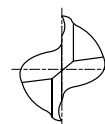


HSSCo8, 2 FLUTE EXTRA LONG LENGTH

● HSSCo8, 2 SCHNEIDEN EXTRA LANG

● Fraise HSSCo8, 2 dents, extra-longue

● 2 TAGLIENTI, SERIE EXTRA LUNGA - HSSCo8



P.746~749

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	TiAIN	e8	h6		
E2510025	EQ510025	2.5	6	8	56
E2510030	EQ510030	3.0	6	8	56
E2510035	EQ510035	3.5	6	10	59
E2510040	EQ510040	4.0	6	11	63
E2510045	EQ510045	4.5	6	11	63
E2510050	EQ510050	5.0	6	13	68
E2510055	EQ510055	5.5	6	13	68
E2510060	EQ510060	6.0	6	13	68
E2510065	EQ510065	6.5	10	16	80
E2510070	EQ510070	7.0	10	16	80
E2510080	EQ510080	8.0	10	19	88
E2510085	EQ510085	8.5	10	19	88
E2510090	EQ510090	9.0	10	19	88
E2510100	EQ510100	10.0	10	22	95
E2510120	EQ510120	12.0	12	26	110
E2510140	EQ510140	14.0	12	26	110
E2510160	EQ510160	16.0	16	32	123
E2510180	EQ510180	18.0	16	32	123
E2510200	EQ510200	20.0	20	38	141
E2510220	EQ510220	22.0	20	38	141
E2510240	EQ510240	24.0	25	45	166
E2510250	EQ510250	25.0	25	45	166
E2510260	EQ510260	26.0	25	45	166
E2510280	EQ510280	28.0	25	45	166
E2510300	EQ510300	30.0	25	45	166
E2510320	EQ510320	32.0	32	53	186
E2510360	EQ510360	36.0	32	53	186
E2510400	EQ510400	40.0	32	63	207
E2510940	EQ510940	40.0	40	63	217

Tolerances according to DIN 7160 & 7161

Tolerance range in μ 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
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

- ▶ Other shank design on your request.
- ▶ 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	○	○	○	○	○																



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

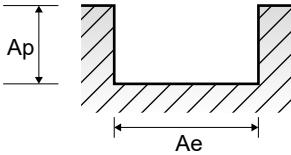
EQ570, EQ571, EQ510 SERIES 2 FLUTE TiAlN COATED - SLOTTING

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	12.0
P	1	Non-alloy steel	1.0D	0.5D	Vc	50	45	50	50	45	50	50	45
					fz	0.004	0.008	0.013	0.02	0.025	0.036	0.045	0.062
	RPM		7958	4775	3979	3183	2387	1989	1592	1194			
	FEED		64	76	103	127	119	143	143	148			
	2		1.0D	0.5D	Vc	40	40	40	40	40	40	40	40
					fz	0.003	0.007	0.012	0.02	0.024	0.04	0.05	0.064
	RPM		6366	4244	3183	2546	2122	1592	1273	1061			
	FEED		38	59	76	102	102	127	127	136			
	3-4	1.0D	0.5D	Vc	35	35	30	35	30	30	35	35	
				fz	0.004	0.008	0.013	0.019	0.025	0.04	0.05	0.061	
	RPM	5570	3714	2387	2228	1592	1194	1114	928				
	FEED	45	59	62	85	80	95	111	113				
	5	1.0D	0.5D	Vc	20	20	20	20	20	20	20	20	
				fz	0.003	0.007	0.013	0.02	0.025	0.041	0.05	0.064	
	RPM	3183	2122	1592	1273	1061	796	637	531				
	FEED	19	30	41	51	53	65	64	68				
6	1.0D	0.5D	Vc	40	40	40	40	40	40	40	40		
			fz	0.003	0.007	0.012	0.02	0.024	0.04	0.05	0.064		
			RPM	6366	4244	3183	2546	2122	1592	1273	1061		
			FEED	38	59	76	102	102	127	127	136		
7	1.0D	0.5D	Vc	35	35	30	35	30	30	35	35		
			fz	0.004	0.008	0.013	0.019	0.025	0.04	0.05	0.061		
			RPM	5570	3714	2387	2228	1592	1194	1114	928		
			FEED	45	59	62	85	80	95	111	113		
8-9	1.0D	0.5D	Vc	20	20	20	20	20	20	20	20		
			fz	0.003	0.007	0.013	0.02	0.025	0.041	0.05	0.064		
			RPM	3183	2122	1592	1273	1061	796	637	531		
			FEED	19	30	41	51	53	65	64	68		
10	1.0D	0.5D	Vc	40	40	40	40	40	40	40	40		
			fz	0.003	0.007	0.012	0.02	0.024	0.04	0.05	0.064		
			RPM	6366	4244	3183	2546	2122	1592	1273	1061		
			FEED	38	59	76	102	102	127	127	136		
11.1	1.0D	0.5D	Vc	20	20	20	20	20	20	20	20		
			fz	0.003	0.007	0.013	0.02	0.025	0.041	0.05	0.064		
			RPM	3183	2122	1592	1273	1061	796	637	531		
			FEED	19	30	41	51	53	65	64	68		
N	21-22	Aluminum-wrought alloy	1.0D	0.5D	Vc	105	145	140	140	150	140	135	130
					fz	0.007	0.011	0.018	0.025	0.028	0.049	0.064	0.076
	RPM	16711	15385	11141	8913	7958	5570	4297	3448				
	FEED	234	338	401	446	446	546	550	524				
23-24	Aluminum-cast, alloyed	1.0D	0.5D	Vc	68	94	91	91	98	91	88	85	
				fz	0.007	0.011	0.018	0.025	0.028	0.049	0.064	0.076	
				RPM	10823	9974	7242	5793	5199	3621	2801	2255	
				FEED	152	219	261	290	291	355	359	343	

