



FLAT SHANK

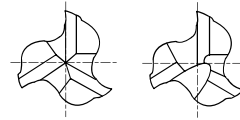
E2516 SERIES

FLAT SHANK

EQ516 SERIES

HSSCo8, 3 FLUTE LONG LENGTH

- HSSCo8, 3 SCHNEIDEN LANG
- Fraise HSSCo8, 3 dents, longue
- 3 TAGLIENTI, SERIE LUNGA - HSSCo8



Up to \varnothing 2.5mm Over \varnothing 2.5mm

HSS Co8
DIN 844
3
30°
DIN 1835B
P.750~757

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	
					UNCOATED
E2516020	EQ516020	2.0	6	10	54
E2516025	EQ516025	2.5	6	12	56
E2516030	EQ516030	3.0	6	12	56
E2516035	EQ516035	3.5	6	15	59
E2516040	EQ516040	4.0	6	19	63
E2516045	EQ516045	4.5	6	19	63
E2516050	EQ516050	5.0	6	24	68
E2516055	EQ516055	5.5	6	24	68
E2516060	EQ516060	6.0	6	24	68
E2516070	EQ516070	7.0	10	30	80
E2516075	EQ516075	7.5	10	30	80
E2516080	EQ516080	8.0	10	38	88
E2516090	EQ516090	9.0	10	38	88
E2516100	EQ516100	10.0	10	45	95
E2516110	EQ516110	11.0	12	45	102
E2516120	EQ516120	12.0	12	53	110
E2516130	EQ516130	13.0	12	53	110
E2516140	EQ516140	14.0	12	53	110
E2516150	EQ516150	15.0	12	53	110
E2516160	EQ516160	16.0	16	63	123
E2516170	EQ516170	17.0	16	63	123
E2516180	EQ516180	18.0	16	63	123
E2516190	EQ516190	19.0	16	63	123
E2516901	EQ516901	20.0	16	75	135

Tolerances according to DIN 7160 & 7161

- ▶ Other shank design on your request.
- ▶ TiN and TiCN Coatings are available on your request.
- ▶ NEXT PAGE

	Tolerance range in μ m					
	Nominal-Diameter in mm					
	from 1 to 3	over 3 to 6	over 6 to 10	over 10 to 18	over 18 to 30	over 30 to 50
e8	-14 -28	-20 -38	-25 -47	-32 -59	-40 -73	-50 -89
h6	0 -6	0 -8	0 -9	0 -11	0 -13	0 -16

◎ : Excellent ○ : Good

ISO Material Description	P											M			K						
	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommend	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	
ISO Material Description	N										S					H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommend	◎	◎	◎	◎	◎																

E2572, E2573, E2516, E2553, E2554, E2551, E2552 SERIES

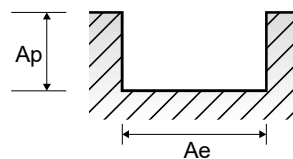
Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

