



FLAT SHANK

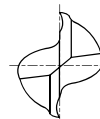
E2570 SERIES

FLAT SHANK

EQ570 SERIES

HSSCo8, 2 FLUTE SHORT LENGTH

- HSSCo8, 2 SCHNEIDEN KURZ
- Fraise HSSCo8, 2 dents, courte
- 2 TAGLIENTI, SERIE CORTA - HSSCo8



P.746~749

Unit : mm

| EDP No. | Mill Diameter | | Shank Diameter | | Length of Cut | Overall Length |
|----------|---------------|-------|----------------|-----|---------------|----------------|
| | UNCOATED | TiAlN | e8 | h6 | | |
| E2570010 | EQ570010 | 1.0 | 6 | 2.5 | 47 | |
| E2570015 | EQ570015 | 1.5 | 6 | 3 | 47 | |
| E2570020 | EQ570020 | 2.0 | 6 | 4 | 48 | |
| E2570025 | EQ570025 | 2.5 | 6 | 5 | 49 | |
| E2570028 | EQ570028 | 2.8 | 6 | 5 | 49 | |
| E2570030 | EQ570030 | 3.0 | 6 | 5 | 49 | |
| E2570035 | EQ570035 | 3.5 | 6 | 6 | 50 | |
| E2570038 | EQ570038 | 3.8 | 6 | 7 | 51 | |
| E2570040 | EQ570040 | 4.0 | 6 | 7 | 51 | |
| E2570045 | EQ570045 | 4.5 | 6 | 7 | 51 | |
| E2570048 | EQ570048 | 4.8 | 6 | 8 | 52 | |
| E2570050 | EQ570050 | 5.0 | 6 | 8 | 52 | |
| E2570055 | EQ570055 | 5.5 | 6 | 8 | 52 | |
| E2570957 | EQ570957 | 5.8 | 6 | 8 | 52 | |
| E2570060 | EQ570060 | 6.0 | 6 | 8 | 52 | |
| E2570065 | EQ570065 | 6.5 | 10 | 10 | 60 | |
| E2570967 | EQ570967 | 6.8 | 10 | 10 | 60 | |
| E2570070 | EQ570070 | 7.0 | 10 | 10 | 60 | |
| E2570075 | EQ570075 | 7.5 | 10 | 10 | 60 | |
| E2570977 | EQ570977 | 7.8 | 10 | 11 | 61 | |
| E2570080 | EQ570080 | 8.0 | 10 | 11 | 61 | |
| E2570085 | EQ570085 | 8.5 | 10 | 11 | 61 | |
| E2570087 | EQ570087 | 8.7 | 10 | 11 | 61 | |
| E2570090 | EQ570090 | 9.0 | 10 | 11 | 61 | |

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 μm | | | | | |
|-----------|----------------------------------|-------------|--------------|---------------|---------------|---------------|
| | 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 | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ |

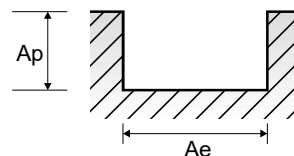
E2570, E2571, E2510 SERIES 2 FLUTE - SLOTTING

