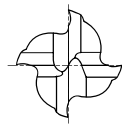


HSSCo8, 4 FLUTE LONG LENGTH - CENTER CUTTING

- HSSCo8, 4&6 SCHNEIDEN LANG
- Fraise HSSCo8, 4&6 dents, coupe au centre, longue
- 4&6 TAGLIANTI, SERIE LUNGA, TAGLIENTE AL CENTRO - HSSCo8



HSS Co8
DIN 844
4
30°
DIN 1835B
P.758~761

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	TiAIN				
E2597020	EQ597020	2.0	6	10	54
E2597025	EQ597025	2.5	6	12	56
E2597030	EQ597030	3.0	6	12	56
E2597035	EQ597035	3.5	6	15	59
E2597040	EQ597040	4.0	6	19	63
E2597045	EQ597045	4.5	6	19	63
E2597050	EQ597050	5.0	6	24	68
E2597055	EQ597055	5.5	6	24	68
E2597060	EQ597060	6.0	6	24	68
E2597070	EQ597070	7.0	10	30	80
E2597080	EQ597080	8.0	10	38	88
E2597090	EQ597090	9.0	10	38	88
E2597100	EQ597100	10.0	10	45	95
E2597110	EQ597110	11.0	12	45	102
E2597120	EQ597120	12.0	12	53	110
E2597130	EQ597130	13.0	12	53	110
E2597140	EQ597140	14.0	12	53	110
E2597150	EQ597150	15.0	12	53	110
E2597160	EQ597160	16.0	16	63	123
E2597170	EQ597170	17.0	16	63	123
E2597180	EQ597180	18.0	16	63	123
E2597190	EQ597190	19.0	16	63	123
E2597200	EQ597200	20.0	20	75	141

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

Mill Dia. Tolerance(mm)		Shank Dia. Tolerance
up to Ø6	0 ~ + 0.04	
over Ø6	0 ~ + 0.05	

◎ : 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	42	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	○	○	○	○	○																

E2574, E2575, E2576, E2577, E2597, E2598, E2776 SERIES

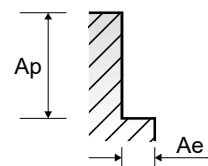
Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

MULTI 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
P	1	Non-alloy steel	0.1D	1.5D	Vc	35	35	35	35	35	35	35
					fz	0.004	0.008	0.013	0.02	0.025	0.036	0.045
					RPM	5570	3714	2785	2228	1857	1393	1114
	2		0.1D	1.5D	Vc	30	30	30	30	30	30	30
					fz	0.003	0.006	0.011	0.017	0.023	0.036	0.044
					RPM	4775	3183	2387	1910	1592	1194	955
	3-4		0.1D	1.5D	Vc	25	25	25	25	25	25	25
					fz	0.003	0.006	0.009	0.014	0.019	0.029	0.038
					RPM	3979	2653	1989	1592	1326	995	796
	5		0.1D	1.5D	Vc	15	15	15	15	15	15	15
					fz	0.002	0.005	0.01	0.014	0.019	0.029	0.036
RPM		2387			1592	1194	955	796	597	477		
6	0.1D	1.5D	Vc	30	30	30	30	30	30	30		
			fz	0.003	0.006	0.011	0.017	0.023	0.036	0.044		
			RPM	4775	3183	2387	1910	1592	1194	955		
7	0.1D	1.5D	Vc	25	25	25	25	25	25	25		
			fz	0.003	0.006	0.009	0.014	0.019	0.029	0.038		
			RPM	3979	2653	1989	1592	1326	995	796		
8-9	0.1D	1.5D	Vc	15	15	15	15	15	15	15		
			fz	0.002	0.005	0.01	0.014	0.019	0.029	0.036		
			RPM	2387	1592	1194	955	796	597	477		
10	0.1D	1.5D	Vc	30	30	30	30	30	30	30		
			fz	0.003	0.006	0.011	0.017	0.023	0.036	0.044		
			RPM	4775	3183	2387	1910	1592	1194	955		
11.1	0.1D	1.5D	Vc	15	15	15	15	15	15	15		
			fz	0.002	0.005	0.01	0.014	0.019	0.029	0.036		
			RPM	2387	1592	1194	955	796	597	477		
N	21-22	Aluminum-wrought alloy	0.1D	1.5D	Vc	75	105	100	100	105	100	95
					fz	0.005	0.009	0.014	0.019	0.021	0.036	0.048
					RPM	11937	11141	7958	6366	5570	3979	3024
N	23-24	Aluminum-cast, alloyed	0.1D	1.5D	Vc	49	68	65	65	68	65	62
					fz	0.005	0.009	0.014	0.019	0.021	0.036	0.048
					RPM	7799	7215	5173	4138	3608	2586	1974