3 FLUTE - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)								
						2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	
P	1	Non-alloy steel	1.0D	0.5D	Vc	35	35	35	35	35	35	35	35	35
					fz	0.002	0.005	0.007	0.012	0.015	0.021	0.027	0.037	
					RPM	5570	3714	2785	2228	1857	1393	1114	928	
	2		1.0D	0.5D	Vc	30	30	30	30	30	30	30	30	30
					fz	0.002	0.004	0.007	0.01	0.014	0.021	0.026	0.033	
					RPM	4775	3183	2387	1910	1592	1194	955	796	
	3-4		1.0D	0.5D	Vc	25	25	25	25	25	25	25	25	25
					fz	0.002	0.003	0.006	0.008	0.011	0.019	0.023	0.029	
					RPM	3979	2653	1989	1592	1326	995	796	663	
	5		1.0D	0.5D	Vc	15	15	15	15	15	15	15	15	15
					fz	0.002	0.003	0.006	0.007	0.01	0.018	0.022	0.029	
RPM		2387			1592	1194	955	796	597	477	398			
6	1.0D	0.5D	Vc	30	30	30	30	30	30	30	30	30		
			fz	0.002	0.004	0.007	0.01	0.014	0.021	0.026	0.033			
			RPM	4775	3183	2387	1910	1592	1194	955	796			
7	1.0D	0.5D	Vc	25	25	25	25	25	25	25	25	25		
			fz	0.002	0.003	0.006	0.008	0.011	0.019	0.023	0.029			
			RPM	3979	2653	1989	1592	1326	995	796	663			
8-9	1.0D	0.5D	Vc	15	15	15	15	15	15	15	15	15		
			fz	0.002	0.003	0.006	0.007	0.01	0.018	0.022	0.029			
			RPM	2387	1592	1194	955	796	597	477	398			
10	1.0D	0.5D	Vc	30	30	30	30	30	30	30	30	30		
			fz	0.002	0.004	0.007	0.01	0.014	0.021	0.026	0.033			
			RPM	4775	3183	2387	1910	1592	1194	955	796			
11.1	1.0D	0.5D	Vc	15	15	15	15	15	15	15	15	15		
			fz	0.002	0.003	0.006	0.007	0.01	0.018	0.022	0.029			
			RPM	2387	1592	1194	955	796	597	477	398			
N	21-22	Aluminum-wrought alloy	1.0D	0.5D	Vc	75	105	100	100	105	100	95	95	
					fz	0.003	0.005	0.008	0.011	0.013	0.022	0.029	0.035	
					RPM	11937	11141	7958	6366	5570	3979	3024	2520	
					FEED	107	167	191	210	217	263	263	265	
N	23-24	Aluminum-cast, alloyed	1.0D	0.5D	Vc	49	68	65	65	68	65	62	62	
					fz	0.003	0.005	0.008	0.011	0.013	0.022	0.029	0.035	
					RPM	7799	7215	5173	4138	3608	2586	1974	1645	
					FEED	70	108	124	137	141	171	172	173	

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

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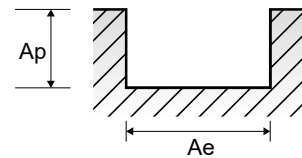


