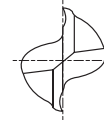


2 FLUTE SHORT END MILLS



P.15~16

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
Non Coating	TiAIN	e8	h6		
ESH570020	EHC570020	2.0	6	4	48
ESH570030	EHC570030	3.0	6	5	49
ESH570040	EHC570040	4.0	6	7	51
ESH570050	EHC570050	5.0	6	8	52
ESH570060	EHC570060	6.0	6	8	52
ESH570070	EHC570070	7.0	10	10	60
ESH570080	EHC570080	8.0	10	11	61
ESH570090	EHC570090	9.0	10	11	61
ESH570100	EHC570100	10.0	10	13	63
ESH570110	EHC570110	11.0	12	13	70
ESH570120	EHC570120	12.0	12	16	73
ESH570130	EHC570130	13.0	12	16	73
ESH570140	EHC570140	14.0	12	16	73
ESH570150	EHC570150	15.0	12	16	73
ESH570160	EHC570160	16.0	16	19	79
ESH570170	EHC570170	17.0	16	19	79
ESH570180	EHC570180	18.0	16	19	79
ESH570190	EHC570190	19.0	16	19	79
ESH570200	EHC570200	20.0	20	22	88
ESH570210	EHC570210	21.0	20	22	88
ESH570220	EHC570220	22.0	20	22	88
ESH570230	EHC570230	23.0	25	22	88
ESH570240	EHC570240	24.0	25	26	102
ESH570250	EHC570250	25.0	25	26	102
ESH570280	EHC570280	28.0	25	26	102
ESH570300	EHC570300	30.0	25	26	102
ESH570320	EHC570320	32.0	32	32	112

Tolerances according to DIN 7160 & 7161

Tolerance range in μm						
Nominal-Diameter in μm						
	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

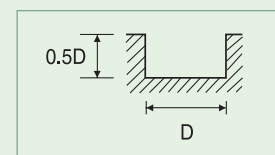
2 FLUTE TiAIN COATED - SLOTTING

EHC570, EHC571 Series

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS			
	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²			
HARDNESS					~ HRc20				HRc20 ~ HRc30			
STRENGTH												
DIAMETER	RPM	FEED	V _c	f _z	RPM	FEED	V _c	f _z	RPM	FEED	V _c	f _z
2.0	7850	55	50	0.004	6300	40	40	0.003	5600	40	35	0.004
3.0	4900	75	45	0.008	4500	65	40	0.007	3500	55	35	0.008
4.0	3900	100	50	0.013	3100	75	40	0.012	2500	65	30	0.013
5.0	3100	125	50	0.020	2500	100	40	0.020	2250	85	35	0.019
6.0	2500	125	45	0.025	2250	110	40	0.024	1700	85	30	0.025
8.0	1950	140	50	0.036	1550	125	40	0.040	1250	100	30	0.040
10.0	1550	140	50	0.045	1250	125	40	0.050	1100	110	35	0.050
12.0	1250	155	45	0.062	1100	140	40	0.064	900	110	35	0.061
14.0	1100	155	50	0.070	1000	125	45	0.063	800	110	35	0.069
16.0	1000	155	50	0.078	800	125	40	0.078	650	100	35	0.077
18.0	900	140	50	0.078	700	125	40	0.089	550	100	30	0.091
20.0	800	140	50	0.088	650	125	40	0.096	550	100	35	0.091
22.0	700	140	50	0.100	650	125	45	0.096	500	100	35	0.100
25.0	650	125	50	0.096	550	110	45	0.100	450	85	35	0.094
28.0	550	110	50	0.100	500	100	45	0.100	400	75	35	0.094
30.0	500	100	45	0.100	450	85	40	0.094	350	70	35	0.100
32.0	500	100	50	0.100	400	75	40	0.094	300	65	30	0.108

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				ALUMINUM ALUMINUM ALLOYS			
	HRc30 ~ HRc40				1000 ~ 1300N/mm ²			
DIAMETER	RPM	FEED	V _c	f _z	RPM	FEED	V _c	f _z
2.0	3100	20	20	0.003	16800	225	105	0.007
3.0	2250	30	20	0.007	15400	350	145	0.011
4.0	1550	40	20	0.013	11200	405	140	0.018
5.0	1250	50	20	0.020	8800	435	140	0.025
6.0	1100	55	20	0.025	7850	435	150	0.028
8.0	800	65	20	0.041	5600	545	140	0.049
10.0	650	65	20	0.050	4350	560	135	0.064
12.0	550	70	20	0.064	3500	530	130	0.076
14.0	500	70	20	0.070	3100	490	135	0.079
16.0	400	65	20	0.081	2800	490	140	0.088
18.0	350	65	20	0.093	2500	490	140	0.098
20.0	300	65	20	0.108	2250	450	140	0.100
22.0	300	65	20	0.108	1950	420	135	0.108
25.0	250	50	20	0.100	1700	390	135	0.115
28.0	200	40	20	0.100	1550	380	135	0.123
30.0	200	40	20	0.100	1550	380	145	0.123
32.0	200	40	20	0.100	1400	335	140	0.120

RPM = rev./min.
Feed = mm/min.
V_c = m/min.
f_z = mm/tooth



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