLOY STEELS TOOL STEELS | | | | CARBON STEELS ALLOY STEELS TOOL STEELS | | | | CARBON STEELS ALLOY STEELS TOOL STEELS | | | |
|----------|--|------|----|-------|--|------|----|-------|--|------|----|-------|
| | ~ 500N/mm ² | | | | ~ 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 | 35 | 35 | 0.002 | 4500 | 25 | 30 | 0.002 | 4000 | 20 | 25 | 0.002 |
| 3.0 | 3500 | 50 | 35 | 0.005 | 3200 | 35 | 30 | 0.004 | 2500 | 25 | 25 | 0.003 |
| 4.0 | 2800 | 60 | 35 | 0.007 | 2200 | 45 | 30 | 0.007 | 1800 | 30 | 25 | 0.006 |
| 5.0 | 2200 | 80 | 35 | 0.012 | 1800 | 55 | 30 | 0.010 | 1600 | 40 | 25 | 0.008 |
| 6.0 | 1800 | 80 | 35 | 0.015 | 1600 | 65 | 30 | 0.014 | 1200 | 40 | 25 | 0.011 |
| 8.0 | 1400 | 90 | 35 | 0.021 | 1100 | 70 | 30 | 0.021 | 900 | 50 | 25 | 0.019 |
| 10.0 | 1100 | 90 | 35 | 0.027 | 900 | 70 | 30 | 0.026 | 800 | 55 | 25 | 0.023 |
| 12.0 | 900 | 100 | 35 | 0.037 | 800 | 80 | 30 | 0.033 | 630 | 55 | 25 | 0.029 |
| 14.0 | 800 | 100 | 35 | 0.042 | 700 | 70 | 30 | 0.033 | 560 | 55 | 25 | 0.033 |
| 16.0 | 700 | 100 | 35 | 0.048 | 560 | 70 | 30 | 0.042 | 450 | 50 | 25 | 0.037 |
| 18.0 | 630 | 90 | 35 | 0.048 | 500 | 70 | 30 | 0.047 | 400 | 50 | 25 | 0.042 |
| 20.0 | 560 | 90 | 35 | 0.054 | 450 | 70 | 30 | 0.052 | 400 | 50 | 25 | 0.042 |
| 22.0 | 500 | 90 | 35 | 0.060 | 450 | 70 | 30 | 0.052 | 350 | 50 | 25 | 0.048 |
| 25.0 | 450 | 80 | 35 | 0.059 | 400 | 65 | 30 | 0.054 | 310 | 40 | 25 | 0.043 |
| 28.0 | 400 | 70 | 35 | 0.058 | 350 | 55 | 30 | 0.052 | 280 | 35 | 25 | 0.042 |
| 30.0 | 350 | 60 | 35 | 0.057 | 310 | 50 | 30 | 0.054 | 250 | 30 | 25 | 0.040 |
| 32.0 | 350 | 60 | 35 | 0.057 | 280 | 45 | 30 | 0.054 | 220 | 30 | 20 | 0.045 |
| 35.0 | 320 | 55 | 35 | 0.057 | 260 | 40 | 30 | 0.051 | 210 | 25 | 25 | 0.040 |
| 36.0 | 310 | 55 | 35 | 0.059 | 250 | 40 | 30 | 0.053 | 200 | 25 | 25 | 0.042 |
| 40.0 | 280 | 55 | 35 | 0.065 | 220 | 40 | 30 | 0.061 | 180 | 25 | 25 | 0.046 |