E2572, E2573, E2516, E2553, E2554, E2551, E2552 SERIES

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

3 FLUTE - SLOTTING

VDI 3323	Parameter	Diameter (Ø)											
		14.0	16.0	18.0	20.0	22.0	25.0	28.0	30.0	32.0	35.0	36.0	40.0
1	Vc	35	35	35	35	35	35	35	35	35	35	35	35
	fz	0.042	0.048	0.048	0.054	0.06	0.059	0.058	0.057	0.057	0.057	0.059	0.065
	RPM	796	696	619	557	506	446	398	371	348	318	309	279
	FEED	100	100	89	90	91	79	69	64	60	54	55	54
2	Vc	30	30	30	30	30	30	30	30	30	30	30	30
	fz	0.033	0.042	0.047	0.052	0.052	0.054	0.052	0.054	0.054	0.051	0.053	0.061
	RPM	682	597	531	477	434	382	341	318	298	273	265	239
	FEED	68	75	75	74	68	62	53	52	48	42	42	44
3-4	Vc	25	25	25	25	25	25	25	25	20	25	25	25
	fz	0.033	0.037	0.042	0.042	0.048	0.043	0.042	0.04	0.045	0.04	0.042	0.046
	RPM	568	497	442	398	362	318	284	265	199	227	221	199
	FEED	56	55	56	50	52	41	36	32	27	27	28	27
5	Vc	15	15	15	15	15	15	15	15	15	15	15	15
	fz	0.033	0.036	0.04	0.045	0.045	0.037	0.042	0.042	0.048	0.038	0.042	0.045
	RPM	341	298	265	239	217	191	171	159	149	136	133	119
	FEED	34	32	32	32	29	21	21	20	21	16	17	16
6	Vc	30	30	30	30	30	30	30	30	30	30	30	30
	fz	0.033	0.042	0.047	0.052	0.052	0.054	0.052	0.054	0.054	0.051	0.053	0.061
	RPM	682	597	531	477	434	382	341	318	298	273	265	239
	FEED	68	75	75	74	68	62	53	52	48	42	42	44
7	Vc	25	25	25	25	25	25	25	25	20	25	25	25
	fz	0.033	0.037	0.042	0.042	0.048	0.043	0.042	0.04	0.045	0.04	0.042	0.046
	RPM	568	497	442	398	362	318	284	265	199	227	221	199
	FEED	56	55	56	50	52	41	36	32	27	27	28	27
8-9	Vc	15	15	15	15	15	15	15	15	15	15	15	15
	fz	0.033	0.036	0.04	0.045	0.045	0.037	0.042	0.042	0.048	0.038	0.042	0.045
	RPM	341	298	265	239	217	191	171	159	149	136	133	119
	FEED	34	32	32	32	29	21	21	20	21	16	17	16
10	Vc	30	30	30	30	30	30	30	30	30	30	30	30
	fz	0.033	0.042	0.047	0.052	0.052	0.054	0.052	0.054	0.054	0.051	0.053	0.061
	RPM	682	597	531	477	434	382	341	318	298	273	265	239
	FEED	68	75	75	74	68	62	53	52	48	42	42	44
11.1	Vc	15	15	15	15	15	15	15	15	15	15	15	15
	fz	0.033	0.036	0.04	0.045	0.045	0.037	0.042	0.042	0.048	0.038	0.042	0.045
	RPM	341	298	265	239	217	191	171	159	149	136	133	119
	FEED	34	32	32	32	29	21	21	20	21	16	17	16
21 - 22	Vc	95	100	100	100	95	95	95	105	100	105	100	100
	fz	0.036	0.04	0.044	0.046	0.048	0.053	0.055	0.055	0.053	0.053	0.056	0.054
	RPM	2160	1989	1768	1592	1375	1210	1080	1114	995	955	884	796
	FEED	233	239	233	220	198	192	178	184	158	152	149	129
23 - 24	Vc	62	65	65	65	62	62	62	68	65	68	65	65
	fz	0.036	0.04	0.044	0.046	0.048	0.053	0.055	0.055	0.053	0.053	0.056	0.054
	RPM	1410	1293	1149	1035	897	789	705	722	647	618	575	517
	FEED	152	155	152	143	129	126	116	119	103	98	97	84



E2572, E2573, E2516, E2553, E2554, E2551, E2552 SERIES

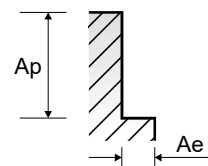
Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

