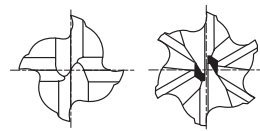


PREMIUM HSS-PM, 4&6 FLUTE SHORT LENGTH

PREMIUM HSS-PM, 4&6 SCHNEIDEN KURZ

- ▶ Excellent performance on Low handness materials (under HRc45), alloy steels, tool steels, carbon steels, prehardened steels, Stainless Steel, Titanium, Inconel.
- ▶ High chemical stability prevents built-up edge, micro cracks and crater wear.
- ▶ Superior workpiece finish.

- ▶ Ausgezeichnete Eignung zur Bearbeitung von weichen Materialien (bis HRc45), Legierten Stählen, kraterbildung, vorgehärtetem Stahl, rostfreiem Stahl, Titanium und Inconel.
- ▶ Hohe chemische Stabilität verhindert Kantenbildung, Mikrorisse und Krateraufzug.
- ▶ Höhere Oberflächengüte.



Unit : mm

EDP No. FLAT	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
EE515030	3.0	6	8	52	4
EE515040	4.0	6	11	55	4
EE515050	5.0	6	13	57	4
EE515060	6.0	6	13	57	4
EE515080	8.0	10	19	69	4
EE515100	10.0	10	22	72	4
EE515120	12.0	12	26	83	4
EE515140	14.0	12	26	83	4
EE515160	16.0	16	32	92	6
EE515180	18.0	16	32	92	6
EE515200	20.0	20	38	104	6
EE515250	25.0	25	45	121	6

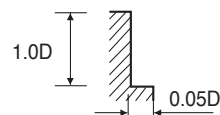
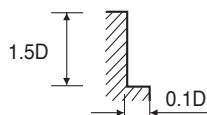
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~+0.03	h6

◎ : 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									
○	◎	◎	○							◎	◎	○		

PREMIUM HSS-PM, 4&6 FLUTE SHORT- SIDE CUTTING
PREMIUM HSS-PM, 4&6 SCHNEIDEN KURZ - SEITENFRÄSEN
EE515 SERIES

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				STAINLESS STEELS TITANIUM ALLOY				INCONEL			
HARDNESS	~ HRc30				HRc30 ~ HRc45											
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
3.0	4400	185	40	0.011	1100	23	10	0.005	2200	110	20	0.013	880	28	10	0.008
4.0	3600	210	45	0.015	900	31	10	0.009	1800	125	25	0.017	720	37	10	0.013
5.0	3000	225	45	0.019	750	30	10	0.010	1500	135	25	0.023	600	36	10	0.015
6.0	2600	235	50	0.023	600	29	10	0.012	1300	140	25	0.027	480	35	10	0.018
8.0	2000	250	50	0.031	500	28	15	0.014	1000	150	25	0.038	400	34	10	0.021
10.0	1600	285	50	0.045	410	30	15	0.018	800	170	25	0.053	330	36	10	0.027
12.0	1320	250	50	0.047	340	29	15	0.021	660	150	25	0.057	270	35	10	0.032
14.0	1160	235	50	0.051	290	27	15	0.023	580	140	25	0.060	230	32	10	0.035
16.0	1000	225	50	0.038	250	26	15	0.017	500	135	25	0.045	200	31	10	0.026
18.0	900	210	50	0.039	225	23	15	0.017	450	125	25	0.046	180	28	10	0.026
20.0	800	200	50	0.042	200	17	15	0.014	400	120	25	0.050	160	21	10	0.022
25.0	640	165	50	0.043	165	15	15	0.015	320	100	25	0.052	130	18	10	0.023



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