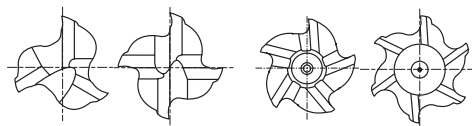


HSSCo8, MULTI FLUTE SHORT LENGTH ROUGHING - COARSE
HSSCo8, MULTI SCHNEIDEN KURZ SCHRUPPFRÄSER - GROB



Up to Ø20mm

Over Ø20mm



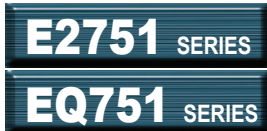
P.1248, 1249

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
UNCOATED	TiAlN	js12	h6			
E2751060	EQ751060	6.0	6	13	57	3
E2751070	EQ751070	7.0	10	16	66	3
E2751080	EQ751080	8.0	10	19	69	3
E2751090	EQ751090	9.0	10	19	69	3
E2751095	EQ751095	9.5	10	19	69	3
E2751100	EQ751100	10.0	10	22	72	4
E2751110	EQ751110	11.0	12	22	79	4
E2751120	EQ751120	12.0	12	26	83	4
E2751125	EQ751125	12.5	12	26	83	4
E2751130	EQ751130	13.0	12	26	83	4
E2751140	EQ751140	14.0	12	26	83	4
E2751145	EQ751145	14.5	12	26	83	4
E2751150	EQ751150	15.0	12	26	83	4
E2751160	EQ751160	16.0	16	32	92	4
E2751170	EQ751170	17.0	16	32	92	4
E2751180	EQ751180	18.0	16	32	92	4
E2751190	EQ751190	19.0	16	32	92	4
E2751200	EQ751200	20.0	20	38	104	4
E2751901	EQ751901	20.0	16	38	98	4
E2751220	EQ751220	22.0	20	38	104	5
E2751240	EQ751240	24.0	25	45	121	5
E2751250	EQ751250	25.0	25	45	121	5
E2751260	EQ751260	26.0	25	45	121	6
E2751280	EQ751280	28.0	25	45	121	6
E2751300	EQ751300	30.0	25	45	121	6

◎ : 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									
◎	◎	○							○					

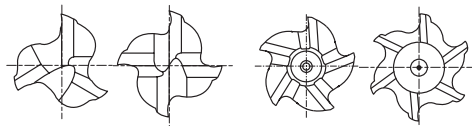


FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

HSSCo8, MULTI FLUTE SHORT LENGTH ROUGHING - COARSE

HSSCo8, MULTI SCHNEIDEN KURZ SCHRUPPFRÄSER - GROB



Up to Ø20mm

Over Ø20mm

HSS Co8
DIN 844
NR
COARSE
3-6
30°
DIN 1835B
~Ø20
Ø22~
P.1248, 1249

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
UNCOATED	TiAIN	js12	h6			
E2751320	EQ751320	32.0	32	53	133	6
E2751340	EQ751340	34.0	32	53	133	6
E2751350	EQ751350	35.0	32	53	133	6
E2751360	EQ751360	36.0	32	53	133	6
E2751380	EQ751380	38.0	32	63	155	6
E2751938	EQ751938	38.0	40	63	155	6
E2751400	EQ751400	40.0	32	63	155	6
E2751940	EQ751940	40.0	40	63	155	6
E2751450	EQ751450	45.0	32	63	143	6
E2751500	EQ751500	50.0	50	75	177	6

- ▶ 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
js12	± 50	± 60	± 75	± 90	± 105	± 125
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									
◎	◎	○							○					

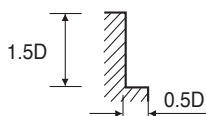


HSSCo8, MULTI FLUTE ROUGHING - SIDE CUTTING
HSSCo8, MULTI SCHNEIDEN SCHRUPPFRÄSER - SEITENFRÄSEN

E2751, E2752, E2764, E2765, E2761, E2753, E2762, E2777, E2778 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
6.0	1800	80	35	0.015	1600	60	30	0.013	1200	55	25	0.015
8.0	1400	105	35	0.025	1100	75	30	0.023	900	65	25	0.024
10.0	1100	150	35	0.034	900	120	30	0.033	800	110	25	0.034
12.0	900	180	35	0.050	800	140	30	0.044	630	110	25	0.044
14.0	800	180	35	0.056	700	140	30	0.050	560	110	25	0.049
16.0	700	180	35	0.064	560	140	30	0.063	450	110	25	0.061
18.0	630	180	35	0.071	500	140	30	0.070	400	110	25	0.069
20.0	560	180	35	0.080	450	140	30	0.078	400	110	25	0.069
22.0	500	220	35	0.088	450	170	30	0.076	350	140	25	0.080
25.0	450	220	35	0.098	400	170	30	0.085	310	140	25	0.090
28.0	400	210	35	0.088	350	160	30	0.076	280	130	25	0.077
30.0	350	210	35	0.100	310	160	30	0.086	250	130	25	0.087
32.0	350	210	35	0.100	280	160	30	0.095	220	130	20	0.098
36.0	310	210	35	0.113	250	160	30	0.107	200	130	25	0.108
40.0	280	200	35	0.119	220	150	30	0.114	180	120	25	0.111
50.0	220	200	35	0.152	180	170	30	0.157	160	140	25	0.146