3 FLUTE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)							
						2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0
P	1	Non-alloy steel	0.1D	1.5D	Vc	35	35	35	35	35	35	35	35
					fz	0.004	0.008	0.013	0.02	0.025	0.036	0.045	0.061
					RPM	5570	3714	2785	2228	1857	1393	1114	928
	2		Vc	30	30	30	30	30	30	30	30		
			fz	0.003	0.006	0.011	0.018	0.023	0.036	0.044	0.056		
			RPM	4775	3183	2387	1910	1592	1194	955	796		
	3-4		Vc	25	25	25	25	25	25	25	25		
			fz	0.003	0.006	0.009	0.014	0.018	0.03	0.038	0.048		
			RPM	3979	2653	1989	1592	1326	995	796	663		
	5		Vc	15	15	15	15	15	15	15	15		
			fz	0.002	0.004	0.009	0.013	0.019	0.03	0.037	0.046		
RPM		2387	1592	1194	955	796	597	477	398				
6	Vc	30	30	30	30	30	30	30	30				
	fz	0.003	0.006	0.011	0.018	0.023	0.036	0.044	0.056				
	RPM	4775	3183	2387	1910	1592	1194	955	796				
7	Vc	25	25	25	25	25	25	25	25				
	fz	0.003	0.006	0.009	0.014	0.018	0.03	0.038	0.048				
	RPM	3979	2653	1989	1592	1326	995	796	663				
8-9	Vc	15	15	15	15	15	15	15	15				
	fz	0.002	0.004	0.009	0.013	0.019	0.03	0.037	0.046				
	RPM	2387	1592	1194	955	796	597	477	398				
10	Vc	30	30	30	30	30	30	30	30				
	fz	0.003	0.006	0.011	0.018	0.023	0.036	0.044	0.056				
	RPM	4775	3183	2387	1910	1592	1194	955	796				
11.1	Vc	15	15	15	15	15	15	15	15				
	fz	0.002	0.004	0.009	0.013	0.019	0.03	0.037	0.046				
	RPM	2387	1592	1194	955	796	597	477	398				
N	21-22	Aluminum-wrought alloy	0.1D	1.5D	Vc	75	105	100	100	105	100	95	95
					fz	0.005	0.008	0.014	0.019	0.021	0.037	0.048	0.057
					RPM	11937	11141	7958	6366	5570	3979	3024	2520
					FEED	179	267	334	363	351	442	435	431
23-24	Aluminum-cast, alloyed	0.1D	1.5D	Vc	49	68	65	65	68	65	62	62	
				fz	0.005	0.008	0.014	0.019	0.021	0.037	0.048	0.057	
				RPM	7799	7215	5173	4138	3608	2586	1974	1645	
				FEED	117	173	217	236	227	287	284	281	

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

▶ NEXT PAGE

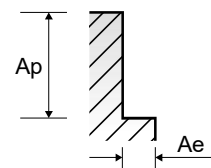


E2572, E2573, E2516, E2553, E2554, E2551, E2552 SERIES

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

3 FLUTE - SIDE CUTTING

VDI 3323	Parameter	Diameter (Ø)											
		14.0	16.0	18.0	20.0	22.0	25.0	28.0	30.0	32.0	35.0	36.0	40.0
1	Vc	35	35	35	35	35	35	35	35	35	35	35	35
	fz	0.069	0.079	0.079	0.089	0.1	0.1	0.1	0.1	0.1	0.099	0.097	0.107
	RPM	796	696	619	557	506	446	398	371	348	318	309	279
2	FEED	165	165	147	149	152	134	119	111	104	95	90	89
	Vc	30	30	30	30	30	30	30	30	30	30	30	30
	fz	0.057	0.071	0.08	0.089	0.089	0.092	0.09	0.086	0.089	0.083	0.087	0.098
3-4	RPM	682	597	531	477	434	382	341	318	298	273	265	239
	FEED	117	127	127	127	116	105	92	82	80	68	69	70
	Vc	25	25	25	25	25	25	25	25	20	25	25	25
5	fz	0.054	0.059	0.067	0.067	0.076	0.07	0.071	0.073	0.076	0.071	0.075	0.083
	RPM	568	497	442	398	362	318	284	265	199	227	221	199
	FEED	92	88	89	80	82	67	61	58	45	48	50	50
6	Vc	15	15	15	15	15	15	15	15	15	15	15	15
	fz	0.052	0.06	0.067	0.076	0.076	0.065	0.063	0.063	0.071	0.064	0.069	0.076
	RPM	341	298	265	239	217	191	171	159	149	136	133	119
7	FEED	53	54	53	54	49	37	32	30	32	26	27	27
	Vc	30	30	30	30	30	30	30	30	30	30	30	30
	fz	0.057	0.071	0.08	0.089	0.089	0.092	0.09	0.086	0.089	0.083	0.087	0.098
8-9	RPM	682	597	531	477	434	382	341	318	298	273	265	239
	FEED	117	127	127	127	116	105	92	82	80	68	69	70
	Vc	25	25	25	25	25	25	25	25	20	25	25	25
10	fz	0.054	0.059	0.067	0.067	0.076	0.07	0.071	0.073	0.076	0.071	0.075	0.083
	RPM	568	497	442	398	362	318	284	265	199	227	221	199
	FEED	92	88	89	80	82	67	61	58	45	48	50	50
11.1	Vc	15	15	15	15	15	15	15	15	15	15	15	15
	fz	0.052	0.06	0.067	0.076	0.076	0.065	0.063	0.063	0.071	0.064	0.069	0.076
	RPM	341	298	265	239	217	191	171	159	149	136	133	119
21-22	FEED	53	54	53	54	49	37	32	30	32	26	27	27
	Vc	95	100	100	100	95	95	95	105	100	105	100	100
	fz	0.061	0.067	0.074	0.075	0.081	0.089	0.091	0.091	0.09	0.091	0.093	0.092
23-24	RPM	2160	1989	1768	1592	1375	1210	1080	1114	995	955	884	796
	FEED	395	400	393	358	334	323	295	304	269	261	247	220
	Vc	62	65	65	65	62	62	62	68	65	68	65	65
23-24	fz	0.061	0.067	0.074	0.075	0.081	0.089	0.091	0.091	0.09	0.091	0.093	0.092
	RPM	1410	1293	1149	1035	897	789	705	722	647	618	575	517
	FEED	258	260	255	233	218	211	192	197	175	169	160	143