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

| 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 |
| | | | | | 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 | | 1.0D | 0.5D | Vc | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 |
| | | | | | fz | 0.003 | 0.007 | 0.013 | 0.019 | 0.025 | 0.041 | 0.05 | 0.063 |
| | | | | | RPM | 4775 | 3183 | 2387 | 1910 | 1592 | 1194 | 955 | 796 |
| | 3-4 | | 1.0D | 0.5D | Vc | 25 | 25 | 25 | 25 | 25 | 25 | 25 | 25 |
| | | | | | fz | 0.004 | 0.008 | 0.013 | 0.019 | 0.025 | 0.039 | 0.05 | 0.063 |
| | | | | | RPM | 3979 | 2653 | 1989 | 1592 | 1326 | 995 | 796 | 663 |
| | 5 | | 1.0D | 0.5D | Vc | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 |
| fz | | 0.003 | | | 0.006 | 0.014 | 0.019 | 0.025 | 0.04 | 0.05 | 0.063 | | |
| RPM | | 2387 | | | 1592 | 1194 | 955 | 796 | 597 | 477 | 398 | | |
| 6 | 1.0D | 0.5D | Vc | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | | |
| | | | fz | 0.003 | 0.007 | 0.013 | 0.019 | 0.025 | 0.041 | 0.05 | 0.063 | | |
| | | | RPM | 4775 | 3183 | 2387 | 1910 | 1592 | 1194 | 955 | 796 | | |
| 7 | 1.0D | 0.5D | Vc | 25 | 25 | 25 | 25 | 25 | 25 | 25 | 25 | | |
| | | | fz | 0.004 | 0.008 | 0.013 | 0.019 | 0.025 | 0.039 | 0.05 | 0.063 | | |
| | | | RPM | 3979 | 2653 | 1989 | 1592 | 1326 | 995 | 796 | 663 | | |
| 8-9 | 1.0D | 0.5D | Vc | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | | |
| | | | fz | 0.003 | 0.006 | 0.014 | 0.019 | 0.025 | 0.04 | 0.05 | 0.063 | | |
| | | | RPM | 2387 | 1592 | 1194 | 955 | 796 | 597 | 477 | 398 | | |
| 10 | 1.0D | 0.5D | Vc | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | | |
| | | | fz | 0.003 | 0.007 | 0.013 | 0.019 | 0.025 | 0.041 | 0.05 | 0.063 | | |
| | | | RPM | 4775 | 3183 | 2387 | 1910 | 1592 | 1194 | 955 | 796 | | |
| 11.1 | 1.0D | 0.5D | Vc | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | | |
| | | | fz | 0.003 | 0.006 | 0.014 | 0.019 | 0.025 | 0.04 | 0.05 | 0.063 | | |
| | | | 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 | 0.007 | 0.011 | 0.018 | 0.025 | 0.028 | 0.049 | 0.065 | 0.076 |
| | | | | | RPM | 11937 | 11141 | 7958 | 6366 | 5570 | 3979 | 3024 | 2520 |
| 23-24 | Aluminum-cast, alloyed | 1.0D | 0.5D | Vc | 49 | 68 | 65 | 65 | 68 | 65 | 62 | 62 | |
| | | | | fz | 0.007 | 0.011 | 0.018 | 0.025 | 0.028 | 0.049 | 0.065 | 0.076 | |
| | | | | RPM | 7799 | 7215 | 5173 | 4138 | 3608 | 2586 | 1974 | 1645 | |

