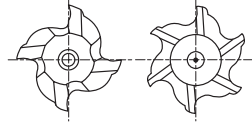


HSSCo8, 4&6 FLUTE SHORT LENGTH
HSSCo8, 4&6 SCHNEIDEN KURZ


P.1238, 1239

Unit : mm

EDP No.	ITEM No.	EDP No.	ITEM No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
UNCOATED	UNCOATED	TiAIN	TiAIN					
E2574020	C4GRS-020AF	EQ574020	R4GRS-020AF	2.0	6	7	51	4
E2574025	C4GRS-025AF	EQ574025	R4GRS-025AF	2.5	6	8	52	4
E2574030	C4GRS-030AF	EQ574030	R4GRS-030AF	3.0	6	8	52	4
E2574035	C4GRS-035AF	EQ574035	R4GRS-035AF	3.5	6	10	54	4
E2574040	C4GRS-040AF	EQ574040	R4GRS-040AF	4.0	6	11	55	4
E2574050	C4GRS-050AF	EQ574050	R4GRS-050AF	5.0	6	13	57	4
E2574060	C4GRS-060AF	EQ574060	R4GRS-060AF	6.0	6	13	57	4
E2574070	C4GRS-070TF	EQ574070	R4GRS-070TF	7.0	10	16	66	4
E2574080	C4GRS-080TF	EQ574080	R4GRS-080TF	8.0	10	19	69	4
E2574090	C4GRS-090TF	EQ574090	R4GRS-090TF	9.0	10	19	69	4
E2574100	C4GRS-100TF	EQ574100	R4GRS-100TF	10.0	10	22	72	4
E2574110	C4GRS-110DF	EQ574110	R4GRS-110DF	11.0	12	22	79	4
E2574120	C4GRS-120DF	EQ574120	R4GRS-120DF	12.0	12	26	83	4
E2574130	C4GRS-130DF	EQ574130	R4GRS-130DF	13.0	12	26	83	4
E2574140	C4GRS-140DF	EQ574140	R4GRS-140DF	14.0	12	26	83	4
E2574150	C4GRS-150DF	EQ574150	R4GRS-150DF	15.0	12	26	83	4
E2574160	C4GRS-160EF	EQ574160	R4GRS-160EF	16.0	16	32	92	4
E2574170	C4GRS-170EF	EQ574170	R4GRS-170EF	17.0	16	32	92	4
E2574180	C4GRS-180EF	EQ574180	R4GRS-180EF	18.0	16	32	92	4
E2574190	C4GRS-190EF	EQ574190	R4GRS-190EF	19.0	16	32	92	4
E2574200	C4GRS-200FF	EQ574200	R4GRS-200FF	20.0	20	38	104	4
E2575210	C6GRS-210FF	EQ575210	R6GRS-210FF	21.0	20	38	104	6
E2575220	C6GRS-220FF	EQ575220	R6GRS-220FF	22.0	20	38	104	6
E2575230	C6GRS-230FF	EQ575230	R6GRS-230FF	23.0	20	38	104	6
E2575240	C6GRS-240GF	EQ575240	R6GRS-240GF	24.0	25	45	121	6
E2575250	C6GRS-250GF	EQ575250	R6GRS-250GF	25.0	25	45	121	6
E2575260	C6GRS-260GF	EQ575260	R6GRS-260GF	26.0	25	45	121	6
E2575280	C6GRS-280GF	EQ575280	R6GRS-280GF	28.0	25	45	121	6
E2575300	C6GRS-300GF	EQ575300	R6GRS-300GF	30.0	25	45	121	6
E2575320	C6GRS-320HF	EQ575320	R6GRS-320HF	32.0	32	53	133	6
E2575340	C6GRS-340HF	EQ575340	R6GRS-340HF	34.0	32	53	133	6
E2575350	C6GRS-350HF	EQ575350	R6GRS-350HF	35.0	32	53	133	6
E2575360	C6GRS-360HF	EQ575360	R6GRS-360HF	36.0	32	53	133	6
E2575400	C6GRS-400HF	EQ575400	R6GRS-400HF	40.0	32	63	143	6

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~+0.04	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									
◎	◎	○						○					

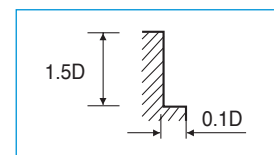

**HSSCo8, MULTI FLUTE - SIDE CUTTING
HSSCo8, MULTI SCHNEIDEN - SEITENFRÄSEN**
E2574, E2575, E2576, E2577, E2597, E2598, E2776 SERIES