EQ572, EQ573, EQ516, EQ553, EQ554, EQ551, EQ552 SERIES

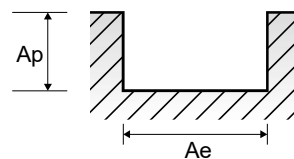
Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

3 FLUTE TiAIN COATED - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)							
						2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0
P	1	Non-alloy steel	1.0D	0.5D	Vc	50	45	50	50	45	50	45	50
					fz	0.002	0.005	0.007	0.012	0.015	0.021	0.028	0.036
					RPM	7958	4775	3979	3183	2387	1989	1432	1326
					FEED	48	72	84	115	107	125	120	143
	2		Vc	40	40	40	40	40	40	40	40		
			fz	0.002	0.004	0.006	0.01	0.014	0.022	0.028	0.033		
			RPM	6366	4244	3183	2546	2122	1592	1273	1061		
			FEED	38	51	57	76	89	105	107	105		
	3-4		Vc	35	35	30	35	30	35	35	35		
			fz	0.002	0.003	0.005	0.008	0.011	0.018	0.023	0.028		
			RPM	5570	3714	2387	2228	1592	1393	1114	928		
FEED		33	33	36	53	53	75	77	78				
5	Vc	20	20	20	20	20	20	20	20				
	fz	0.002	0.003	0.007	0.008	0.011	0.017	0.021	0.03				
	RPM	3183	2122	1592	1273	1061	796	637	531				
	FEED	19	19	33	31	35	41	40	48				
6	Vc	40	40	40	40	40	40	40	40				
	fz	0.002	0.004	0.006	0.01	0.014	0.022	0.028	0.033				
	RPM	6366	4244	3183	2546	2122	1592	1273	1061				
	FEED	38	51	57	76	89	105	107	105				
7	Vc	35	35	30	35	30	35	35	35				
	fz	0.002	0.003	0.005	0.008	0.011	0.018	0.023	0.028				
	RPM	5570	3714	2387	2228	1592	1393	1114	928				
	FEED	33	33	36	53	53	75	77	78				
8-9	Vc	20	20	20	20	20	20	20	20				
	fz	0.002	0.003	0.007	0.008	0.011	0.017	0.021	0.03				
	RPM	3183	2122	1592	1273	1061	796	637	531				
	FEED	19	19	33	31	35	41	40	48				
10	Vc	40	40	40	40	40	40	40	40				
	fz	0.002	0.004	0.006	0.01	0.014	0.022	0.028	0.033				
	RPM	6366	4244	3183	2546	2122	1592	1273	1061				
	FEED	38	51	57	76	89	105	107	105				
11.1	Vc	20	20	20	20	20	20	20	20				
	fz	0.002	0.003	0.007	0.008	0.011	0.017	0.021	0.03				
	RPM	3183	2122	1592	1273	1061	796	637	531				
	FEED	19	19	33	31	35	41	40	48				
N	21-22	Aluminum-wrought alloy	1.0D	0.5D	Vc	105	145	140	140	145	140	135	130
					fz	0.003	0.005	0.008	0.011	0.012	0.021	0.029	0.034
	RPM		16711	15385	11141	8913	7692	5570	4297	3448			
	FEED		150	231	267	294	277	351	374	352			
23-24	Aluminum-cast, alloyed	1.0D	0.5D	Vc	68	94	91	91	94	91	88	85	
				fz	0.003	0.005	0.008	0.011	0.012	0.021	0.029	0.034	
		RPM	10823	9974	7242	5793	4987	3621	2801	2255			
		FEED	97	150	174	191	180	228	244	230			