| 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 | 2200 | 10 | 15 | 0.002 | 12000 | 110 | 75 | 0.003 |
| 3.0 | 1600 | 15 | 15 | 0.003 | 11000 | 170 | 105 | 0.005 |
| 4.0 | 1100 | 20 | 15 | 0.006 | 8000 | 200 | 100 | 0.008 |
| 5.0 | 900 | 20 | 15 | 0.007 | 6300 | 210 | 100 | 0.011 |
| 6.0 | 800 | 25 | 15 | 0.010 | 5600 | 210 | 105 | 0.013 |
| 8.0 | 560 | 30 | 15 | 0.018 | 4000 | 260 | 100 | 0.022 |
| 10.0 | 450 | 30 | 15 | 0.022 | 3100 | 270 | 95 | 0.029 |
| 12.0 | 400 | 35 | 15 | 0.029 | 2500 | 260 | 95 | 0.035 |
| 14.0 | 350 | 35 | 15 | 0.033 | 2200 | 240 | 95 | 0.036 |
| 16.0 | 280 | 30 | 15 | 0.036 | 2000 | 240 | 100 | 0.040 |
| 18.0 | 250 | 30 | 15 | 0.040 | 1800 | 240 | 100 | 0.044 |
| 20.0 | 220 | 30 | 15 | 0.045 | 1600 | 220 | 100 | 0.046 |
| 22.0 | 220 | 30 | 15 | 0.045 | 1400 | 200 | 95 | 0.048 |
| 25.0 | 180 | 20 | 15 | 0.037 | 1200 | 190 | 95 | 0.053 |
| 28.0 | 160 | 20 | 15 | 0.042 | 1100 | 180 | 95 | 0.055 |
| 30.0 | 160 | 20 | 15 | 0.042 | 1100 | 180 | 105 | 0.055 |
| 32.0 | 140 | 20 | 15 | 0.048 | 1000 | 160 | 100 | 0.053 |
| 35.0 | 130 | 15 | 15 | 0.038 | 950 | 150 | 105 | 0.053 |
| 36.0 | 120 | 15 | 15 | 0.042 | 900 | 150 | 100 | 0.056 |
| 40.0 | 110 | 15 | 15 | 0.045 | 800 | 130 | 100 | 0.054 |



* 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, 3 FLUTE TiAlN COATED - SLOTTING
HSSCo8, 3 SCHNEIDEN TiAlN-BESCHICHTET - NUTENFRÄSEN

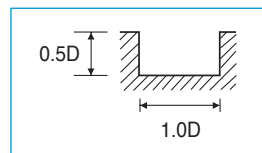
E2572, E2573, E2516, E2553, E2554, E2551, E2552 SERIES

| MATERIAL | CARBON STEELS ALLOY STEELS TOOL STEELS | | | | CARBON STEELS ALLOY STEELS TOOL STEELS | | | | CARBON STEELS ALLOY STEELS TOOL STEELS | | | |
|----------|--|------|----|-------|--|------|----|-------|--|------|----|-------|
| | ~ 500N/mm ² | | | | ~ HRC20 | | | | HRC20 ~ HRC30 | | | |
| HARDNESS | | | | | | | | | | | | |
| STRENGTH | | | | | 500 ~ 800N/mm ² | | | | 800 ~ 1000N/mm ² | | | |
| DIAMETER | RPM | FEED | Vc | fz | RPM | FEED | Vc | fz | RPM | FEED | Vc | fz |
| 2.0 | 7900 | 50 | 50 | 0.002 | 6300 | 35 | 40 | 0.002 | 5600 | 30 | 35 | 0.002 |
| 3.0 | 4900 | 70 | 45 | 0.005 | 4500 | 50 | 40 | 0.004 | 3500 | 35 | 35 | 0.003 |
| 4.0 | 3900 | 85 | 50 | 0.007 | 3100 | 60 | 40 | 0.006 | 2500 | 40 | 30 | 0.005 |
| 5.0 | 3100 | 110 | 50 | 0.012 | 2500 | 75 | 40 | 0.010 | 2200 | 55 | 35 | 0.008 |
| 6.0 | 2500 | 110 | 45 | 0.015 | 2200 | 90 | 40 | 0.014 | 1700 | 55 | 30 | 0.011 |
| 8.0 | 2000 | 125 | 50 | 0.021 | 1500 | 100 | 40 | 0.022 | 1300 | 70 | 35 | 0.018 |
| 10.0 | 1500 | 125 | 45 | 0.028 | 1300 | 110 | 40 | 0.028 | 1100 | 75 | 35 | 0.023 |
| 12.0 | 1300 | 140 | 50 | 0.036 | 1100 | 110 | 40 | 0.033 | 880 | 75 | 35 | 0.028 |
| 14.0 | 1100 | 140 | 50 | 0.042 | 980 | 100 | 45 | 0.034 | 780 | 75 | 35 | 0.032 |
| 16.0 | 980 | 140 | 50 | 0.048 | 780 | 100 | 40 | 0.043 | 630 | 70 | 30 | 0.037 |
| 18.0 | 880 | 125 | 50 | 0.047 | 700 | 100 | 40 | 0.048 | 560 | 70 | 30 | 0.042 |
| 20.0 | 780 | 125 | 50 | 0.053 | 630 | 100 | 40 | 0.053 | 560 | 70 | 35 | 0.042 |
| 22.0 | 700 | 125 | 50 | 0.060 | 630 | 100 | 45 | 0.053 | 490 | 70 | 35 | 0.048 |
| 25.0 | 630 | 110 | 50 | 0.058 | 560 | 90 | 45 | 0.054 | 430 | 55 | 35 | 0.043 |
| 28.0 | 560 | 100 | 50 | 0.060 | 490 | 75 | 45 | 0.051 | 390 | 50 | 35 | 0.043 |
| 30.0 | 490 | 85 | 45 | 0.058 | 430 | 70 | 40 | 0.054 | 350 | 40 | 35 | 0.038 |
| 32.0 | 490 | 85 | 50 | 0.058 | 390 | 65 | 40 | 0.056 | 310 | 40 | 30 | 0.043 |
| 35.0 | 450 | 80 | 50 | 0.059 | 360 | 60 | 40 | 0.056 | 290 | 35 | 30 | 0.040 |
| 36.0 | 430 | 75 | 50 | 0.058 | 350 | 55 | 40 | 0.052 | 280 | 35 | 30 | 0.042 |
| 40.0 | 390 | 75 | 50 | 0.064 | 310 | 55 | 40 | 0.059 | 250 | 35 | 30 | 0.047 |

