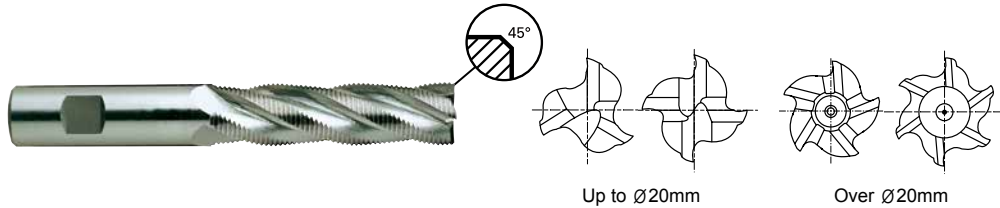


### HSSCo8, MULTI FLUTE LONG LENGTH ROUGHING - FINE

- HSSCo8, MULTI SCHNEIDEN LANG SCHRUPPFÄSER - FEIN
- Fraise HSSCo8, multi-dents ébauche, pas fin, longue
- MULTI TAGLIENTE, PER SGROSSATURA, SERIE LUNGA, BOMBATO FINE - HSSCo8



HSS Co8
DIN 844
HR
3-6
30°
DIN 1835B
~Ø20
Ø22~
C x 45°
P.764~767

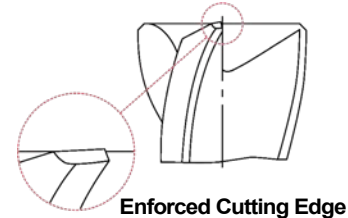
Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute	Chamfer
UNCOATED	TiAIN	js12	h6				
E2762060	EQ762060	6.0	6	24	68	3	0.18
E2762070	EQ762070	7.0	10	30	80	3	0.18
E2762080	EQ762080	8.0	10	38	88	3	0.18
E2762090	EQ762090	9.0	10	38	88	3	0.18
E2762100	EQ762100	10.0	10	45	95	4	0.18
E2762110	EQ762110	11.0	12	45	102	4	0.18
E2762120	EQ762120	12.0	12	53	110	4	0.18
E2762130	EQ762130	13.0	12	53	110	4	0.18
E2762140	EQ762140	14.0	12	53	110	4	0.25
E2762150	EQ762150	15.0	12	53	110	4	0.25
E2762160	EQ762160	16.0	16	63	123	4	0.25
E2762170	EQ762170	17.0	16	63	123	4	0.25
E2762180	EQ762180	18.0	16	63	123	4	0.25
E2762190	EQ762190	19.0	16	63	123	4	0.25
E2762200	EQ762200	20.0	20	75	141	4	0.25
E2762220	EQ762220	22.0	20	75	141	5	0.36
E2762240	EQ762240	24.0	25	90	166	5	0.36
E2762250	EQ762250	25.0	25	90	166	5	0.36
E2762260	EQ762260	26.0	25	90	166	6	0.36
E2762280	EQ762280	28.0	25	90	166	6	0.36
E2762300	EQ762300	30.0	25	90	166	6	0.36
E2762320	EQ762320	32.0	32	106	186	6	0.51
E2762350	EQ762350	35.0	32	106	186	6	0.51
E2762360	EQ762360	36.0	32	106	186	6	0.56
E2762380	EQ762380	38.0	32	125	217	6	0.56
E2762400	EQ762400	40.0	32	125	217	6	0.56
E2762940	EQ762940	40.0	40	125	217	6	0.56

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

#### Tolerances according to DIN 7160 & 7161

	Tolerance range in $\mu\text{m}$					
	Nominal-Diameter in mm					
	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



Enforced Cutting Edge

◎ : Excellent ○ : Good

ISO Material Description	P										M			K							
	Non-alloy steel					Low alloy 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	34	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	◎	◎	◎	◎	◎						◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

**E2761, E2753, E2762, E2751, E2764, E2752, E2765, E2778, E2777 SERIES**

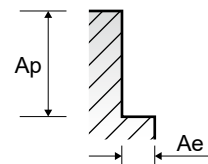
Vc = m/min.  
fz = mm/tooth  
RPM = rev./min.  
FEED = mm/min.