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

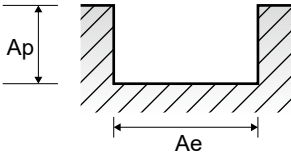
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E2464, E2509 SERIES 2 FLUTE - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)								
						3.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0
N	21-22	Aluminum-wrought alloy	1.0D	0.5D	Vc	75	130	150	155	190	155	175	130	145
					fz	0.035	0.05	0.071	0.12	0.12	0.177	0.177	0.283	0.283
					RPM	7958	6897	5968	4934	5040	3524	3482	2299	2308
					FEED	557	690	848	1184	1210	1248	1232	1301	1306
	23-24	Aluminum-cast, alloyed	1.0D	0.5D	Vc	49	85	98	101	124	101	114	85	94
					fz	0.035	0.05	0.071	0.12	0.12	0.177	0.177	0.283	0.283
					RPM	5199	4509	3899	3215	3289	2296	2268	1503	1496
					FEED	364	451	554	772	789	813	803	851	847

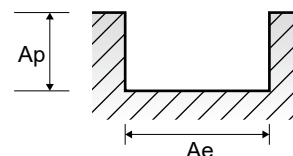
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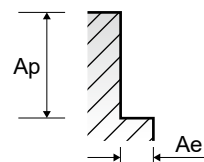
Vc = m/min.
 fz = mm/tooth
 RPM = rev./min.
 FEED = mm/min.

EQ570, EQ571, EQ510 SERIES
2 FLUTE TIALN COATED - SLOTTING

VDI 3323	Parameter	Diameter (Ø)										
		14.0	16.0	18.0	20.0	22.0	25.0	28.0	30.0	32.0	36.0	40.0
1	Vc	50	50	50	50	50	50	50	45	50	50	50
	fz	0.07	0.078	0.078	0.088	0.1	0.096	0.1	0.1	0.1	0.094	0.106
	RPM	1137	995	884	796	723	637	568	477	497	442	398
	FEED	159	155	138	140	145	122	114	95	99	83	84
2	Vc	45	40	40	40	45	45	45	40	40	40	40
	fz	0.063	0.078	0.089	0.096	0.096	0.1	0.1	0.094	0.094	0.1	0.117
	RPM	1023	796	707	637	651	573	512	424	398	354	318
	FEED	129	124	126	122	125	115	102	80	75	71	74
3-4	Vc	35	35	30	35	35	35	35	35	30	35	30
	fz	0.069	0.077	0.091	0.091	0.1	0.094	0.094	0.1	0.108	0.092	0.11
	RPM	796	696	531	557	506	446	398	371	298	309	239
	FEED	110	107	97	101	101	84	75	74	64	57	53
5	Vc	20	20	20	20	20	20	20	20	20	15	20
	fz	0.07	0.081	0.093	0.108	0.108	0.1	0.1	0.1	0.1	0.117	0.117
	RPM	455	398	354	318	289	255	227	212	199	133	159
	FEED	64	64	66	69	63	51	45	42	40	31	37
6	Vc	45	40	40	40	45	45	45	40	40	40	40
	fz	0.063	0.078	0.089	0.096	0.096	0.1	0.1	0.094	0.094	0.1	0.117
	RPM	1023	796	707	637	651	573	512	424	398	354	318
	FEED	129	124	126	122	125	115	102	80	75	71	74
7	Vc	35	35	30	35	35	35	35	35	30	35	30
	fz	0.069	0.077	0.091	0.091	0.1	0.094	0.094	0.1	0.108	0.092	0.11
	RPM	796	696	531	557	506	446	398	371	298	309	239
	FEED	110	107	97	101	101	84	75	74	64	57	53
8-9	Vc	20	20	20	20	20	20	20	20	20	15	20
	fz	0.07	0.081	0.093	0.108	0.108	0.1	0.1	0.1	0.1	0.117	0.117
	RPM	455	398	354	318	289	255	227	212	199	133	159
	FEED	64	64	66	69	63	51	45	42	40	31	37
10	Vc	45	40	40	40	45	45	45	40	40	40	40
	fz	0.063	0.078	0.089	0.096	0.096	0.1	0.1	0.094	0.094	0.1	0.117
	RPM	1023	796	707	637	651	573	512	424	398	354	318
	FEED	129	124	126	122	125	115	102	80	75	71	74
11.1	Vc	20	20	20	20	20	20	20	20	20	15	20
	fz	0.07	0.081	0.093	0.108	0.108	0.1	0.1	0.1	0.1	0.117	0.117
	RPM	455	398	354	318	289	255	227	212	199	133	159
	FEED	64	64	66	69	63	51	45	42	40	31	37
21 - 22	Vc	135	140	140	140	135	135	135	145	140	140	140
	fz	0.079	0.088	0.098	0.1	0.108	0.115	0.123	0.123	0.12	0.124	0.127
	RPM	3069	2785	2476	2228	1953	1719	1535	1538	1393	1238	1114
	FEED	485	490	485	446	422	395	378	378	334	307	283
23 - 24	Vc	88	91	91	91	88	88	88	94	91	91	91
	fz	0.079	0.088	0.098	0.1	0.108	0.115	0.123	0.123	0.12	0.124	0.127
	RPM	2001	1810	1609	1448	1273	1120	1000	997	905	805	724
	FEED	316	319	315	290	275	258	246	245	217	200	184