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

▶ NEXT PAGE

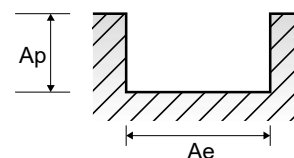


E2570, E2571, E2510 SERIES

2 FLUTE - SLOTTING

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

| VDI 3323 | Parameter | 14.0 | 16.0 | 18.0 | 20.0 | 22.0 | 25.0 | 28.0 | 30.0 | 32.0 | 36.0 | 40.0 |
|----------|-----------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1 | Vc | 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 | 0.097 | 0.107 |
| | RPM | 796 | 696 | 619 | 557 | 506 | 446 | 398 | 371 | 348 | 309 | 279 |
| 2 | FEED | 110 | 110 | 98 | 99 | 101 | 89 | 80 | 74 | 70 | 60 | 60 |
| | Vc | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 |
| | fz | 0.064 | 0.08 | 0.09 | 0.1 | 0.1 | 0.1 | 0.1 | 0.097 | 0.098 | 0.1 | 0.114 |
| 3-4 | RPM | 682 | 597 | 531 | 477 | 434 | 382 | 341 | 318 | 298 | 265 | 239 |
| | FEED | 87 | 95 | 95 | 95 | 87 | 76 | 68 | 62 | 58 | 53 | 54 |
| | Vc | 25 | 25 | 25 | 25 | 25 | 25 | 25 | 25 | 20 | 25 | 25 |
| 5 | fz | 0.071 | 0.078 | 0.088 | 0.088 | 0.1 | 0.097 | 0.098 | 0.1 | 0.102 | 0.1 | 0.111 |
| | RPM | 568 | 497 | 442 | 398 | 362 | 318 | 284 | 265 | 199 | 221 | 199 |
| | FEED | 81 | 78 | 78 | 70 | 72 | 62 | 56 | 53 | 41 | 44 | 44 |
| 6 | Vc | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 |
| | fz | 0.071 | 0.08 | 0.09 | 0.102 | 0.102 | 0.097 | 0.094 | 0.094 | 0.107 | 0.104 | 0.114 |
| | RPM | 341 | 298 | 265 | 239 | 217 | 191 | 171 | 159 | 149 | 133 | 119 |
| 7 | FEED | 48 | 48 | 48 | 49 | 44 | 37 | 32 | 30 | 32 | 28 | 27 |
| | Vc | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 |
| | fz | 0.064 | 0.08 | 0.09 | 0.1 | 0.1 | 0.1 | 0.1 | 0.097 | 0.098 | 0.1 | 0.114 |
| 8-9 | RPM | 682 | 597 | 531 | 477 | 434 | 382 | 341 | 318 | 298 | 265 | 239 |
| | FEED | 87 | 95 | 95 | 95 | 87 | 76 | 68 | 62 | 58 | 53 | 54 |
| | Vc | 25 | 25 | 25 | 25 | 25 | 25 | 25 | 25 | 20 | 25 | 25 |
| 10 | fz | 0.071 | 0.078 | 0.088 | 0.088 | 0.1 | 0.097 | 0.098 | 0.1 | 0.102 | 0.1 | 0.111 |
| | RPM | 568 | 497 | 442 | 398 | 362 | 318 | 284 | 265 | 199 | 221 | 199 |
| | FEED | 81 | 78 | 78 | 70 | 72 | 62 | 56 | 53 | 41 | 44 | 44 |
| 11.1 | Vc | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 |
| | fz | 0.071 | 0.08 | 0.09 | 0.102 | 0.102 | 0.097 | 0.094 | 0.094 | 0.107 | 0.104 | 0.114 |
| | RPM | 341 | 298 | 265 | 239 | 217 | 191 | 171 | 159 | 149 | 133 | 119 |
| 21-22 | FEED | 48 | 48 | 48 | 49 | 44 | 37 | 32 | 30 | 32 | 28 | 27 |
| | Vc | 95 | 100 | 100 | 100 | 95 | 95 | 95 | 105 | 100 | 100 | 100 |
| | fz | 0.08 | 0.088 | 0.097 | 0.1 | 0.107 | 0.117 | 0.123 | 0.123 | 0.12 | 0.122 | 0.125 |
| 23-24 | RPM | 2160 | 1989 | 1768 | 1592 | 1375 | 1210 | 1080 | 1114 | 995 | 884 | 796 |
| | FEED | 346 | 350 | 343 | 318 | 294 | 283 | 266 | 274 | 239 | 216 | 199 |
| | Vc | 62 | 65 | 65 | 65 | 62 | 62 | 62 | 68 | 65 | 65 | 65 |
| 23-24 | fz | 0.08 | 0.088 | 0.097 | 0.1 | 0.107 | 0.117 | 0.123 | 0.123 | 0.12 | 0.122 | 0.125 |
| | RPM | 1410 | 1293 | 1149 | 1035 | 897 | 789 | 705 | 722 | 647 | 575 | 517 |
| | FEED | 226 | 228 | 223 | 207 | 192 | 185 | 173 | 177 | 155 | 140 | 129 |



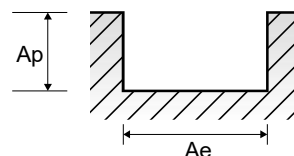
EQ570, EQ571, EQ510 SERIES 2 FLUTE TiAlN COATED - SLOTTING

