

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

**SERIES E2530, GB530**

FLAT SHANK

SEITLICHEN MITNAHMEFLÄCHEN

HSS  
Co8

DIN  
844

N



FLUTE  
4 & 6



P.304,312,316



Unit : mm

EDP No. FLAT	ITEM No. FLAT	EDP No. TiAIN	ITEM No. TiAIN	MILL DIAMETER	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH	No.OF FLUTE
E2530020	C4GRC-020AF	GB530020	R4GRC-020AF	2.0	6	7	51	4
E2530030	C4GRC-030AF	GB530030	R4GRC-030AF	3.0	6	8	52	4
E2530040	C4GRC-040AF	GB530040	R4GRC-040AF	4.0	6	11	55	4
E2530050	C4GRC-050AF	GB530050	R4GRC-050AF	5.0	6	13	57	4
E2530060	C4GRC-060AF	GB530060	R4GRC-060AF	6.0	6	13	57	4
E2530070	C4GRC-070TF	GB530070	R4GRC-070TF	7.0	10	16	66	4
E2530080	C4GRC-080TF	GB530080	R4GRC-080TF	8.0	10	19	69	4
E2530090	C4GRC-090TF	GB530090	R4GRC-090TF	9.0	10	19	69	4
E2530100	C4GRC-100TF	GB530100	R4GRC-100TF	10.0	10	22	72	4
E2530110	C4GRC-110DF	GB530110	R4GRC-110DF	11.0	12	22	79	4
E2530120	C4GRC-120DF	GB530120	R4GRC-120DF	12.0	12	26	83	4
E2530130	C4GRC-130DF	GB530130	R4GRC-130DF	13.0	12	26	83	4
E2530140	C4GRC-140DF	GB530140	R4GRC-140DF	14.0	12	26	83	4
E2530150	C4GRC-150DF	GB530150	R4GRC-150DF	15.0	12	26	83	4
E2530160	C4GRC-160EF	GB530160	R4GRC-160EF	16.0	16	32	92	4
E2530170	C4GRC-170EF	GB530170	R4GRC-170EF	17.0	16	32	92	4
E2530180	C4GRC-180EF	GB530180	R4GRC-180EF	18.0	16	32	92	4
E2530190	C4GRC-190EF	GB530190	R4GRC-190EF	19.0	16	32	92	4
E2530920	C4GRC-200EF	GB530920	R4GRC-200EF	20.0	16	38	98	4
E2530200	C4GRC-200FF	GB530200	R4GRC-200FF	20.0	20	38	104	4
E2530220	C4GRC-220FF	GB530220	R4GRC-220FF	22.0	20	38	104	4
E2530250	C4GRC-250GF	GB530250	R4GRC-250GF	25.0	25	45	121	4
E2530220	C6GRC-220FF	GB530220	R6GRC-220FF	22.0	20	38	104	6
E2530240	C6GRC-240GF	GB530240	R6GRC-240GF	24.0	25	45	121	6
E2530250	C6GRC-250GF	GB530250	R6GRC-250GF	25.0	25	45	121	6
E2530260	C6GRC-260GF	GB530260	R6GRC-260GF	26.0	25	45	121	6
E2530280	C6GRC-280GF	GB530280	R6GRC-280GF	28.0	25	45	121	6
E2530300	C6GRC-300GF	GB530300	R6GRC-300GF	30.0	25	45	121	6
E2530320	C6GRC-320HF	GB530320	R6GRC-320HF	32.0	32	53	133	6
E2530340	C6GRC-340HF	GB530340	R6GRC-340HF	34.0	32	53	133	6
E2530350	C6GRC-350HF	GB530350	R6GRC-350HF	35.0	32	53	133	6
E2530360	C6GRC-360HF	GB530360	R6GRC-360HF	36.0	32	53	133	6
E2530380	C6GRC-380HF	GB530380	R6GRC-380HF	38.0	32	63	143	6
E2530901	C6GRC-400HF	GB530901	R6GRC-400HF	40.0	32	63	143	6
E2530400	C6GRC-400IF	GB530400	R6GRC-400IF	40.0	40	63	155	6

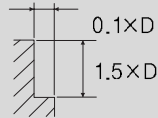
- ▶ Other shank design on your request.
- ▶ TiN-COATING & TiCN-COATING is available on your request.