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

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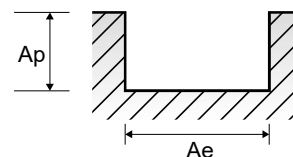


EQ572, EQ573, EQ516, EQ553, EQ554, EQ551, EQ552 SERIES

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

3 FLUTE TiAlN COATED - SLOTTING

VDI 3323	Parameter	Diameter (Ø)											
		14.0	16.0	18.0	20.0	22.0	25.0	28.0	30.0	32.0	35.0	36.0	40.0
1	Vc	50	50	50	50	50	50	50	45	50	50	50	50
	fz	0.042	0.048	0.047	0.053	0.06	0.058	0.06	0.058	0.058	0.059	0.058	0.064
	RPM	1137	995	884	796	723	637	568	477	497	455	442	398
2	FEED	143	143	125	127	130	111	102	83	87	80	77	76
	Vc	45	40	40	40	45	45	45	40	40	40	40	40
	fz	0.034	0.043	0.048	0.053	0.053	0.054	0.051	0.054	0.056	0.056	0.052	0.059
3-4	RPM	1023	796	707	637	651	573	512	424	398	364	354	318
	FEED	104	103	102	101	104	93	78	69	67	61	55	56
	Vc	35	30	30	35	35	35	35	35	30	30	30	30
5	fz	0.032	0.037	0.042	0.042	0.048	0.043	0.043	0.038	0.043	0.04	0.042	0.047
	RPM	796	597	531	557	506	446	398	371	298	273	265	239
	FEED	76	66	67	70	73	57	51	42	38	33	33	34
6	Vc	20	20	20	20	20	20	20	20	20	20	20	20
	fz	0.034	0.034	0.038	0.043	0.043	0.04	0.045	0.045	0.05	0.046	0.039	0.044
	RPM	455	398	354	318	289	255	227	212	199	182	177	159
7	FEED	46	41	40	41	37	31	31	29	30	25	21	21
	Vc	45	40	40	40	45	45	45	40	40	40	40	40
	fz	0.034	0.043	0.048	0.053	0.053	0.054	0.051	0.054	0.056	0.056	0.052	0.059
8-9	RPM	1023	796	707	637	651	573	512	424	398	364	354	318
	FEED	104	103	102	101	104	93	78	69	67	61	55	56
	Vc	35	30	30	35	35	35	35	35	30	30	30	30
10	fz	0.032	0.037	0.042	0.042	0.048	0.043	0.043	0.038	0.043	0.04	0.042	0.047
	RPM	796	597	531	557	506	446	398	371	298	273	265	239
	FEED	76	66	67	70	73	57	51	42	38	33	33	34
11.1	Vc	20	20	20	20	20	20	20	20	20	20	20	20
	fz	0.034	0.034	0.038	0.043	0.043	0.04	0.045	0.045	0.05	0.046	0.039	0.044
	RPM	455	398	354	318	289	255	227	212	199	182	177	159
21-22	FEED	46	41	40	41	37	31	31	29	30	25	21	21
	Vc	135	140	140	140	135	135	130	140	140	145	140	140
	fz	0.037	0.04	0.045	0.047	0.048	0.053	0.056	0.056	0.054	0.055	0.056	0.055
23-24	RPM	3069	2785	2476	2228	1953	1719	1478	1485	1393	1319	1238	1114
	FEED	341	334	334	314	281	273	248	250	226	218	208	184
	Vc	88	91	91	91	88	88	85	91	91	94	91	91
23-24	fz	0.037	0.04	0.045	0.047	0.048	0.053	0.056	0.056	0.054	0.055	0.056	0.055
	RPM	2001	1810	1609	1448	1273	1120	966	966	905	855	805	724
	FEED	222	217	217	204	183	178	162	162	147	141	135	119