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

| 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 | 50 | 45 |
| | | | | | fz | 0.004 | 0.008 | 0.013 | 0.02 | 0.025 | 0.036 | 0.045 | 0.062 |
| | | | | | RPM | 7958 | 4775 | 3979 | 3183 | 2387 | 1989 | 1592 | 1194 |
| | 2 | | Vc | 40 | 40 | 40 | 40 | 40 | 40 | 40 | 40 | | |
| | | | fz | 0.003 | 0.007 | 0.012 | 0.02 | 0.024 | 0.04 | 0.05 | 0.064 | | |
| | | | RPM | 6366 | 4244 | 3183 | 2546 | 2122 | 1592 | 1273 | 1061 | | |
| | 3-4 | | Vc | 35 | 35 | 30 | 35 | 30 | 30 | 35 | 35 | | |
| | | | fz | 0.004 | 0.008 | 0.013 | 0.019 | 0.025 | 0.04 | 0.05 | 0.061 | | |
| | | | RPM | 5570 | 3714 | 2387 | 2228 | 1592 | 1194 | 1114 | 928 | | |
| | 5 | | Vc | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 | | |
| | | | fz | 0.003 | 0.007 | 0.013 | 0.02 | 0.025 | 0.041 | 0.05 | 0.064 | | |
| RPM | | 3183 | 2122 | 1592 | 1273 | 1061 | 796 | 637 | 531 | | | | |
| 6 | Vc | 40 | 40 | 40 | 40 | 40 | 40 | 40 | 40 | | | | |
| | fz | 0.003 | 0.007 | 0.012 | 0.02 | 0.024 | 0.04 | 0.05 | 0.064 | | | | |
| | RPM | 6366 | 4244 | 3183 | 2546 | 2122 | 1592 | 1273 | 1061 | | | | |
| 7 | Vc | 35 | 35 | 30 | 35 | 30 | 30 | 35 | 35 | | | | |
| | fz | 0.004 | 0.008 | 0.013 | 0.019 | 0.025 | 0.04 | 0.05 | 0.061 | | | | |
| | RPM | 5570 | 3714 | 2387 | 2228 | 1592 | 1194 | 1114 | 928 | | | | |
| 8-9 | Vc | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 | | | | |
| | fz | 0.003 | 0.007 | 0.013 | 0.02 | 0.025 | 0.041 | 0.05 | 0.064 | | | | |
| | RPM | 3183 | 2122 | 1592 | 1273 | 1061 | 796 | 637 | 531 | | | | |
| 10 | Vc | 40 | 40 | 40 | 40 | 40 | 40 | 40 | 40 | | | | |
| | fz | 0.003 | 0.007 | 0.012 | 0.02 | 0.024 | 0.04 | 0.05 | 0.064 | | | | |
| | RPM | 6366 | 4244 | 3183 | 2546 | 2122 | 1592 | 1273 | 1061 | | | | |
| 11.1 | Vc | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 | | | | |
| | fz | 0.003 | 0.007 | 0.013 | 0.02 | 0.025 | 0.041 | 0.05 | 0.064 | | | | |
| | RPM | 3183 | 2122 | 1592 | 1273 | 1061 | 796 | 637 | 531 | | | | |
| N | 21-22 | Aluminum-wrought alloy | 1.0D | 0.5D | Vc | 105 | 145 | 140 | 140 | 150 | 140 | 135 | 130 |
| | | | | | fz | 0.007 | 0.011 | 0.018 | 0.025 | 0.028 | 0.049 | 0.064 | 0.076 |
| | | | | | RPM | 16711 | 15385 | 11141 | 8913 | 7958 | 5570 | 4297 | 3448 |
| 23-24 | Aluminum-cast, alloyed | 1.0D | 0.5D | Vc | 68 | 94 | 91 | 91 | 98 | 91 | 88 | 85 | |
| | | | | fz | 0.007 | 0.011 | 0.018 | 0.025 | 0.028 | 0.049 | 0.064 | 0.076 | |
| | | | | RPM | 10823 | 9974 | 7242 | 5793 | 5199 | 3621 | 2801 | 2255 | |

