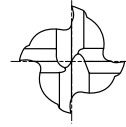


### HSSCo8, 4 FLUTE LONG LENGTH - CENTER CUTTING

- HSSCo8, 4&6 SCHNEIDEN LANG
- Fraise HSSCo8, 4&6 dents, coupe au centre, longue
- 4&6 TAGLIENTI, 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		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

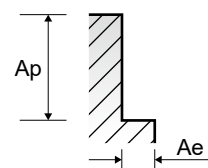
Vc = m/min.  
fz = mm/tooth  
RPM = rev./min.  
FEED = mm/min.

**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		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		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		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	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	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	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	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	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
					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

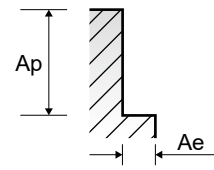


**E2574, E2575, E2576, E2577, E2597, E2598, E2776** SERIES

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

**MULTI FLUTE - SIDE CUTTING**

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
2	FEED	227	220	220	196	198	204	179	160	149	140	121	119
	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
3-4	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
	Vc	25	25	25	25	25	25	25	25	25	20	25	25
5	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
6	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
7	FEED	75	74	69	69	71	64	53	48	45	48	39	38
	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
8-9	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
	Vc	25	25	25	25	25	25	25	25	25	20	25	25
10	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
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
21-22	FEED	75	74	69	69	71	64	53	48	45	48	39	38
	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
23-24	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
	Vc	62	62	65	65	65	62	62	62	68	65	65	65
23-24	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**



**HSS**

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°
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

**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](http://globalyg1.com/mat) for material search



SHORT LENGTH	LONG LENGTH	STUB LENGTH	SHORT LENGTH	LONG LENGTH	SHORT LENGTH THROW AWAY	THROW AWAY SET
Uncoated	Uncoated	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated
HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8



ISO	VDI 3323	Material Description	HB	HRc	E2464	E2509	E2572	E2573	E2516	E2553	E2SET553	
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		130									
20	Malleable cast iron	230	21									
N	21	Aluminum-wrought alloy	60		◎	◎	○	○	○	○	○	
	22		100		◎	◎	○	○	○	○	○	
	23	Aluminum-cast, alloyed	75		◎	◎	○	○	○	○	○	
	24		90		◎	◎	○	○	○	○	○	
	25		130		○	○	○	○	○	○	○	
	26		110									
	27	Copper and Copper Alloys (Bronze / Brass)	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 / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN
HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8
										
⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙
⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙
⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙
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○	○	○	○	○	○	○	○	○	○	○

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