HSSCo8, 4&6 FLUTE SHORT LENGTH

HSSCo8, 4&6 SCHNEIDEN KURZ
Fraise HSSCo8, 4&6 dents, courte
HSSCo8, 4&6 TAGLIENTI, SERIE CORTA

Under Ø3mm : Center cut type

HSS Co8 | DIN 844 | 4&6 | ≈30° | DIN 1835B

P.758~761

Unit : mm

EDP No. UNCOATED	EDP No. TiAlN	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No.of Flute
E2574020	EQ574020	2.0	6	7	51	4
E2574025	EQ574025	2.5	6	8	52	4
E2574030	EQ574030	3.0	6	8	52	4
E2574035	EQ574035	3.5	6	10	54	4
E2574040	EQ574040	4.0	6	11	55	4
E2574050	EQ574050	5.0	6	13	57	4
E2574060	EQ574060	6.0	6	13	57	4
E2574070	EQ574070	7.0	10	16	66	4
E2574080	EQ574080	8.0	10	19	69	4
E2574090	EQ574090	9.0	10	19	69	4
E2574100	EQ574100	10.0	10	22	72	4
E2574110	EQ574110	11.0	12	22	79	4
E2574120	EQ574120	12.0	12	26	83	4
E2574130	EQ574130	13.0	12	26	83	4
E2574140	EQ574140	14.0	12	26	83	4
E2574150	EQ574150	15.0	12	26	83	4
E2574160	EQ574160	16.0	16	32	92	4
E2574170	EQ574170	17.0	16	32	92	4
E2574180	EQ574180	18.0	16	32	92	4
E2574190	EQ574190	19.0	16	32	92	4
E2574200	EQ574200	20.0	20	38	104	4
▲ E2575210	-	21.0	20	38	104	6
▲ E2575220	-	22.0	20	38	104	6
▲ E2575230	-	23.0	20	38	104	6
▲ E2575240	-	24.0	25	45	121	6
▲ E2575250	▲ EQ575250	25.0	25	45	121	6
▲ E2575260	-	26.0	25	45	121	6
▲ E2575300	▲ EQ575300	30.0	25	45	121	6
▲ E2575320	-	32.0	32	53	133	6
▲ E2575400	-	40.0	32	63	143	6

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ + 0.04	h6

▲ : Only available till stock runs out
▶ Other shank design on your reguest.
▶ TiN and TiCN Coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	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	N										S							H			
Material Description	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	○	○	○	○	○																

HSS END MILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

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

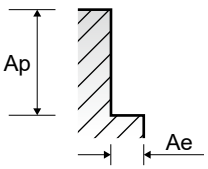
MULTI FLUTE - SIDE CUTTING

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
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
					FEED	89	119	145	178	186	201	201
	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
					FEED	57	76	105	130	146	172	168
	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
					FEED	48	64	72	89	101	115	121
	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
					FEED	19	32	48	53	60	69	69
	6	Low alloy steel	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
					FEED	57	76	105	130	146	172	168
	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
					FEED	48	64	72	89	101	115	121
	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
					FEED	19	32	48	53	60	69	69
	10	High alloyed steel, and tool steel	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
					FEED	57	76	105	130	146	172	168
	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
					FEED	19	32	48	53	60	69	69
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
					FEED	239	401	446	484	468	573	581
	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
					FEED	156	260	290	314	303	372	379

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

▶ NEXT PAGE

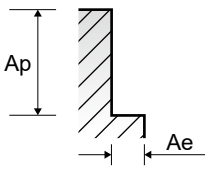


E2574, E2575, E2576, E2577, E2597, E2598, E2776 SERIES

MULTI FLUTE - SIDE CUTTING

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

VDI 3323	Parameter	Diameter (Ø)											
		12.0	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	35
	fz	0.061	0.069	0.079	0.079	0.089	0.067	0.067	0.067	0.067	0.067	0.065	0.071
	RPM	928	796	696	619	557	506	446	398	371	348	309	279
	FEED	227	220	220	196	198	204	179	160	149	140	121	119
2	Vc	30	30	30	30	30	30	30	30	30	30	30	30
	fz	0.056	0.057	0.071	0.08	0.089	0.059	0.06	0.06	0.059	0.06	0.06	0.068
	RPM	796	682	597	531	477	434	382	341	318	298	265	239
	FEED	178	156	170	170	170	154	138	123	113	107	95	97
3-4	Vc	25	25	25	25	25	25	25	25	25	20	25	25
	fz	0.048	0.054	0.058	0.066	0.066	0.05	0.048	0.048	0.05	0.049	0.05	0.056
	RPM	663	568	497	442	398	362	318	284	265	199	221	199
	FEED	127	123	115	117	105	109	92	82	80	58	66	67
5	Vc	15	15	15	15	15	15	15	15	15	15	15	15
	fz	0.047	0.054	0.058	0.065	0.074	0.049	0.046	0.047	0.047	0.054	0.049	0.053
	RPM	398	341	298	265	239	217	191	171	159	149	133	119
	FEED	75	74	69	69	71	64	53	48	45	48	39	38
6	Vc	30	30	30	30	30	30	30	30	30	30	30	30
	fz	0.056	0.057	0.071	0.08	0.089	0.059	0.06	0.06	0.059	0.06	0.06	0.068
	RPM	796	682	597	531	477	434	382	341	318	298	265	239
	FEED	178	156	170	170	170	154	138	123	113	107	95	97
7	Vc	25	25	25	25	25	25	25	25	25	20	25	25
	fz	0.048	0.054	0.058	0.066	0.066	0.05	0.048	0.048	0.05	0.049	0.05	0.056
	RPM	663	568	497	442	398	362	318	284	265	199	221	199
	FEED	127	123	115	117	105	109	92	82	80	58	66	67
8-9	Vc	15	15	15	15	15	15	15	15	15	15	15	15
	fz	0.047	0.054	0.058	0.065	0.074	0.049	0.046	0.047	0.047	0.054	0.049	0.053
	RPM	398	341	298	265	239	217	191	171	159	149	133	119
	FEED	75	74	69	69	71	64	53	48	45	48	39	38
10	Vc	30	30	30	30	30	30	30	30	30	30	30	30
	fz	0.056	0.057	0.071	0.08	0.089	0.059	0.06	0.06	0.059	0.06	0.06	0.068
	RPM	796	682	597	531	477	434	382	341	318	298	265	239
	FEED	178	156	170	170	170	154	138	123	113	107	95	97
11.1	Vc	15	15	15	15	15	15	15	15	15	15	15	15
	fz	0.047	0.054	0.058	0.065	0.074	0.049	0.046	0.047	0.047	0.054	0.049	0.053
	RPM	398	341	298	265	239	217	191	171	159	149	133	119
	FEED	75	74	69	69	71	64	53	48	45	48	39	38
21 - 22	Vc	95	95	100	100	100	95	95	95	105	100	100	100
	fz	0.057	0.06	0.066	0.074	0.075	0.054	0.058	0.061	0.061	0.06	0.061	0.063
	RPM	2520	2160	1989	1768	1592	1375	1210	1080	1114	995	884	796
	FEED	575	518	525	523	477	445	421	395	408	358	324	301
23 - 24	Vc	62	62	65	65	65	62	62	62	68	65	65	65
	fz	0.057	0.06	0.066	0.074	0.075	0.054	0.058	0.061	0.061	0.06	0.061	0.063
	RPM	1645	1410	1293	1149	1035	897	789	705	722	647	575	517
	FEED	375	338	341	340	310	291	275	258	264	233	210	196