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

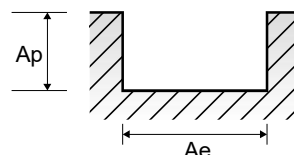
▶ NEXT PAGE



E2464, E2509 SERIES 2 FLUTE - SLOTTING

| ISO | VDI 3323 | Material Description | Ae | Ap | Parameter | Diameter (Ø) | | | | | | | | |
|-------|------------------------|------------------------|------|------|-----------|--------------|------|-------|------|------|-------|-------|-------|-------|
| | | | | | | 3.0 | 6.0 | 8.0 | 10.0 | 12.0 | 14.0 | 16.0 | 18.0 | 20.0 |
| N | 21-22 | Aluminum-wrought alloy | 1.0D | 0.5D | Vc | 75 | 130 | 150 | 155 | 190 | 155 | 175 | 130 | 145 |
| | | | | | fz | 0.035 | 0.05 | 0.071 | 0.12 | 0.12 | 0.177 | 0.177 | 0.283 | 0.283 |
| | | | | | RPM | 7958 | 6897 | 5968 | 4934 | 5040 | 3524 | 3482 | 2299 | 2308 |
| | | | | | FEED | 557 | 690 | 848 | 1184 | 1210 | 1248 | 1232 | 1301 | 1306 |
| | | | | | Vc | 49 | 85 | 98 | 101 | 124 | 101 | 114 | 85 | 94 |
| | | | | | fz | 0.035 | 0.05 | 0.071 | 0.12 | 0.12 | 0.177 | 0.177 | 0.283 | 0.283 |
| 23-24 | Aluminum-cast, alloyed | 1.0D | 0.5D | RPM | 5199 | 4509 | 3899 | 3215 | 3289 | 2296 | 2268 | 1503 | 1496 | |
| | | | | FEED | 364 | 451 | 554 | 772 | 789 | 813 | 803 | 851 | 847 | |

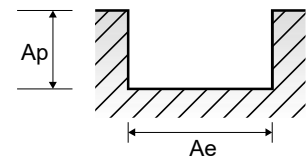
▶ NEXT PAGE



EQ570, EQ571, EQ510 SERIES 2 FLUTE TIALN COATED - **SLOTING**

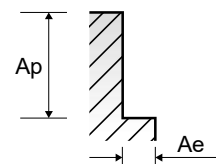
Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

| VDI 3323 | Parameter | Diameter (Ø) | | | | | | | | | | |
|----------|-----------|--------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | | 14.0 | 16.0 | 18.0 | 20.0 | 22.0 | 25.0 | 28.0 | 30.0 | 32.0 | 36.0 | 40.0 |
| 1 | Vc | 50 | 50 | 50 | 50 | 50 | 50 | 50 | 45 | 50 | 50 | 50 |
| | fz | 0.07 | 0.078 | 0.078 | 0.088 | 0.1 | 0.096 | 0.1 | 0.1 | 0.1 | 0.094 | 0.106 |
| | RPM | 1137 | 995 | 884 | 796 | 723 | 637 | 568 | 477 | 497 | 442 | 398 |
| 2 | Vc | 45 | 40 | 40 | 40 | 45 | 45 | 45 | 40 | 40 | 40 | 40 |
| | fz | 0.063 | 0.078 | 0.089 | 0.096 | 0.096 | 0.1 | 0.1 | 0.094 | 0.094 | 0.1 | 0.117 |
| | RPM | 1023 | 796 | 707 | 637 | 651 | 573 | 512 | 424 | 398 | 354 | 318 |
| 3-4 | Vc | 35 | 35 | 30 | 35 | 35 | 35 | 35 | 30 | 30 | 35 | 30 |
| | fz | 0.069 | 0.077 | 0.091 | 0.091 | 0.1 | 0.094 | 0.094 | 0.1 | 0.108 | 0.092 | 0.11 |
| | RPM | 796 | 696 | 531 | 557 | 506 | 446 | 398 | 371 | 298 | 309 | 239 |
| 5 | Vc | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 15 | 20 |
| | fz | 0.07 | 0.081 | 0.093 | 0.108 | 0.108 | 0.1 | 0.1 | 0.1 | 0.1 | 0.117 | 0.117 |
| | RPM | 455 | 398 | 354 | 318 | 289 | 255 | 227 | 212 | 199 | 133 | 159 |
| 6 | Vc | 45 | 40 | 40 | 40 | 45 | 45 | 45 | 40 | 40 | 40 | 40 |
| | fz | 0.063 | 0.078 | 0.089 | 0.096 | 0.096 | 0.1 | 0.1 | 0.094 | 0.094 | 0.1 | 0.117 |
| | RPM | 1023 | 796 | 707 | 637 | 651 | 573 | 512 | 424 | 398 | 354 | 318 |
| 7 | Vc | 35 | 35 | 30 | 35 | 35 | 35 | 35 | 30 | 30 | 35 | 30 |
| | fz | 0.069 | 0.077 | 0.091 | 0.091 | 0.1 | 0.094 | 0.094 | 0.1 | 0.108 | 0.092 | 0.11 |
| | RPM | 796 | 696 | 531 | 557 | 506 | 446 | 398 | 371 | 298 | 309 | 239 |
| 8-9 | Vc | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 15 | 20 |
| | fz | 0.07 | 0.081 | 0.093 | 0.108 | 0.108 | 0.1 | 0.1 | 0.1 | 0.1 | 0.117 | 0.117 |
| | RPM | 455 | 398 | 354 | 318 | 289 | 255 | 227 | 212 | 199 | 133 | 159 |
| 10 | Vc | 45 | 40 | 40 | 40 | 45 | 45 | 45 | 40 | 40 | 40 | 40 |
| | fz | 0.063 | 0.078 | 0.089 | 0.096 | 0.096 | 0.1 | 0.1 | 0.094 | 0.094 | 0.1 | 0.117 |
| | RPM | 1023 | 796 | 707 | 637 | 651 | 573 | 512 | 424 | 398 | 354 | 318 |
| 11.1 | Vc | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 15 | 20 |
| | fz | 0.07 | 0.081 | 0.093 | 0.108 | 0.108 | 0.1 | 0.1 | 0.1 | 0.1 | 0.117 | 0.117 |
| | RPM | 455 | 398 | 354 | 318 | 289 | 255 | 227 | 212 | 199 | 133 | 159 |
| 21 - 22 | Vc | 135 | 140 | 140 | 140 | 135 | 135 | 135 | 145 | 140 | 140 | 140 |
| | fz | 0.079 | 0.088 | 0.098 | 0.1 | 0.108 | 0.115 | 0.123 | 0.123 | 0.12 | 0.124 | 0.127 |
| | RPM | 3069 | 2785 | 2476 | 2228 | 1953 | 1719 | 1535 | 1538 | 1393 | 1238 | 1114 |
| 23 - 24 | Vc | 88 | 91 | 91 | 91 | 88 | 88 | 88 | 94 | 91 | 91 | 91 |
| | fz | 0.079 | 0.088 | 0.098 | 0.1 | 0.108 | 0.115 | 0.123 | 0.123 | 0.12 | 0.124 | 0.127 |
| | RPM | 2001 | 1810 | 1609 | 1448 | 1273 | 1120 | 1000 | 997 | 905 | 805 | 724 |
| | FEED | 316 | 319 | 315 | 290 | 275 | 258 | 246 | 245 | 217 | 200 | 184 |



