

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN
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HSSCo8, 3 FLUTE 37° HELIX SHORT LENGTH ROUGHING HSSCo8, 3 SCHNEIDEN 37° RECHTSSPIRALE KURZ SCHRUPPFRÄSER

for ALUMINUM
für ALUMINIUM



HSS Co8
DIN 844
WR
ALU
3
37°
DIN 1835B
P.1250, 1251

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	js12	h6		
E2755060	6.0	6	13	57
E2755080	8.0	10	19	69
E2755100	10.0	10	22	72
E2755120	12.0	12	26	83
E2755140	14.0	12	26	83
E2755160	16.0	16	32	92
E2755180	18.0	16	32	92
E2755200	20.0	20	38	104
E2755220	22.0	20	38	104
E2755250	25.0	25	45	121
E2755300	30.0	25	45	121

- ▶ 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

- CBN END MILLS
- i-Xmill END MILLS
- i-HS mill END MILLS
- X5070 END MILLS
- 4G MILL END MILLS
- X-SPEED ROUGHER END MILLS
- X-POWER END MILLS
- JET-POWER END MILLS
- TN MILL END MILLS
- V7 Mill END MILLS
- ALU-POWER END MILLS
- CRX S END MILLS
- D-POWER GRAPHITE END MILLS
- D-POWER CFRP END MILLS
- ROUTERS
- K-2 CARBIDE END MILLS
- GENERAL CARBIDE END MILLS
- TANK-POWER END MILLS
- GENERAL HSS END MILLS
- MILLING CUTTERS
- TECHNICAL DATA

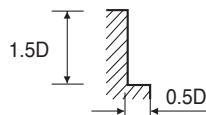
◎ : Excellent ○ : Good

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**
E2755, E2756 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
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	0.045	900	120	30	0.044	800	110	25	0.046
12.0	900	180	35	0.067	800	140	30	0.058	630	110	25	0.058
14.0	800	180	35	0.075	700	140	30	0.067	560	110	25	0.065
16.0	700	180	35	0.086	560	140	30	0.083	450	110	25	0.081
18.0	630	180	35	0.095	500	140	30	0.093	400	110	25	0.092
20.0	560	180	35	0.107	450	140	30	0.104	400	110	25	0.092
22.0	500	220	35	0.147	450	170	30	0.126	350	140	25	0.133
25.0	450	220	35	0.163	400	170	30	0.142	310	140	25	0.151
30.0	350	210	35	0.200	310	160	30	0.172	250	130	25	0.173

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
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	0.044	2500	350	80	0.047
12.0	400	70	15	0.058	2000	400	75	0.067
14.0	350	70	15	0.067	1800	420	80	0.078
16.0	280	70	15	0.083	1600	450	80	0.094
18.0	250	70	15	0.093	1400	470	80	0.112
20.0	220	70	15	0.106	1200	500	75	0.139
22.0	220	85	15	0.129	1100	470	75	0.142
25.0	180	85	15	0.157	1000	450	80	0.150
30.0	160	85	15	0.177	900	530	85	0.196



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

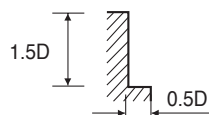
RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

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

E2755, E2756 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
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	0.045	1250	170	40	0.045	1100	155	35	0.047
12.0	1250	250	45	0.067	1100	195	40	0.059	900	155	35	0.057
14.0	1100	250	50	0.076	1000	195	45	0.065	800	155	35	0.065
16.0	1000	250	50	0.083	800	195	40	0.081	650	155	35	0.079
18.0	900	250	50	0.093	700	195	40	0.093	550	155	30	0.094
20.0	800	250	50	0.104	650	195	40	0.100	550	155	35	0.094
22.0	700	310	50	0.148	650	240	45	0.123	500	195	35	0.130
25.0	650	310	50	0.159	550	240	45	0.145	450	195	35	0.144
30.0	500	295	45	0.197	450	225	40	0.167	350	180	35	0.171

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
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	0.044	3500	490	110	0.047
12.0	550	100	20	0.061	2800	560	105	0.067
14.0	500	100	20	0.067	2500	590	110	0.079
16.0	400	100	20	0.083	2250	630	115	0.093
18.0	350	100	20	0.095	1950	660	110	0.113
20.0	300	100	20	0.111	1700	700	105	0.137
22.0	300	120	20	0.133	1550	660	105	0.142
25.0	250	120	20	0.160	1400	630	110	0.150
30.0	220	120	20	0.182	1250	740	120	0.197



※ 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