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

▶ NEXT PAGE

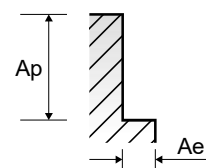


EQ574, EQ575, EQ576, EQ577, EQ597, EQ598, EQ776 SERIES

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

MULTI FLUTE TIAIN COATED - SIDE CUTTING

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	50	50	50	50	50	50	50	45	50	50	50
	fz	0.07	0.078	0.078	0.088	0.067	0.064	0.068	0.065	0.065	0.063	0.071
	RPM	1137	995	884	796	723	637	568	477	497	442	398
	FEED	318	310	276	280	291	244	232	186	194	167	170
2	Vc	45	40	40	40	45	45	45	40	40	40	40
	fz	0.056	0.07	0.08	0.087	0.058	0.062	0.058	0.057	0.058	0.06	0.069
	RPM	1023	796	707	637	651	573	512	424	398	354	318
	FEED	229	223	226	222	227	213	178	145	138	127	132
3-4	Vc	35	35	30	35	35	35	35	35	30	35	30
	fz	0.053	0.056	0.066	0.066	0.048	0.046	0.046	0.05	0.05	0.047	0.057
	RPM	796	696	531	557	506	446	398	371	298	309	239
	FEED	169	156	140	147	146	123	110	111	90	87	82
5	Vc	20	20	20	20	20	20	20	20	20	15	20
	fz	0.053	0.056	0.064	0.075	0.05	0.047	0.054	0.054	0.054	0.056	0.056
	RPM	455	398	354	318	289	255	227	212	199	133	159
	FEED	96	89	91	95	87	72	74	69	64	45	53
6	Vc	45	40	40	40	45	45	45	40	40	40	40
	fz	0.056	0.07	0.08	0.087	0.058	0.062	0.058	0.057	0.058	0.06	0.069
	RPM	1023	796	707	637	651	573	512	424	398	354	318
	FEED	229	223	226	222	227	213	178	145	138	127	132
7	Vc	35	35	30	35	35	35	35	35	30	35	30
	fz	0.053	0.056	0.066	0.066	0.048	0.046	0.046	0.05	0.05	0.047	0.057
	RPM	796	696	531	557	506	446	398	371	298	309	239
	FEED	169	156	140	147	146	123	110	111	90	87	82
8-9	Vc	20	20	20	20	20	20	20	20	20	15	20
	fz	0.053	0.056	0.064	0.075	0.05	0.047	0.054	0.054	0.054	0.056	0.056
	RPM	455	398	354	318	289	255	227	212	199	133	159
	FEED	96	89	91	95	87	72	74	69	64	45	53
10	Vc	45	40	40	40	45	45	45	40	40	40	40
	fz	0.056	0.07	0.08	0.087	0.058	0.062	0.058	0.057	0.058	0.06	0.069
	RPM	1023	796	707	637	651	573	512	424	398	354	318
	FEED	229	223	226	222	227	213	178	145	138	127	132
11.1	Vc	20	20	20	20	20	20	20	20	20	15	20
	fz	0.053	0.056	0.064	0.075	0.05	0.047	0.054	0.054	0.054	0.056	0.056
	RPM	455	398	354	318	289	255	227	212	199	133	159
	FEED	96	89	91	95	87	72	74	69	64	45	53
21 - 22	Vc	135	140	140	140	135	135	135	145	140	140	140
	fz	0.06	0.066	0.074	0.074	0.054	0.058	0.06	0.06	0.06	0.061	0.064
	RPM	3069	2785	2476	2228	1953	1719	1535	1538	1393	1238	1114
	FEED	737	735	733	660	633	598	552	554	501	453	428
23 - 24	Vc	88	91	91	91	88	88	88	94	91	91	91
	fz	0.06	0.066	0.074	0.074	0.054	0.058	0.06	0.06	0.06	0.061	0.064
	RPM	2001	1810	1609	1448	1273	1120	1000	997	905	805	724
	FEED	480	478	476	429	413	390	360	359	326	294	278



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