EQ572, EQ573, EQ516, EQ553, EQ554, EQ551, EQ552 SERIES

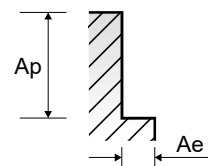
Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

3 FLUTE TiAIN COATED - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)							
						2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0
P	1	Non-alloy steel	0.1D	1.5D	Vc	50	45	50	50	45	50	45	50
					fz	0.004	0.007	0.012	0.02	0.025	0.035	0.047	0.059
					RPM	7958	4775	3979	3183	2387	1989	1432	1326
	2		Vc	40	40	40	40	40	40	40	40		
			fz	0.003	0.006	0.011	0.017	0.023	0.038	0.044	0.058		
			RPM	6366	4244	3183	2546	2122	1592	1273	1061		
	3-4		Vc	35	35	30	35	30	35	35	35		
			fz	0.003	0.006	0.009	0.014	0.018	0.028	0.038	0.047		
			RPM	5570	3714	2387	2228	1592	1393	1114	928		
	5		Vc	20	20	20	20	20	20	20	20		
			fz	0.002	0.005	0.009	0.013	0.018	0.03	0.037	0.045		
RPM		3183	2122	1592	1273	1061	796	637	531				
6	Vc	40	40	40	40	40	40	40	40				
	fz	0.003	0.006	0.011	0.017	0.023	0.038	0.044	0.058				
	RPM	6366	4244	3183	2546	2122	1592	1273	1061				
7	Vc	35	35	30	35	30	35	35	35				
	fz	0.003	0.006	0.009	0.014	0.018	0.028	0.038	0.047				
	RPM	5570	3714	2387	2228	1592	1393	1114	928				
8-9	Vc	20	20	20	20	20	20	20	20				
	fz	0.002	0.005	0.009	0.013	0.018	0.03	0.037	0.045				
	RPM	3183	2122	1592	1273	1061	796	637	531				
10	Vc	40	40	40	40	40	40	40	40				
	fz	0.003	0.006	0.011	0.017	0.023	0.038	0.044	0.058				
	RPM	6366	4244	3183	2546	2122	1592	1273	1061				
11.1	Vc	20	20	20	20	20	20	20	20				
	fz	0.002	0.005	0.009	0.013	0.018	0.03	0.037	0.045				
	RPM	3183	2122	1592	1273	1061	796	637	531				
N	21-22	Aluminum-wrought alloy	0.1D	1.5D	Vc	105	145	140	140	145	140	135	130
					fz	0.005	0.008	0.014	0.019	0.021	0.037	0.049	0.057
					RPM	16711	15385	11141	8913	7692	5570	4297	3448
					FEED	251	369	468	508	485	618	632	590
23-24	Aluminum-cast, alloyed	0.1D	1.5D	Vc	68	94	91	91	94	91	88	85	
				fz	0.005	0.008	0.014	0.019	0.021	0.037	0.049	0.057	
				RPM	10823	9974	7242	5793	4987	3621	2801	2255	
				FEED	162	239	304	330	314	402	412	386	