**MULTI FLUTE ROUGHING - SIDE CUTTING**

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)					
						6.0	8.0	10.0	12.0	14.0	16.0
P	1	Non-alloy steel	0.5D	1.5D	Vc	35	35	35	35	35	35
					fz	0.015	0.025	0.034	0.05	0.056	0.064
					RPM	1857	1393	1114	928	796	696
	2		0.5D	1.5D	Vc	30	30	30	30	30	30
					fz	0.013	0.023	0.033	0.044	0.05	0.063
					RPM	1592	1194	955	796	682	597
	3-4		0.5D	1.5D	Vc	25	25	25	25	25	25
					fz	0.015	0.024	0.034	0.044	0.049	0.061
					RPM	1326	995	796	663	568	497
	5		0.5D	1.5D	Vc	15	15	15	15	15	15
					fz	0.013	0.021	0.033	0.044	0.05	0.063
RPM		796			597	477	398	341	298		
6	0.5D	1.5D	Vc	30	30	30	30	30	30		
			fz	0.013	0.023	0.033	0.044	0.05	0.063		
			RPM	1592	1194	955	796	682	597		
7	0.5D	1.5D	Vc	25	25	25	25	25	25		
			fz	0.015	0.024	0.034	0.044	0.049	0.061		
			RPM	1326	995	796	663	568	497		
8-9	0.5D	1.5D	Vc	15	15	15	15	15	15		
			fz	0.013	0.021	0.033	0.044	0.05	0.063		
			RPM	796	597	477	398	341	298		
10	0.5D	1.5D	Vc	30	30	30	30	30	30		
			fz	0.013	0.023	0.033	0.044	0.05	0.063		
			RPM	1592	1194	955	796	682	597		
11.1	0.5D	1.5D	Vc	15	15	15	15	15	15		
			fz	0.013	0.021	0.033	0.044	0.05	0.063		
			RPM	796	597	477	398	341	298		
21-22	0.5D	1.5D	Vc	85	80	80	75	80	80		
			fz	0.015	0.025	0.035	0.05	0.058	0.07		
			RPM	4509	3183	2546	1989	1819	1592		
23-24	0.5D	1.5D	Vc	55	52	52	49	52	52		
			fz	0.015	0.025	0.035	0.05	0.058	0.07		
			RPM	2918	2069	1655	1300	1182	1035		
					FEED	131	155	232	260	274	290

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

▶ NEXT PAGE

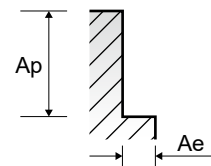


Vc = m/min.  
fz = mm/tooth  
RPM = rev./min.  
FEED = mm/min.