| 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 | 15 | 20 | 0.002 | 16800 | 150 | 105 | 0.003 |
| 3.0 | 2200 | 20 | 20 | 0.003 | 15400 | 240 | 145 | 0.005 |
| 4.0 | 1500 | 30 | 20 | 0.007 | 11200 | 280 | 140 | 0.008 |
| 5.0 | 1300 | 30 | 20 | 0.008 | 8800 | 290 | 140 | 0.011 |
| 6.0 | 1100 | 35 | 20 | 0.011 | 7800 | 290 | 145 | 0.012 |
| 8.0 | 780 | 40 | 20 | 0.017 | 5600 | 360 | 140 | 0.021 |
| 10.0 | 630 | 40 | 20 | 0.021 | 4300 | 380 | 135 | 0.029 |
| 12.0 | 560 | 50 | 20 | 0.030 | 3500 | 360 | 130 | 0.034 |
| 14.0 | 490 | 50 | 20 | 0.034 | 3100 | 340 | 135 | 0.037 |
| 16.0 | 390 | 40 | 20 | 0.034 | 2800 | 340 | 140 | 0.040 |
| 18.0 | 350 | 40 | 20 | 0.038 | 2500 | 340 | 140 | 0.045 |
| 20.0 | 310 | 40 | 20 | 0.043 | 2200 | 310 | 140 | 0.047 |
| 22.0 | 310 | 40 | 20 | 0.043 | 1950 | 280 | 135 | 0.048 |
| 25.0 | 250 | 30 | 20 | 0.040 | 1700 | 270 | 135 | 0.053 |
| 28.0 | 220 | 30 | 20 | 0.045 | 1500 | 250 | 130 | 0.056 |
| 30.0 | 220 | 30 | 20 | 0.045 | 1500 | 250 | 140 | 0.056 |
| 32.0 | 200 | 30 | 20 | 0.050 | 1400 | 225 | 140 | 0.054 |
| 35.0 | 180 | 25 | 20 | 0.046 | 1300 | 215 | 145 | 0.055 |
| 36.0 | 170 | 20 | 20 | 0.039 | 1250 | 210 | 140 | 0.056 |
| 40.0 | 150 | 20 | 20 | 0.044 | 1100 | 180 | 140 | 0.055 |