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
6.0	800	30	15	0.013	4500	200	85	0.015
8.0	560	35	15	0.021	3100	230	80	0.025
10.0	450	60	15	0.033	2500	350	80	0.035
12.0	400	70	15	0.044	2000	400	75	0.050
14.0	350	70	15	0.050	1800	420	80	0.058
16.0	280	70	15	0.063	1600	450	80	0.070
18.0	250	70	15	0.070	1400	470	80	0.084
20.0	220	70	15	0.080	1200	500	75	0.104
22.0	220	85	15	0.077	1100	470	75	0.085
25.0	180	85	15	0.094	1000	450	80	0.090
28.0	160	85	15	0.089	900	510	80	0.094
30.0	160	85	15	0.089	900	530	85	0.098
32.0	140	85	15	0.101	800	500	80	0.104
36.0	120	85	15	0.118	700	470	80	0.112
40.0	110	80	15	0.121	630	450	80	0.119
50.0	90	80	15	0.148	500	370	80	0.123



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

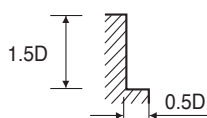
RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

HSSCo8, MULTI FLUTE ROUGHING TiAlN COATED - SIDE CUTTING
HSSCo8, MULTI SCHNEIDEN SCHRUPPFRÄSER TiAlN-BESCHICHTET - SEITENFRÄSEN

E2751, E2752, E2764, E2765, E2761, E2753, E2762, E2777, E2778 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
6.0	2500	110	45	0.015	2250	85	40	0.013	1700	75	30	0.015
8.0	1950	145	50	0.025	1550	105	40	0.023	1250	90	30	0.024
10.0	1550	210	50	0.034	1250	170	40	0.034	1100	155	35	0.035
12.0	1250	250	45	0.050	1100	195	40	0.044	900	155	35	0.043
14.0	1100	250	50	0.057	1000	195	45	0.049	800	155	35	0.048
16.0	1000	250	50	0.063	800	195	40	0.061	650	155	35	0.060
18.0	900	250	50	0.069	700	195	40	0.070	550	155	30	0.070
20.0	800	250	50	0.078	650	195	40	0.075	550	155	35	0.070
22.0	700	310	50	0.089	650	240	45	0.074	500	195	35	0.078
25.0	650	310	50	0.095	550	240	45	0.087	450	195	35	0.087
28.0	550	295	50	0.089	500	225	45	0.075	400	180	35	0.075
30.0	500	295	45	0.098	450	225	40	0.083	350	180	35	0.086
32.0	500	295	50	0.098	400	225	40	0.094	300	180	30	0.100
36.0	450	295	50	0.109	350	225	40	0.107	300	180	35	0.100
40.0	400	280	50	0.117	300	210	40	0.117	250	170	30	0.113
50.0	300	280	45	0.156	250	240	40	0.160	220	195	35	0.148

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
6.0	1100	40	20	0.012	6300	280	120	0.015
8.0	800	50	20	0.021	4350	320	110	0.025
10.0	650	85	20	0.033	3500	490	110	0.035
12.0	550	100	20	0.045	2800	560	105	0.050
14.0	500	100	20	0.050	2500	590	110	0.059
16.0	400	100	20	0.063	2250	630	115	0.070
18.0	350	100	20	0.071	1950	660	110	0.085
20.0	300	100	20	0.083	1700	700	105	0.103
22.0	300	120	20	0.080	1550	660	105	0.085
25.0	250	120	20	0.096	1400	630	110	0.090
28.0	220	120	20	0.091	1250	715	110	0.095
30.0	220	120	20	0.091	1250	740	120	0.099
32.0	200	120	20	0.100	1100	700	110	0.106
36.0	170	120	20	0.118	1000	660	115	0.110
40.0	130	110	15	0.141	900	630	115	0.117
50.0	120	110	20	0.153	700	520	110	0.124



※ 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