**E2761, E2753, E2762, E2751, E2764, E2752, E2765, E2778, E2777 SERIES**

**MULTI FLUTE ROUGHING - SIDE CUTTING**

VDI 3323	Parameter	Diameter (Ø)									
		18.0	20.0	22.0	25.0	28.0	30.0	32.0	36.0	40.0	50.0
1	Vc	35	35	35	35	35	35	35	35	35	35
	fz	0.071	0.08	0.088	0.098	0.088	0.1	0.1	0.113	0.119	0.152
	RPM	619	557	506	446	398	371	348	309	279	223
	FEED	176	178	223	218	210	223	209	210	199	203
2	Vc	30	30	30	30	30	30	30	30	30	30
	fz	0.07	0.078	0.076	0.085	0.076	0.086	0.095	0.107	0.114	0.157
	RPM	531	477	434	382	341	318	298	265	239	191
	FEED	149	149	165	162	156	164	170	170	163	180
3-4	Vc	25	25	25	25	25	25	20	25	25	25
	fz	0.069	0.069	0.08	0.09	0.077	0.087	0.098	0.108	0.111	0.146
	RPM	442	398	362	318	284	265	199	221	199	159
	FEED	122	110	145	143	131	138	117	143	132	139
5	Vc	15	15	15	15	15	15	15	15	15	15
	fz	0.07	0.08	0.077	0.094	0.089	0.089	0.101	0.118	0.121	0.148
	RPM	265	239	217	191	171	159	149	133	119	95
	FEED	74	76	84	90	91	85	90	94	87	85
6	Vc	30	30	30	30	30	30	30	30	30	30
	fz	0.07	0.078	0.076	0.085	0.076	0.086	0.095	0.107	0.114	0.157
	RPM	531	477	434	382	341	318	298	265	239	191
	FEED	149	149	165	162	156	164	170	170	163	180
7	Vc	25	25	25	25	25	25	20	25	25	25
	fz	0.069	0.069	0.08	0.09	0.077	0.087	0.098	0.108	0.111	0.146
	RPM	442	398	362	318	284	265	199	221	199	159
	FEED	122	110	145	143	131	138	117	143	132	139
8-9	Vc	15	15	15	15	15	15	15	15	15	15
	fz	0.07	0.08	0.077	0.094	0.089	0.089	0.101	0.118	0.121	0.148
	RPM	265	239	217	191	171	159	149	133	119	95
	FEED	74	76	84	90	91	85	90	94	87	85
10	Vc	30	30	30	30	30	30	30	30	30	30
	fz	0.07	0.078	0.076	0.085	0.076	0.086	0.095	0.107	0.114	0.157
	RPM	531	477	434	382	341	318	298	265	239	191
	FEED	149	149	165	162	156	164	170	170	163	180
11.1	Vc	15	15	15	15	15	15	15	15	15	15
	fz	0.07	0.08	0.077	0.094	0.089	0.089	0.101	0.118	0.121	0.148
	RPM	265	239	217	191	171	159	149	133	119	95
	FEED	74	76	84	90	91	85	90	94	87	85
21 - 22	Vc	80	75	75	80	80	85	80	80	80	80
	fz	0.084	0.104	0.085	0.09	0.094	0.098	0.104	0.112	0.119	0.123
	RPM	1415	1194	1085	1019	909	902	796	707	637	509
	FEED	475	497	461	458	513	530	497	475	455	376
23 - 24	Vc	52	49	49	52	52	55	52	52	52	52
	fz	0.084	0.104	0.085	0.09	0.094	0.098	0.104	0.112	0.119	0.123
	RPM	920	780	709	662	591	584	517	460	414	331
	FEED	309	324	301	298	333	343	323	309	295	244



**SELECTION GUIDE**



**MILLING TOOLS**

SERIES	E2524	E2753	E2762	E2757	E2764	E2765	E2755
FLUTE	3&4	Multi Flute	Multi Flute	3&4	3	3	3
HELIX ANGLE	30°	30°	30°	30°	30°	30°	37°
	SQUARE ROUGHING	SQUARE ROUGHING	SQUARE ROUGHING	BALL NOSE ROUGHING	SQUARE ROUGHING	SQUARE ROUGHING	SQUARE ROUGHING
SIZE MIN	D6.0	D6.0	D6.0	R4.0	D10.0	D10.0	D6.0
SIZE MAX	D20.0	D40.0	D40.0	R12.5	D40.0	D40.0	D30.0
PAGE	719	720	721	722	723	724	725

**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



STUB LENGTH	SHORT LENGTH	LONG LENGTH	SHORT LENGTH	SHORT LENGTH	LONG LENGTH	SHORT LENGTH
Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated / TiAlN	Uncoated
HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8	HSS Co8



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

ISO	VDI 3323	Material Description	HB	HRc	E2524	E2753	E2762	E2757	E2764	E2765	E2755	
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								
D-POWER GRAPHITE END MILLS	14	Grey cast iron	180	10								
	15		260	26								
D-POWER CFRP END MILLS	16	Nodular cast iron	180	10								
	17		260	26								
	18		160	3								
	19		250	25								
D-POWER CFRP END MILLS	20	Malleable cast iron	130									
	21		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								