

HSSCo8, 2 FLUTE LONG LENGTH BALL NOSE HSSCo8, 2 SCHNEIDEN LANG STIRNRADIUS


 HSS
Co8

 DIN
1889

N

2

 30°

 R
±0.02

 DIN
1835B




P.1244, 1245

Unit : mm

EDP No.	ITEM No.	EDP No.	ITEM No.	Radius of Ball Nose R (±0.02)	Mill Diameter e8	Shank Diameter h6	Length of Cut	Overall Length
UNCOATED	UNCOATED	TiAIN	TiAIN					
E2492020	C2GLB-020AF	EQ492020	R2GLB-020AF	R1.0	2.0	6	7	54
E2492030	C2GLB-030AF	EQ492030	R2GLB-030AF	R1.5	3.0	6	8	56
E2492040	C2GLB-040AF	EQ492040	R2GLB-040AF	R2.0	4.0	6	11	63
E2492050	C2GLB-050AF	EQ492050	R2GLB-050AF	R2.5	5.0	6	13	68
E2492060	C2GLB-060AF	EQ492060	R2GLB-060AF	R3.0	6.0	6	13	68
E2492070	C2GLB-070TF	EQ492070	R2GLB-070TF	R3.5	7.0	10	16	80
E2492080	C2GLB-080TF	EQ492080	R2GLB-080TF	R4.0	8.0	10	19	88
E2492090	C2GLB-090TF	EQ492090	R2GLB-090TF	R4.5	9.0	10	19	88
E2492100	C2GLB-100TF	EQ492100	R2GLB-100TF	R5.0	10.0	10	22	95
E2492110	C2GLB-110DF	EQ492110	R2GLB-110DF	R5.5	11.0	12	22	102
E2492120	C2GLB-120DF	EQ492120	R2GLB-120DF	R6.0	12.0	12	26	110
E2492130	C2GLB-130DF	EQ492130	R2GLB-130DF	R6.5	13.0	12	26	110
E2492140	C2GLB-140DF	EQ492140	R2GLB-140DF	R7.0	14.0	12	26	110
E2492150	C2GLB-150DF	EQ492150	R2GLB-150DF	R7.5	15.0	12	26	110
E2492160	C2GLB-160EF	EQ492160	R2GLB-160EF	R8.0	16.0	16	32	123
E2492170	C2GLB-170EF	EQ492170	R2GLB-170EF	R8.5	17.0	16	32	123
E2492180	C2GLB-180EF	EQ492180	R2GLB-180EF	R9.0	18.0	16	32	123
E2492190	C2GLB-190EF	EQ492190	R2GLB-190EF	R9.5	19.0	16	32	123
E2492200	C2GLB-200FF	EQ492200	R2GLB-200FF	R10.0	20.0	20	38	141
E2492220	C2GLB-220FF	EQ492220	R2GLB-220FF	R11.0	22.0	20	38	141
E2492240	C2GLB-240GF	EQ492240	R2GLB-240GF	R12.0	24.0	25	45	166
E2492250	C2GLB-250GF	EQ492250	R2GLB-250GF	R12.5	25.0	25	45	166
E2492260	C2GLB-260GF	EQ492260	R2GLB-260GF	R13.0	26.0	25	45	166
E2492280	C2GLB-280GF	EQ492280	R2GLB-280GF	R14.0	28.0	25	45	166
E2492300	C2GLB-300GF	EQ492300	R2GLB-300GF	R15.0	30.0	25	45	166

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6

▶ Other shank design on your request.

▶ TiN-COATING & TiCN-COATING are available on your request.

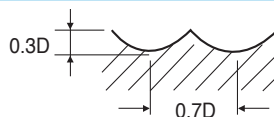
◎ : Excellent ○ : Good

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 BALL NOSE
HSSCo8, 2 SCHNEIDEN STIRNRADIUS
E2535, E2492 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
R1.5 × 3.0	4500	95	40	0.011	3400	70	30	0.010	2000	30	20	0.008
R2.0 × 4.0	3200	115	40	0.018	2400	80	30	0.017	1400	35	20	0.013
R3.0 × 6.0	2200	135	40	0.031	1700	90	30	0.026	1000	45	20	0.023
R4.0 × 8.0	1600	160	40	0.050	1200	105	30	0.044	700	50	20	0.036
R5.0 × 10.0	1300	180	40	0.069	1000	120	30	0.060	560	60	20	0.054
R6.0 × 12.0	1000	170	40	0.085	800	105	30	0.066	450	55	15	0.061
R8.0 × 16.0	800	150	40	0.094	600	100	30	0.083	350	55	20	0.079
R10.0 × 20.0	600	140	40	0.117	500	85	30	0.085	300	50	20	0.083
R12.5 × 25.0	500	130	40	0.130	400	70	30	0.088	220	40	15	0.091

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
R1.5 × 3.0	1400	20	15	0.007	11000	230	105	0.010
R2.0 × 4.0	1000	25	15	0.013	8000	260	100	0.016
R3.0 × 6.0	700	25	15	0.018	5600	280	105	0.025
R4.0 × 8.0	500	30	15	0.030	4000	350	100	0.044
R5.0 × 10.0	400	35	15	0.044	3200	360	100	0.056
R6.0 × 12.0	320	35	10	0.055	2500	340	95	0.068
R8.0 × 16.0	250	35	15	0.070	2000	300	100	0.075
R10.0 × 20.0	200	35	15	0.088	1600	280	100	0.088
R12.5 × 25.0	160	30	15	0.094	1300	250	100	0.096



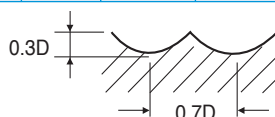
※ The FEED, in long & extra long types, should be reduced by around 50%

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

HSSCo8, 2 FLUTE BALL NOSE TiAlN COATED
HSSCo8, 2 SCHNEIDEN STIRNRADIUS TiAlN-BESCHICHTET
E2535, E2492 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
R1.5 × 3.0	6300	135	60	0.011	4750	100	45	0.011	2800	40	25	0.007
R2.0 × 4.0	4500	160	55	0.018	3350	110	40	0.016	1950	50	25	0.013
R3.0 × 6.0	3100	190	60	0.031	2400	125	45	0.026	1400	65	25	0.023
R4.0 × 8.0	2250	225	55	0.050	1700	145	45	0.043	1000	70	25	0.035
R5.0 × 10.0	1800	250	55	0.069	1400	170	45	0.061	800	85	25	0.053
R6.0 × 12.0	1400	240	55	0.086	1100	145	40	0.066	650	75	25	0.058
R8.0 × 16.0	1100	210	55	0.095	850	140	45	0.082	500	75	25	0.075
R10.0 × 20.0	850	195	55	0.115	700	120	45	0.086	400	70	25	0.088
R12.5 × 25.0	700	180	55	0.129	550	100	45	0.091	300	55	25	0.092

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
R1.5 × 3.0	1950	30	20	0.008	15400	320	145	0.010
R2.0 × 4.0	1400	35	20	0.013	11200	365	140	0.016
R3.0 × 6.0	1000	35	20	0.018	7850	390	150	0.025
R4.0 × 8.0	700	40	20	0.029	5600	490	140	0.044
R5.0 × 10.0	550	50	15	0.045	4500	505	140	0.056
R6.0 × 12.0	450	50	15	0.056	3500	475	130	0.068
R8.0 × 16.0	350	50	20	0.071	2800	420	140	0.075
R10.0 × 20.0	300	50	20	0.083	2250	390	140	0.087
R12.5 × 25.0	200	40	15	0.100	1800	350	140	0.097



※ 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