E2464, E2509 SERIES 2 FLUTE - **SITE CUTTING**

| ISO | VDI 3323 | Material Description | Ae | Ap | Parameter | Diameter (Ø) | | | | | | | | |
|-----|----------|------------------------|------------------------------|------|-----------|--------------|-------|-------|------|------|-------|-------|------|------|
| | | | | | | 3.0 | 6.0 | 8.0 | 10.0 | 12.0 | 14.0 | 16.0 | 18.0 | 20.0 |
| N | 21-22 | Aluminum-wrought alloy | Ø3~Ø10=0.25D Ø12~Ø20=0.5D | 1.0D | Vc | 75 | 130 | 150 | 155 | 190 | 155 | 175 | 130 | 145 |
| | | | | | fz | 0.046 | 0.064 | 0.092 | 0.15 | 0.15 | 0.229 | 0.229 | 0.37 | 0.37 |
| | | | | | RPM | 7958 | 6897 | 5968 | 4934 | 5040 | 3524 | 3482 | 2299 | 2308 |
| | 23-24 | Aluminum-cast, alloyed | Ø3~Ø10=0.25D Ø12~Ø20=0.5D | 1.0D | Vc | 49 | 85 | 98 | 101 | 124 | 101 | 114 | 85 | 94 |
| | | | | | fz | 0.046 | 0.064 | 0.092 | 0.15 | 0.15 | 0.229 | 0.229 | 0.37 | 0.37 |
| | | | | | RPM | 5199 | 4509 | 3899 | 3215 | 3289 | 2296 | 2268 | 1503 | 1496 |
| | FEED | 478 | 577 | 717 | 964 | 987 | 1052 | 1039 | 1112 | 1107 | | | | |



CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR END MILLS

X5070 END MILLS

4G MILL END MILLS

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

V7 PLUS END MILLS

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

D-POWER CFRP END MILLS

ROUTERS

CRX S END MILLS

K-2 END MILLS

ONLY ONE COATED PM60 END MILLS

TANK-POWER END MILLS

GENERAL HSS END MILLS

MILLING CUTTERS

TECHNICAL DATA