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

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EQ572, EQ573, EQ516, EQ553, EQ554, EQ551, EQ552 SERIES

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

3 FLUTE TiAlN COATED - SIDE CUTTING

VDI 3323	Parameter	Diameter (Ø)											
		14.0	16.0	18.0	20.0	22.0	25.0	28.0	30.0	32.0	35.0	36.0	40.0
1	Vc	50	50	50	50	50	50	50	45	50	50	50	50
	fz	0.07	0.078	0.08	0.09	0.1	0.101	0.101	0.099	0.099	0.096	0.097	0.107
	RPM	1137	995	884	796	723	637	568	477	497	455	442	398
2	FEED	239	233	212	215	217	193	172	142	148	131	129	128
	Vc	45	40	40	40	45	45	45	40	40	40	40	40
	fz	0.058	0.073	0.081	0.09	0.09	0.092	0.088	0.085	0.09	0.088	0.086	0.097
3-4	RPM	1023	796	707	637	651	573	512	424	398	364	354	318
	FEED	178	174	172	172	176	158	135	108	107	96	91	93
	Vc	35	30	30	35	35	35	35	35	30	30	30	30
5	fz	0.053	0.058	0.065	0.065	0.075	0.07	0.073	0.071	0.075	0.075	0.077	0.087
	RPM	796	597	531	557	506	446	398	371	298	273	265	239
	FEED	127	104	103	109	114	94	87	79	67	61	61	62
6	Vc	20	20	20	20	20	20	20	20	20	20	20	20
	fz	0.051	0.06	0.067	0.075	0.075	0.067	0.061	0.061	0.067	0.065	0.069	0.078
	RPM	455	398	354	318	289	255	227	212	199	182	177	159
7	FEED	70	72	71	72	65	51	42	39	40	35	37	37
	Vc	45	40	40	40	45	45	45	40	40	40	40	40
	fz	0.058	0.073	0.081	0.09	0.09	0.092	0.088	0.085	0.09	0.088	0.086	0.097
8-9	RPM	1023	796	707	637	651	573	512	424	398	364	354	318
	FEED	178	174	172	172	176	158	135	108	107	96	91	93
	Vc	35	30	30	35	35	35	35	35	30	30	30	30
10	fz	0.053	0.058	0.065	0.065	0.075	0.07	0.073	0.071	0.075	0.075	0.077	0.087
	RPM	796	597	531	557	506	446	398	371	298	273	265	239
	FEED	127	104	103	109	114	94	87	79	67	61	61	62
11.1	Vc	20	20	20	20	20	20	20	20	20	20	20	20
	fz	0.051	0.06	0.067	0.075	0.075	0.067	0.061	0.061	0.067	0.065	0.069	0.078
	RPM	455	398	354	318	289	255	227	212	199	182	177	159
21-22	FEED	70	72	71	72	65	51	42	39	40	35	37	37
	Vc	135	140	140	140	135	135	130	140	140	145	140	140
	fz	0.06	0.067	0.075	0.076	0.082	0.088	0.093	0.093	0.09	0.092	0.093	0.094
23-24	RPM	3069	2785	2476	2228	1953	1719	1478	1485	1393	1319	1238	1114
	FEED	552	560	557	508	481	454	412	414	376	364	345	314
	Vc	88	91	91	91	88	88	85	91	91	94	91	91
23-24	fz	0.06	0.067	0.075	0.076	0.082	0.088	0.093	0.093	0.09	0.092	0.093	0.094
	RPM	2001	1810	1609	1448	1273	1120	966	966	905	855	805	724
	FEED	360	364	362	330	313	296	270	269	244	236	224	204