* 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





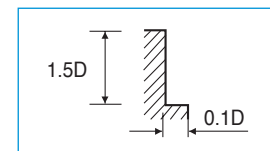
RECOMMENDED CUTTING CONDITIONS
EMPHOHLENE SCHNEIDKONDITIONEN

HSSCo8, 3 FLUTE - SIDE CUTTING
HSSCo8, 3 SCHNEIDEN - SEITENFRÄSEN

E2572, E2573, E2516, E2553, E2554, E2551, E2552 SERIES

| MATERIAL | CARBON STEELS ALLOY STEELS TOOL STEELS | | | | CARBON STEELS ALLOY STEELS TOOL STEELS | | | | CARBON STEELS ALLOY STEELS TOOL STEELS | | | |
|----------|--|------|----|-------|--|------|----|-------|--|------|----|-------|
| | ~ 500N/mm ² | | | | ~ HRC20 500 ~ 800N/mm ² | | | | HRC20 ~ HRC30 800 ~ 1000N/mm ² | | | |
| HARDNESS | | | | | | | | | | | | |
| STRENGTH | | | | | | | | | | | | |
| DIAMETER | RPM | FEED | Vc | fz | RPM | FEED | Vc | fz | RPM | FEED | Vc | fz |
| 2.0 | 5600 | 60 | 35 | 0.004 | 4500 | 40 | 30 | 0.003 | 4000 | 35 | 25 | 0.003 |
| 3.0 | 3500 | 80 | 35 | 0.008 | 3200 | 60 | 30 | 0.006 | 2500 | 45 | 25 | 0.006 |
| 4.0 | 2800 | 105 | 35 | 0.013 | 2200 | 75 | 30 | 0.011 | 1800 | 50 | 25 | 0.009 |
| 5.0 | 2200 | 135 | 35 | 0.020 | 1800 | 95 | 30 | 0.018 | 1600 | 65 | 25 | 0.014 |
| 6.0 | 1800 | 135 | 35 | 0.025 | 1600 | 110 | 30 | 0.023 | 1200 | 65 | 25 | 0.018 |
| 8.0 | 1400 | 150 | 35 | 0.036 | 1100 | 120 | 30 | 0.036 | 900 | 80 | 25 | 0.030 |
| 10.0 | 1100 | 150 | 35 | 0.045 | 900 | 120 | 30 | 0.044 | 800 | 90 | 25 | 0.038 |
| 12.0 | 900 | 165 | 35 | 0.061 | 800 | 135 | 30 | 0.056 | 630 | 90 | 25 | 0.048 |
| 14.0 | 800 | 165 | 35 | 0.069 | 700 | 120 | 30 | 0.057 | 560 | 90 | 25 | 0.054 |
| 16.0 | 700 | 165 | 35 | 0.079 | 560 | 120 | 30 | 0.071 | 450 | 80 | 25 | 0.059 |
| 18.0 | 630 | 150 | 35 | 0.079 | 500 | 120 | 30 | 0.080 | 400 | 80 | 25 | 0.067 |
| 20.0 | 560 | 150 | 35 | 0.089 | 450 | 120 | 30 | 0.089 | 400 | 80 | 25 | 0.067 |
| 22.0 | 500 | 150 | 35 | 0.100 | 450 | 120 | 30 | 0.089 | 350 | 80 | 25 | 0.076 |
| 25.0 | 450 | 135 | 35 | 0.100 | 400 | 110 | 30 | 0.092 | 310 | 65 | 25 | 0.070 |
| 28.0 | 400 | 120 | 35 | 0.100 | 350 | 95 | 30 | 0.090 | 280 | 60 | 25 | 0.071 |
| 30.0 | 350 | 105 | 35 | 0.100 | 310 | 80 | 30 | 0.086 | 250 | 55 | 25 | 0.073 |
| 32.0 | 350 | 105 | 35 | 0.100 | 280 | 75 | 30 | 0.089 | 220 | 50 | 20 | 0.076 |
| 35.0 | 320 | 95 | 35 | 0.099 | 260 | 65 | 30 | 0.083 | 210 | 45 | 25 | 0.071 |
| 36.0 | 310 | 90 | 35 | 0.097 | 250 | 65 | 30 | 0.087 | 200 | 45 | 25 | 0.075 |
| 40.0 | 280 | 90 | 35 | 0.107 | 220 | 65 | 30 | 0.098 | 180 | 45 | 25 | 0.083 |

