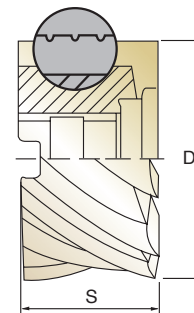
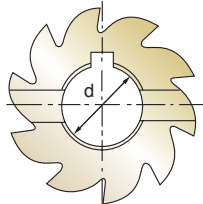


**HSSCo8, MULTI FLUTE ROUGHING & FINISHING SHELL END MILL**  
**HSSCo8, MULTI SCHNEIDEN WALZENSTIRN-SCHRUPPSCHLICHTFRÄSER**



HSS Co8
DIN 841
NF
ROUGHING & FINISHING
6-12
30°
P.1293

Unit : mm

EDP No.	Mill Diameter	Width of Face	Internal Diameter	No. of Teeth
	D	S	d	
E2679401	40.0	40	● 16	6
E2679501	50.0	50	22	8
E2679600	60.0	30	27	8
E2679601	60.0	60	27	8
E2679750	75.0	35	27	10
E2679751	75.0	75	27	10
E2679900	90.0	35	27	10
E2679902	110.0	35	32	12

● Tolerance of Internal Diameter = +0.018 ~ 0  
 ▶ TIN-COATING, TiCN-COATING & TiAlN-COATING is available on your request.

HSS Co8
DIN 1880
NF
ROUGHING & FINISHING
6-12
30°
P.522

Unit : mm

EDP No.	Mill Diameter	Width of Face	Internal Diameter	No. of Teeth
	D	S	d	
E2679400	40.0	32	● 16	6
E2679500	50.0	36	22	8
E2679630	63.0	40	27	8
E2679800	80.0	45	27	10
E2679901	100.0	50	32	10
E2679903	125.0	56	40	12
E2679904	160.0	63	50	12

● Tolerance of Internal Diameter = +0.018 ~ 0  
 ▶ TIN-COATING, TiCN-COATING & TiAlN-COATING is available on your request.

Mill Dia. Tolerance(mm)	Width of Face Tolerance(mm)	Internal Dia. Tolerance(mm)
+ 0.25 - 0.15	+ 0.5 - 0	+ 0.02 - 0

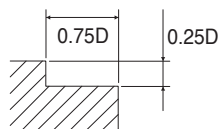
◎ : Excellent ○ : Good

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 SHELL END MILL**  
**HSSCo8, MULTI SCHNEIDEN WALZENSTIRN-SCHRUPPFÄRÄSER**

**E2677, E2678 SERIES**

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			
	HARDNESS	~ HRc20				HRc20 ~ HRc28				HRc28 ~ HRc35				HRc35 ~ HRc40		
STRENGTH	~ 800N/mm <sup>2</sup>				800 ~ 900N/mm <sup>2</sup>				900 ~ 1100N/mm <sup>2</sup>				1100 ~ 1300N/mm <sup>2</sup>			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
40.0	240	100	30	0.069	200	85	25	0.071	140	60	20	0.071	80	35	10	0.073
50.0	200	125	30	0.078	170	105	25	0.077	120	75	20	0.078	70	45	10	0.080
63.0	150	110	30	0.092	130	95	25	0.091	90	65	20	0.090	50	40	10	0.100
80.0	120	120	30	0.100	100	100	25	0.100	80	75	20	0.094	40	40	10	0.100
100.0	100	115	30	0.115	80	95	25	0.119	60	70	20	0.117	30	35	10	0.117
125.0	80	115	30	0.120	70	95	25	0.113	50	65	20	0.108	20	35	10	0.146
160.0	60	110	30	0.153	60	100	30	0.139	40	65	20	0.135	20	35	10	0.146

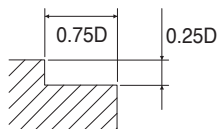


RPM = rev./min.  
FEED = mm/min.  
Vc = m/min.  
fz = mm/t

**HSSCo8, MULTI FLUTE ROUGHING & FINISHING SHELL END MILL**  
**HSSCo8, MULTI SCHNEIDEN WALZENSTIRN-SCHRUPPSCHLICHTFRÄSER**

**E2679 SERIES**

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			
	HARDNESS	~ HRc20				HRc20 ~ HRc28				HRc28 ~ HRc35				HRc35 ~ HRc40		
STRENGTH	~ 800N/mm <sup>2</sup>				800 ~ 900N/mm <sup>2</sup>				900 ~ 1100N/mm <sup>2</sup>				1100 ~ 1300N/mm <sup>2</sup>			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
40.0	240	100	30	0.069	200	85	25	0.071	140	60	20	0.071	80	35	10	0.073
50.0	200	125	30	0.078	170	105	25	0.077	120	75	20	0.078	70	45	10	0.080
63.0	150	110	30	0.092	130	95	25	0.091	90	65	20	0.090	50	40	10	0.100
80.0	120	120	30	0.100	100	100	25	0.100	80	75	20	0.094	40	40	10	0.100
100.0	100	115	30	0.115	80	95	25	0.119	60	70	20	0.117	30	35	10	0.117
125.0	80	115	30	0.120	70	95	25	0.113	50	65	20	0.108	20	35	10	0.146
160.0	60	110	30	0.153	60	100	30	0.139	40	65	20	0.135	20	35	10	0.146



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