TOLERANCE	
MILL DIA.	+ 0.040 - 0
SHANK DIA.	h6

# MULTI FLUTE, FINISH SIDE CUTTING, HSS-Co8 END MILLS

HSS

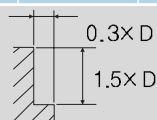
MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		ALUMINUM ALUMINUM ALLOYS	
HARDNESS			~ HRc20		HRc20 ~ HRc30		HRc30 ~ HRc40			
STRENGTH	~ 500N/mm <sup>2</sup>		500 ~ 800N/mm <sup>2</sup>		800 ~ 1000N/mm <sup>2</sup>		1000 ~ 1300N/mm <sup>2</sup>			
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	5600	80	4500	55	4000	45	2200	20	12000	240
3	3500	110	3200	80	2500	60	1600	30	11000	380
4	2800	140	2200	100	1800	65	1100	45	8000	440
5	2200	180	1800	125	1600	90	900	50	6300	470
6	1800	180	1600	145	1200	90	800	60	5600	470
8	1400	200	1100	160	900	105	560	65	4000	580
10	1100	200	900	160	800	120	450	65	3100	600
12	900	220	800	180	630	120	400	75	2500	570
14	800	220	700	160	560	120	350	75	2200	530
16	700	220	560	160	450	105	280	65	2000	530
18	630	200	500	160	400	105	250	65	1800	530
20	560	200	450	160	400	105	220	65	1600	480
22	500	200	450	160	350	105	220	65	1400	450
25	450	180	400	145	310	90	180	50	1200	420
28	400	160	350	125	280	80	160	45	1100	400
30	350	140	310	110	250	75	160	45	1100	400
32	350	140	280	100	220	65	140	45	1000	360
36	310	120	250	90	200	60	120	35	900	330
40	280	120	220	90	180	60	110	35	800	300



RPM=REVOLUTION PER MIN.  
FEED=mm/min.

# MULTI FLUTE, FINISH SIDE CUTTING, 50° HELIX, HSS-Co8 END MILLS

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS	
HARDNESS	~ HRc20		HRc20 ~ HRc30		HRc30 ~ HRc40	
STRENGTH	500 ~ 800N/mm <sup>2</sup>		800 ~ 1000N/mm <sup>2</sup>		1000 ~ 1300N/mm <sup>2</sup>	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED
2	5000	35	4500	25	2500	10
3	3500	50	2800	35	1800	20
4	2500	60	2000	40	1200	25
5	2000	75	1800	55	1000	30
6	1800	85	1300	55	900	35
8	1200	95	1000	65	600	40
10	1000	95	900	70	500	40
12	900	110	700	70	450	45
14	800	95	600	70	400	45
16	600	95	500	65	300	40
18	550	95	450	65	280	40
20	500	95	450	65	250	40
22	500	95	400	65	250	40
25	450	85	350	55	200	30
28	400	75	300	50	180	25
30	350	65	280	45	180	25

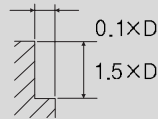


RPM=REVOLUTION PER MIN.  
FEED=mm/min.

## 3FL. FINISH SIDE CUTTING, HSS-Co8 END MILLS, TiN-COATED

HSS

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		ALUMINUM ALUMINUM ALLOYS	
HARDNESS			~ HRc20		HRc20 ~ HRc30		HRc30 ~ HRc40			
STRENGTH	~ 500N/mm <sup>2</sup>		500 ~ 800N/mm <sup>2</sup>		800 ~ 1000N/mm <sup>2</sup>		1000 ~ 1300N/mm <sup>2</sup>			
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	6700	70	5400	50	5000	40	2600	20	14000	220
3	4200	95	3800	70	3000	55	1900	25	13000	340
4	3400	125	2600	90	2200	60	1300	35	9500	400
5	2600	160	2200	115	1900	80	1100	40	7500	420
6	2200	160	1900	130	1400	80	950	55	6700	420
8	1700	180	1300	145	1100	95	670	60	5000	530
10	1300	180	1100	145	950	110	550	60	3700	540
12	1100	200	950	160	750	110	500	65	3000	520
14	950	200	850	145	670	110	400	65	2600	480
16	850	200	670	145	550	95	340	60	2400	480
18	750	180	600	145	500	95	300	60	2200	480
20	670	180	550	145	500	95	260	60	1900	430
22	600	180	550	145	400	95	260	60	1700	410
25	550	160	500	130	370	80	220	40	1400	380
28	500	145	400	115	340	70	190	35	1300	360
30	400	125	370	95	300	65	190	35	1300	360

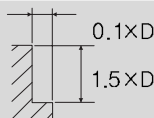


※The FEED, in long & extra long types, should be reduced by around 50%

RPM=REVOLUTION PER MIN. FEED=mm/min.

