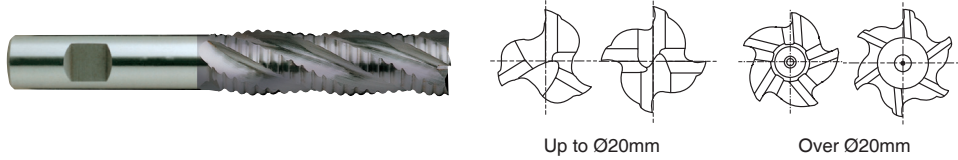


MULTI FLUTE LONG ROUGHING END MILLS (COARSE)



P.25~26

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
Non Coating	TiAlN	js12	h6			
ESH752060	EHC752060	6.0	6	24	68	3
ESH752070	EHC752070	7.0	10	30	80	3
ESH752080	EHC752080	8.0	10	38	88	3
ESH752090	EHC752090	9.0	10	38	88	3
ESH752100	EHC752100	10.0	10	45	95	4
ESH752110	EHC752110	11.0	12	45	102	4
ESH752120	EHC752120	12.0	12	53	110	4
ESH752130	EHC752130	13.0	12	53	110	4
ESH752140	EHC752140	14.0	12	53	110	4
ESH752150	EHC752150	15.0	12	53	110	4
ESH752160	EHC752160	16.0	16	63	123	4
ESH752170	EHC752170	17.0	16	63	123	4
ESH752180	EHC752180	18.0	16	63	123	4
ESH752190	EHC752190	19.0	16	63	123	4
ESH752200	EHC752200	20.0	20	75	141	4
ESH752220	EHC752220	22.0	20	75	141	5
ESH752240	EHC752240	24.0	25	90	166	5
ESH752250	EHC752250	25.0	25	90	166	5
ESH752260	EHC752260	26.0	25	90	166	6
ESH752280	EHC752280	28.0	25	90	166	6
ESH752300	EHC752300	30.0	25	90	166	6
ESH752320	EHC752320	32.0	32	106	186	6

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
js12	±50	±60	±75	±90	±105	±125
h6	0 -6	0 -8	0 -9	0 -11	0 -13	0 -16

MULTI FLUTE SHORT ROUGHING

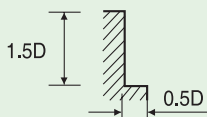
TiAIN COATED- SIDE CUTTING

EHC751, EHC752 Series**EHC752, EHC762** Series

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS			
HARDNESS					~ HRc20				HRc20 ~ HRc30			
STRENGTH	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²			
DIAMETER	RPM	FEED	V _c	f _z	RPM	FEED	V _c	f _z	RPM	FEED	V _c	f _z
6.0	2500	110	45	0.015	2250	85	40	0.013	1700	75	30	0.015
8.0	1950	145	50	0.025	1550	105	40	0.023	1250	90	30	0.024
10.0	1550	210	50	0.034	1250	170	40	0.034	1100	155	35	0.035
12.0	1250	250	45	0.050	1100	195	40	0.044	900	155	35	0.043
14.0	1100	250	50	0.057	1000	195	45	0.049	800	155	35	0.048
16.0	1000	250	50	0.063	800	195	40	0.061	650	155	35	0.060
18.0	900	250	50	0.069	700	195	40	0.070	550	155	30	0.070
20.0	800	250	50	0.078	650	195	40	0.075	550	155	35	0.070
22.0	700	310	50	0.089	650	240	45	0.074	500	195	35	0.078
25.0	650	310	50	0.095	550	240	45	0.087	450	195	35	0.087
28.0	550	295	50	0.089	500	225	45	0.075	400	180	35	0.075
30.0	500	295	45	0.098	450	225	40	0.083	350	180	35	0.086
32.0	500	295	50	0.098	400	225	40	0.094	300	180	30	0.100

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				ALUMINUM ALUMINUM ALLOYS			
HARDNESS	HRc30 ~ HRc40							
STRENGTH	1000 ~ 1300N/mm ²							
DIAMETER	RPM	FEED	V _c	f _z	RPM	FEED	V _c	f _z
6.0	1100	40	20	0.012	6300	280	120	0.015
8.0	800	50	20	0.021	4350	320	110	0.025
10.0	650	85	20	0.033	3500	490	110	0.035
12.0	550	100	20	0.045	2800	560	105	0.050
14.0	500	100	20	0.050	2500	590	110	0.059
16.0	400	100	20	0.063	2250	630	115	0.070
18.0	350	100	20	0.071	1950	660	110	0.085
20.0	300	100	20	0.083	1700	700	105	0.103
22.0	300	120	20	0.080	1550	660	105	0.085
25.0	250	120	20	0.096	1400	630	110	0.090
28.0	220	120	20	0.091	1250	715	110	0.095
30.0	220	120	20	0.091	1250	740	120	0.099
32.0	200	120	20	0.100	1100	700	110	0.106

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%