| MATERIAL | CARBON STEELS ALLOY STEELS TOOL STEELS | | | | ALUMINUM ALUMINUM ALLOYS | | | |
|----------|---|------|----|-------|-----------------------------|------|-----|-------|
| | HRC30 ~ HRC40 1000 ~ 1300N/mm ² | | | | | | | |
| HARDNESS | | | | | | | | |
| STRENGTH | | | | | | | | |
| DIAMETER | RPM | FEED | Vc | fz | RPM | FEED | Vc | fz |
| 2.0 | 2200 | 15 | 15 | 0.002 | 12000 | 180 | 75 | 0.005 |
| 3.0 | 1600 | 20 | 15 | 0.004 | 11000 | 280 | 105 | 0.008 |
| 4.0 | 1100 | 30 | 15 | 0.009 | 8000 | 330 | 100 | 0.014 |
| 5.0 | 900 | 35 | 15 | 0.013 | 6300 | 350 | 100 | 0.019 |
| 6.0 | 800 | 45 | 15 | 0.019 | 5600 | 350 | 105 | 0.021 |
| 8.0 | 560 | 50 | 15 | 0.030 | 4000 | 440 | 100 | 0.037 |
| 10.0 | 450 | 50 | 15 | 0.037 | 3100 | 450 | 95 | 0.048 |
| 12.0 | 400 | 55 | 15 | 0.046 | 2500 | 430 | 95 | 0.057 |
| 14.0 | 350 | 55 | 15 | 0.052 | 2200 | 400 | 95 | 0.061 |
| 16.0 | 280 | 50 | 15 | 0.060 | 2000 | 400 | 100 | 0.067 |
| 18.0 | 250 | 50 | 15 | 0.067 | 1800 | 400 | 100 | 0.074 |
| 20.0 | 220 | 50 | 15 | 0.076 | 1600 | 360 | 100 | 0.075 |
| 22.0 | 220 | 50 | 15 | 0.076 | 1400 | 340 | 95 | 0.081 |
| 25.0 | 180 | 35 | 15 | 0.065 | 1200 | 320 | 95 | 0.089 |
| 28.0 | 160 | 30 | 15 | 0.063 | 1100 | 300 | 95 | 0.091 |
| 30.0 | 160 | 30 | 15 | 0.063 | 1100 | 300 | 105 | 0.091 |
| 32.0 | 140 | 30 | 15 | 0.071 | 1000 | 270 | 100 | 0.090 |
| 35.0 | 130 | 25 | 15 | 0.064 | 950 | 260 | 105 | 0.091 |
| 36.0 | 120 | 25 | 15 | 0.069 | 900 | 250 | 100 | 0.093 |
| 40.0 | 110 | 25 | 15 | 0.076 | 800 | 220 | 100 | 0.092 |



* 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, 3 FLUTE TiAlN COATED - SIDE CUTTING
HSSCo8, 3 SCHNEIDEN TiAlN-BESCHICHTET - SEITENFRÄSEN