## MULTI FLUTE, FINISH SIDE CUTTING, HSS-Co8 END MILLS, TiN-COATED

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		ALUMINUM ALUMINUM ALLOYS	
HARDNESS			~ HRc20		HRc20 ~ HRc30		HRc30 ~ HRc40			
STRENGTH	~ 500N/mm <sup>2</sup>		500 ~ 800N/mm <sup>2</sup>		800 ~ 1000N/mm <sup>2</sup>		1000 ~ 1300N/mm <sup>2</sup>			
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	6700	95	5400	65	5000	55	2600	25	14000	290
3	4200	130	3800	95	3000	70	1900	35	13000	460
4	3400	170	2600	120	2200	80	1300	55	9500	530
5	2600	220	2200	150	1900	110	1100	60	7500	560
6	2200	220	1900	170	1400	110	950	70	6700	560
8	1700	240	1300	190	1100	125	670	80	5000	700
10	1300	240	1100	190	950	145	550	80	3700	720
12	1100	260	950	220	750	145	500	90	3000	680
14	950	260	850	190	670	145	400	90	2600	640
16	850	260	670	190	550	125	340	80	2400	640
18	750	240	600	190	500	125	300	80	2200	640
20	670	240	550	190	500	125	260	80	1900	580
22	600	240	550	190	400	125	260	80	1700	540
25	550	220	500	175	370	110	220	60	1400	500
28	500	190	400	150	340	95	190	55	1300	480
30	400	170	370	130	300	90	190	55	1300	480
32	400	170	340	120	260	80	170	55	1200	430
36	370	145	300	110	240	70	140	40	1100	400
40	340	145	260	110	220	70	130	40	950	360



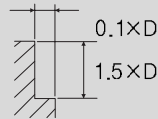
※The FEED, in long & extra long types, should be reduced by around 50%

RPM=REVOLUTION PER MIN. FEED=mm/min.

# 3FL. FINISH SIDE CUTTING, HSS-Co8 END MILLS, TiCN-COATED

HSS

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		ALUMINUM ALUMINUM ALLOYS	
HARDNESS			~ HRc20		HRc20 ~ HRc30		HRc30 ~ HRc40			
STRENGTH	~ 500N/mm <sup>2</sup>		500 ~ 800N/mm <sup>2</sup>		800 ~ 1000N/mm <sup>2</sup>		1000 ~ 1300N/mm <sup>2</sup>			
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	7300	80	6000	50	5000	45	2900	20	16000	230
3	4500	105	4200	80	3300	60	2100	25	14000	360
4	3600	135	2900	95	2300	65	1400	40	10000	430
5	2900	175	2300	125	2100	85	1200	45	8200	450
6	2300	175	2000	145	1600	85	1000	60	7300	450
8	1800	195	1400	155	1200	105	730	65	5000	570
10	1400	195	1200	155	1000	115	600	65	4000	590
12	1200	215	1000	175	800	115	500	70	3300	560
14	1000	215	900	155	700	115	450	70	2800	520
16	900	215	700	155	600	105	360	65	2600	520
18	800	195	650	155	500	105	320	65	2300	520
20	730	195	600	155	500	105	300	65	2100	470
22	650	195	600	155	450	105	280	65	1800	440
25	600	175	500	145	400	85	230	45	1600	420
28	500	155	450	125	350	80	210	40	1400	390
30	450	135	400	105	320	70	210	40	1400	390

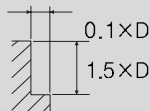


※The FEED, in long & extra long types, should be reduced by around 50%

RPM=REVOLUTION PER MIN. FEED=mm/min.

# MULTI FLUTE, FINISH SIDE CUTTING, HSS-Co8 END MILLS, TiCN-COATED

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		ALUMINUM ALUMINUM ALLOYS	
HARDNESS			~ HRc20		HRc20 ~ HRc30		HRc30 ~ HRc40			
STRENGTH	~ 500N/mm <sup>2</sup>		500 ~ 800N/mm <sup>2</sup>		800 ~ 1000N/mm <sup>2</sup>		1000 ~ 1300N/mm <sup>2</sup>			
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	7300	105	6000	70	5000	60	2900	25	16000	310
3	4500	145	4200	105	3300	80	2100	40	14000	500
4	3600	180	2900	130	2300	85	1400	60	10000	570
5	2900	235	2300	160	2100	115	1200	65	8200	610
6	2300	235	2000	190	1600	115	1000	80	7300	610
8	1800	260	1400	210	1200	135	730	85	5000	750
10	1400	260	1200	210	1000	155	600	85	4000	780
12	1200	285	1000	235	800	155	500	95	3300	740
14	1000	285	900	210	700	155	450	95	2800	690
16	900	285	700	210	600	135	360	85	2600	690
18	800	260	650	210	500	135	320	85	2300	690
20	730	260	600	210	500	135	300	85	2100	620
22	650	260	600	210	450	135	280	85	1800	580
25	600	235	500	190	400	115	230	65	1600	550
28	500	210	450	160	350	105	210	60	1400	520
30	450	180	400	145	320	95	210	60	1400	520
32	450	180	360	130	280	85	180	60	1300	470
36	400	155	320	120	260	80	160	45	1200	430
40	360	155	280	120	230	80	140	45	1000	390



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

RPM=REVOLUTION PER MIN. FEED=mm/min.