E2464, E2509 SERIES
2 FLUTE - SITE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)								
						3.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0
N	21-22	Aluminum-wrought alloy	Ø3~Ø10=0.25D Ø12~Ø20=0.5D	1.0D	Vc	75	130	150	155	190	155	175	130	145
					fz	0.046	0.064	0.092	0.15	0.15	0.229	0.229	0.37	0.37
					RPM	7958	6897	5968	4934	5040	3524	3482	2299	2308
					FEED	732	883	1098	1480	1512	1614	1595	1701	1708
	23-24	Aluminum-cast, alloyed	Ø3~Ø10=0.25D Ø12~Ø20=0.5D	1.0D	Vc	49	85	98	101	124	101	114	85	94
					fz	0.046	0.064	0.092	0.15	0.15	0.229	0.229	0.37	0.37
					RPM	5199	4509	3899	3215	3289	2296	2268	1503	1496
					FFFD	478	577	717	964	987	1052	1039	1112	1107



SELECTION GUIDE



MILLING TOOLS

HSS

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

SERIES	E9410	E9720	E3570	E3574
FLUTE	2	Muti Flute	2	4
HELIX ANGLE	≈ 30°	30°	≈ 30°	≈ 30°
CUTTING EDGE SHAPE	SQUARE	SQUARE	SQUARE	SQUARE
SIZE MIN	D3.0	D6.0	D2.5	D2.0
SIZE MAX	D25.0	D30.0	D18.0	D18.0
PAGE	678	679	680	681

HSS
GENERAL HSS
END MILLS

General Purpose, Non-coated, Any Coating Available



Please visit
globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : P 738

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc				
P	1	Non-alloy steel	About 0.15% C	Annealed	125		◎	◎	◎	◎
	2		About 0.45% C	Annealed	190	13	◎	◎	◎	◎
	3		About 0.45% C	Quenched & Tempered	250	25	◎	◎	◎	◎
	4		About 0.75% C	Annealed	270	28	◎	◎	◎	◎
	5		About 0.75% C	Quenched & Tempered	300	32	○	○	○	○
	6	Low alloy steel		Annealed	180	10	◎	◎	◎	◎
	7			Quenched & Tempered	275	29	◎	◎	◎	◎
	8			Quenched & Tempered	300	32	○	○	○	○
	9			Quenched & Tempered	350	38	○	○	○	○
	10	High alloyed steel, and tool steel		Annealed	200	15	◎	◎	◎	◎
	11			Quenched & Tempered	325	35	○	○	○	○
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15				
	13		Martensitic	Quenched & Tempered	240	23				
	14		Austenitic		180	10				
K	15	Grey cast iron	Pearlitic / ferritic		180	10				
	16		Pearlitic (Martensitic)		260	26				
	17	Nodular cast iron	Ferritic		160	3				
	18		Pearlitic		250	25				
	19	Malleable cast iron	Ferritic		130					
	20		Pearlitic		230	21				
N	21	Aluminum-wrought alloy	Not Curable		60		○	○	○	○
	22		Curable Hardened		100		○	○	○	○
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		○	○	○	○
	24		≤ 12% Si, Curable Hardened		90		○	○	○	○
	25		> 12% Si, Not Curable		130		○	○	○	○
	26		Copper and Copper Alloys, PB>1%		110					
	27	Copper and Copper Alloys (Bronze / Brass)	CuZn, CuSnZn (Brass)		90					
	28		CuSn, lead-free copper and electrolytic copper		100					
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic							
	30		Rubber, Wood, etc.							
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15				
	32			Cured	280	30				
	33		Ni or Co Based	Annealed	250	25				
	34			Cured	350	38				
	35			Cast	320	34				
	36	Titanium Alloys	Pure Titanium		400 Rm					
	37		Alpha + Beta Alloys	Hardened	1050 Rm					
H	38	Hardened steel			550	55				
	39				630	60				
	40	Chilled Cast Iron	Cast		400	42				
	41	Hardened Cast Iron	Hardened		550	55				



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