E2572, E2573, E2516, E2553, E2554, E2551, E2552 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 | 7900 | 85 | 50 | 0.004 | 6300 | 55 | 40 | 0.003 | 5600 | 50 | 35 | 0.003 |
| 3.0 | 4900 | 110 | 45 | 0.007 | 4500 | 85 | 40 | 0.006 | 3500 | 60 | 35 | 0.006 |
| 4.0 | 3900 | 145 | 50 | 0.012 | 3100 | 105 | 40 | 0.011 | 2500 | 70 | 30 | 0.009 |
| 5.0 | 3100 | 190 | 50 | 0.020 | 2500 | 130 | 40 | 0.017 | 2200 | 90 | 35 | 0.014 |
| 6.0 | 2500 | 190 | 45 | 0.025 | 2200 | 155 | 40 | 0.023 | 1700 | 90 | 30 | 0.018 |
| 8.0 | 2000 | 210 | 50 | 0.035 | 1500 | 170 | 40 | 0.038 | 1300 | 110 | 35 | 0.028 |
| 10.0 | 1500 | 210 | 45 | 0.047 | 1300 | 170 | 40 | 0.044 | 1100 | 125 | 35 | 0.038 |
| 12.0 | 1300 | 230 | 50 | 0.059 | 1100 | 190 | 40 | 0.058 | 880 | 125 | 35 | 0.047 |
| 14.0 | 1100 | 230 | 50 | 0.070 | 980 | 170 | 45 | 0.058 | 780 | 125 | 35 | 0.053 |
| 16.0 | 980 | 230 | 50 | 0.078 | 780 | 170 | 40 | 0.073 | 630 | 110 | 30 | 0.058 |
| 18.0 | 880 | 210 | 50 | 0.080 | 700 | 170 | 40 | 0.081 | 560 | 110 | 30 | 0.065 |
| 20.0 | 780 | 210 | 50 | 0.090 | 630 | 170 | 40 | 0.090 | 560 | 110 | 35 | 0.065 |
| 22.0 | 700 | 210 | 50 | 0.100 | 630 | 170 | 45 | 0.090 | 490 | 110 | 35 | 0.075 |
| 25.0 | 630 | 190 | 50 | 0.101 | 560 | 155 | 45 | 0.092 | 430 | 90 | 35 | 0.070 |
| 28.0 | 560 | 170 | 50 | 0.101 | 490 | 130 | 45 | 0.088 | 390 | 85 | 35 | 0.073 |
| 30.0 | 490 | 145 | 45 | 0.099 | 430 | 110 | 40 | 0.085 | 350 | 75 | 35 | 0.071 |
| 32.0 | 490 | 145 | 50 | 0.099 | 390 | 105 | 40 | 0.090 | 310 | 70 | 30 | 0.075 |
| 35.0 | 450 | 130 | 50 | 0.096 | 360 | 95 | 40 | 0.088 | 290 | 65 | 30 | 0.075 |
| 36.0 | 430 | 125 | 50 | 0.097 | 350 | 90 | 40 | 0.086 | 280 | 65 | 30 | 0.077 |
| 40.0 | 390 | 125 | 50 | 0.107 | 310 | 90 | 40 | 0.097 | 250 | 65 | 30 | 0.087 |

| 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 | 0.002 | 16800 | 250 | 105 | 0.005 |
| 3.0 | 2200 | 30 | 20 | 0.005 | 15400 | 390 | 145 | 0.008 |
| 4.0 | 1500 | 40 | 20 | 0.009 | 11200 | 460 | 140 | 0.014 |
| 5.0 | 1300 | 50 | 20 | 0.013 | 8800 | 490 | 140 | 0.019 |
| 6.0 | 1100 | 60 | 20 | 0.018 | 7800 | 490 | 145 | 0.021 |
| 8.0 | 780 | 70 | 20 | 0.030 | 5600 | 620 | 140 | 0.037 |
| 10.0 | 630 | 70 | 20 | 0.037 | 4300 | 630 | 135 | 0.049 |
| 12.0 | 560 | 75 | 20 | 0.045 | 3500 | 600 | 130 | 0.057 |
| 14.0 | 490 | 75 | 20 | 0.051 | 3100 | 560 | 135 | 0.060 |
| 16.0 | 390 | 70 | 20 | 0.060 | 2800 | 560 | 140 | 0.067 |
| 18.0 | 350 | 70 | 20 | 0.067 | 2500 | 560 | 140 | 0.075 |
| 20.0 | 310 | 70 | 20 | 0.075 | 2200 | 500 | 140 | 0.076 |
| 22.0 | 310 | 70 | 20 | 0.075 | 1950 | 480 | 135 | 0.082 |
| 25.0 | 250 | 50 | 20 | 0.067 | 1700 | 450 | 135 | 0.088 |
| 28.0 | 220 | 40 | 20 | 0.061 | 1500 | 420 | 130 | 0.093 |
| 30.0 | 220 | 40 | 20 | 0.061 | 1500 | 420 | 140 | 0.093 |
| 32.0 | 200 | 40 | 20 | 0.067 | 1400 | 380 | 140 | 0.090 |
| 35.0 | 180 | 35 | 20 | 0.065 | 1300 | 360 | 145 | 0.092 |
| 36.0 | 170 | 35 | 20 | 0.069 | 1250 | 350 | 140 | 0.093 |
| 40.0 | 150 | 35 | 20 | 0.078 | 1100 | 310 | 140 | 0.094 |

* 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