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
2.0	5600	80	35	0.004	4500	55	30	0.003	4000	45	25	0.003
3.0	3500	110	35	0.008	3200	80	30	0.006	2500	60	25	0.006
4.0	2800	140	35	0.013	2200	100	30	0.011	1800	65	25	0.009
5.0	2200	180	35	0.020	1800	125	30	0.017	1600	90	25	0.014
6.0	1800	180	35	0.025	1600	145	30	0.023	1200	90	25	0.019
8.0	1400	200	35	0.036	1100	160	30	0.036	900	105	25	0.029
10.0	1100	200	35	0.045	900	160	30	0.044	800	120	25	0.038
12.0	900	220	35	0.061	800	180	30	0.056	630	120	25	0.048
14.0	800	220	35	0.069	700	160	30	0.057	560	120	25	0.054
16.0	700	220	35	0.079	560	160	30	0.071	450	105	25	0.058
18.0	630	200	35	0.079	500	160	30	0.080	400	105	25	0.066
20.0	560	200	35	0.089	450	160	30	0.089	400	105	25	0.066
22.0	500	200	35	0.067	450	160	30	0.059	350	105	25	0.050
25.0	450	180	35	0.067	400	145	30	0.060	310	90	25	0.048
28.0	400	160	35	0.067	350	125	30	0.060	280	80	25	0.048
30.0	350	140	35	0.067	310	110	30	0.059	250	75	25	0.050
32.0	350	140	35	0.067	280	100	30	0.060	220	65	20	0.049
36.0	310	120	35	0.065	250	90	30	0.060	200	60	25	0.050
40.0	280	120	35	0.071	220	90	30	0.068	180	60	25	0.056

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
2.0	2200	20	15	0.002	12000	240	75	0.005
3.0	1600	30	15	0.005	11000	380	105	0.009
4.0	1100	45	15	0.010	8000	440	100	0.014
5.0	900	50	15	0.014	6300	470	100	0.019
6.0	800	60	15	0.019	5600	470	105	0.021
8.0	560	65	15	0.029	4000	580	100	0.036
10.0	450	65	15	0.036	3100	600	95	0.048
12.0	400	75	15	0.047	2500	570	95	0.057
14.0	350	75	15	0.054	2200	530	95	0.060
16.0	280	65	15	0.058	2000	530	100	0.066
18.0	250	65	15	0.065	1800	530	100	0.074
20.0	220	65	15	0.074	1600	480	100	0.075
22.0	220	65	15	0.049	1400	450	95	0.054
25.0	180	50	15	0.046	1200	420	95	0.058
28.0	160	45	15	0.047	1100	400	95	0.061
30.0	160	45	15	0.047	1100	400	105	0.061
32.0	140	45	15	0.054	1000	360	100	0.060
36.0	120	35	15	0.049	900	330	100	0.061
40.0	110	35	15	0.053	800	300	100	0.063

※ 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 TiAIN COATED - SIDE CUTTING
HSSCo8, MULTI SCHNEIDEN TiAIN-BESCHICHTET - SEITENFRÄSEN
E2574, E2575, E2576, E2577, E2597, E2598, E2776 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
2.0	7850	110	50	0.004	6300	75	40	0.003	5600	65	35	0.003
3.0	4900	155	45	0.008	4500	110	40	0.006	3500	85	35	0.006
4.0	3900	195	50	0.013	3100	140	40	0.011	2500	90	30	0.009
5.0	3100	250	50	0.020	2500	175	40	0.018	2250	125	35	0.014
6.0	2500	250	45	0.025	2250	205	40	0.023	1700	125	30	0.018
8.0	1950	280	50	0.036	1550	225	40	0.036	1250	145	30	0.029
10.0	1550	280	50	0.045	1250	225	40	0.045	1100	170	35	0.039
12.0	1250	310	45	0.062	1100	250	40	0.057	900	170	35	0.047
14.0	1100	310	50	0.070	1000	225	45	0.056	800	170	35	0.053
16.0	1000	310	50	0.078	800	225	40	0.070	650	145	35	0.056
18.0	900	280	50	0.078	700	225	40	0.080	550	145	30	0.066
20.0	800	280	50	0.088	650	225	40	0.087	550	145	35	0.066
22.0	700	280	50	0.067	650	225	45	0.058	500	145	35	0.048
25.0	650	250	50	0.064	550	205	45	0.062	450	125	35	0.046
28.0	550	225	50	0.068	500	175	45	0.058	400	110	35	0.046
30.0	500	195	45	0.065	450	155	40	0.057	350	105	35	0.050
32.0	500	195	50	0.065	400	140	40	0.058	300	90	30	0.050
36.0	450	170	50	0.063	350	125	40	0.060	300	85	35	0.047
40.0	400	170	50	0.071	300	125	40	0.069	250	85	30	0.057

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
2.0	3100	30	20	0.002	16800	335	105	0.005
3.0	2250	40	20	0.004	15400	530	145	0.009
4.0	1550	65	20	0.010	11200	615	140	0.014
5.0	1250	70	20	0.014	8800	660	140	0.019
6.0	1100	85	20	0.019	7850	660	150	0.021
8.0	800	90	20	0.028	5600	810	140	0.036
10.0	650	90	20	0.035	4350	840	135	0.048
12.0	550	105	20	0.048	3500	800	130	0.057
14.0	500	105	20	0.053	3100	740	135	0.060
16.0	400	90	20	0.056	2800	740	140	0.066
18.0	350	90	20	0.064	2500	740	140	0.074
20.0	300	90	20	0.075	2250	670	140	0.074
22.0	300	90	20	0.050	1950	630	135	0.054
25.0	250	70	20	0.047	1700	590	135	0.058
28.0	200	65	20	0.054	1550	560	135	0.060
30.0	200	65	20	0.054	1550	560	145	0.060
32.0	200	65	20	0.054	1400	505	140	0.060
36.0	150	50	15	0.056	1250	460	140	0.061
40.0	150	50	20	0.056	1100	420	140	0.064

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

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