SELECTION GUIDE

YG MILLING TOOLS

HSS

GENERAL HSS END MILLS

General Purpose, Non-coated, Any Coating Available

◎ : Excellent ○ : Good

Recommended cutting conditions : P 738

Please visit globalyg1.com/mat for material search

SERIES	E2464	E2509	E2572	E2573	E2516	E2553	E2SET553
FLUTE	2	2	3	3	3	3	3
HELIX ANGLE	42°	42°	≒ 30°	≒ 30°	30°	30°	30°
	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE
SIZE MIN	D1.0	D2.0	D1.5	D1.0	D2.0	D1.0	D2.0
SIZE MAX	D32.0	D20.0	D32.0	D40.0	D40.0	D20.0	D10.0
PAGE	696	698	699	700	702	704	705
	SHORT LENGTH	LONG LENGTH	STUB LENGTH	SHORT LENGTH	LONG LENGTH	SHORT LENGTH THROW AWAY	THROW AWAY SET
	Uncoated	Uncoated	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated
	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8

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

E2554	E2551	E2552	E2574 E2575	E2595 E2596	E2576 E2577	E2597 E2598	E2776	E2461 E2462 E2463	E2761	E2606
3	3	3	4&6	4&6	4&6	4&6	Multi Flute	Multi Flute	Multi Flute	3&4
30°	30°	30°	≈ 30°	≈ 30°	30°	45°	30°	50°	30°	30°
SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE ROUGHING	BALL NOSE ROUGHING
D1.5	D1.0	D1.5	D2.0/D21.0	D2.0/D22.0	D2.0/D22.0	D2.0/D22.0	D14.0	D2.0/D6.0/D22.0	D6.0	R3.0
D10.0	D10.0	D10.0	D20.0 /D40.0	D25.0/D40.0	D20.0/D40.0	D20.0/D40.0	D50.0	D5.0/D23.0/D30.0	D25.0	R16.0
706	707	708	709	710, 711	712	713, 714	715	716	717	718
LONG LENGTH THROW AWAY	SHORT LENGTH THROW AWAY	LONG LENGTH THROW AWAY	SHORT LENGTH	SHORT LENGTH CENTER CUTTING	LONG LENGTH	LONG LENGTH CENTER CUTTING	SHORT LENGTH	SHORT LENGTH	SHORT LENGTH	SHORT LENGTH
Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN
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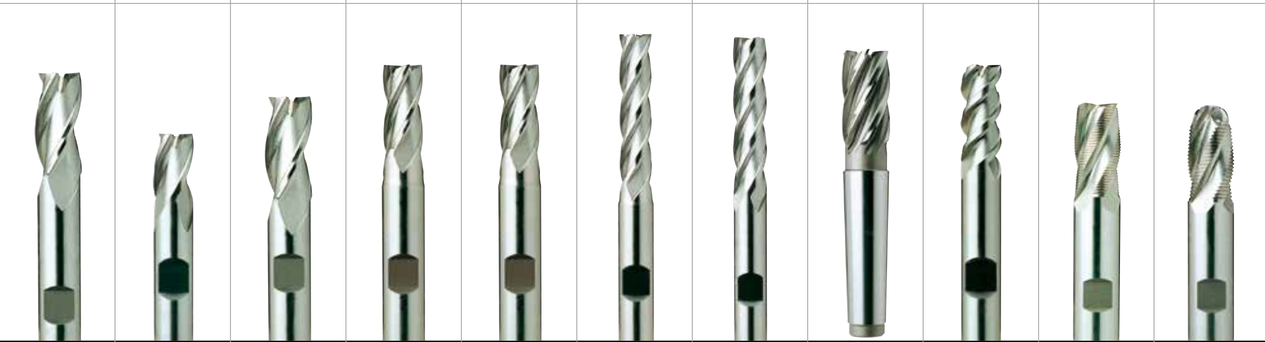

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