



FLAT SHANK

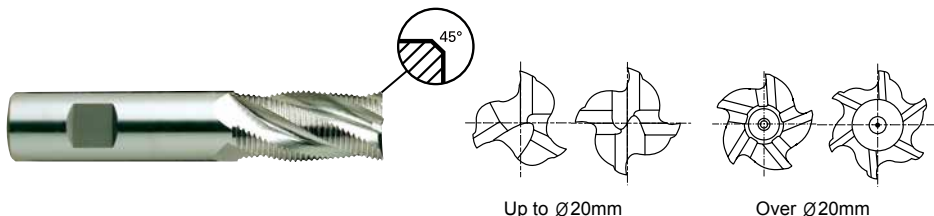
E2753 SERIES

FLAT SHANK

EQ753 SERIES

HSSCo8, MULTI FLUTE SHORT LENGTH ROUGHING - FINE

- HSSCo8, MULTI SCHNEIDEN KURZ SCHRUPPFRÄSER - FEIN
- Fraise HSSCo8, multi-dents ébauche, pas fin, courte
- MULTI TAGLIENTE, PER SGROSSATURA, SERIE CORTA, BOMBATO FINE - HSSCo8



HSS Co8
DIN 844
HR
3-6
30°
DIN 1835B
~Ø20
Ø25~
C x 45°
P.764~767

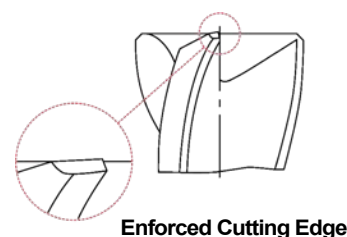
Unit : mm

	EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute	Chamfer
	UNCOATED	TiAIN	js12	h6				
	E2753060	EQ753060	6.0	6	13	57	3	0.18
	E2753070	EQ753070	7.0	10	16	66	3	0.18
	E2753080	EQ753080	8.0	10	19	69	3	0.18
	E2753090	EQ753090	9.0	10	19	69	3	0.18
	E2753100	EQ753100	10.0	10	22	72	4	0.18
	E2753110	EQ753110	11.0	12	22	79	4	0.18
	E2753120	EQ753120	12.0	12	26	83	4	0.18
	E2753130	EQ753130	13.0	12	26	83	4	0.18
	E2753140	EQ753140	14.0	12	26	83	4	0.25
	E2753150	EQ753150	15.0	12	26	83	4	0.25
	E2753160	EQ753160	16.0	16	32	92	4	0.25
	E2753180	EQ753180	18.0	16	32	92	4	0.25
	E2753200	EQ753200	20.0	20	38	104	4	0.25
	E2753250	EQ753250	25.0	25	45	121	5	0.36
	E2753280	EQ753280	28.0	25	45	121	6	0.36
	E2753300	EQ753300	30.0	25	45	121	6	0.36
	E2753320	EQ753320	32.0	32	53	133	6	0.51
	E2753350	EQ753350	35.0	32	53	133	6	0.51
	E2753400	EQ753400	40.0	32	63	155	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 μm					
	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



◎ : 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	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	◎	◎	◎	◎	◎																

EQ761, EQ753, EQ762, EQ751 EQ764, EQ752 EQ765, EQ778, EQ777 SERIES

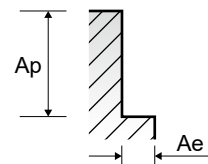
Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

MULTI FLUTE ROUGHING TiAIN COATED - 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	45	50	50	45	50	50
					fz	0.015	0.025	0.034	0.05	0.057	0.063
					RPM	2387	1989	1592	1194	1137	995
	2		0.5D	1.5D	Vc	40	40	40	40	45	40
					fz	0.013	0.023	0.034	0.044	0.049	0.061
					RPM	2122	1592	1273	1061	1023	796
	3-4		0.5D	1.5D	Vc	30	30	35	35	35	35
					fz	0.015	0.024	0.035	0.043	0.048	0.06
					RPM	1592	1194	1114	928	796	696
	5		0.5D	1.5D	Vc	20	20	20	20	20	20
					fz	0.012	0.021	0.033	0.045	0.05	0.063
RPM		1061			796	637	531	455	398		
6	0.5D	1.5D	Vc	40	40	40	40	45	40		
			fz	0.013	0.023	0.034	0.044	0.049	0.061		
			RPM	2122	1592	1273	1061	1023	796		
7	0.5D	1.5D	Vc	30	30	35	35	35	35		
			fz	0.015	0.024	0.035	0.043	0.048	0.06		
			RPM	1592	1194	1114	928	796	696		
8-9	0.5D	1.5D	Vc	20	20	20	20	20	20		
			fz	0.012	0.021	0.033	0.045	0.05	0.063		
			RPM	1061	796	637	531	455	398		
10	0.5D	1.5D	Vc	40	40	40	40	45	40		
			fz	0.013	0.023	0.034	0.044	0.049	0.061		
			RPM	2122	1592	1273	1061	1023	796		
11.1	0.5D	1.5D	Vc	20	20	20	20	20	20		
			fz	0.012	0.021	0.033	0.045	0.05	0.063		
			RPM	1061	796	637	531	455	398		
N	21-22	Aluminum-wrought alloy	0.5D	1.5D	Vc	120	110	110	105	110	115
					fz	0.015	0.025	0.035	0.05	0.059	0.07
					RPM	6366	4377	3501	2785	2501	2288
					FEED	286	328	490	557	590	641
N	23-24	Aluminum-cast, alloyed	0.5D	1.5D	Vc	78	72	72	68	72	75
					fz	0.015	0.025	0.035	0.05	0.059	0.07
					RPM	4138	2865	2292	1804	1637	1492
					FEED	186	215	321	361	386	418

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

▶ NEXT PAGE

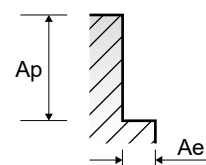


EQ761, EQ753, EQ762, EQ751 EQ764, EQ752 EQ765, EQ778, EQ777 SERIES

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

MULTI FLUTE ROUGHING TiAIN COATED - 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	50	50	50	50	50	45	50	50	50	45
	fz	0.069	0.078	0.089	0.095	0.089	0.098	0.098	0.109	0.117	0.156
	RPM	884	796	723	637	568	477	497	442	398	286
	FEED	244	248	322	302	304	281	292	289	279	268
2	Vc	40	40	45	45	45	40	40	40	40	40
	fz	0.07	0.075	0.074	0.087	0.075	0.083	0.094	0.107	0.117	0.16
	RPM	707	637	651	573	512	424	398	354	318	255
	FEED	198	191	241	249	230	211	224	227	223	244
3-4	Vc	30	35	35	35	35	35	30	35	30	35
	fz	0.07	0.07	0.078	0.087	0.075	0.086	0.1	0.1	0.113	0.148
	RPM	531	557	506	446	398	371	298	309	239	223
	FEED	149	156	197	194	179	192	179	186	162	198
5	Vc	20	20	20	20	20	20	20	20	15	20
	fz	0.071	0.083	0.08	0.096	0.091	0.091	0.1	0.118	0.141	0.153
	RPM	354	318	289	255	227	212	199	177	119	127
	FEED	100	106	116	122	124	116	119	125	101	117
6	Vc	40	40	45	45	45	40	40	40	40	40
	fz	0.07	0.075	0.074	0.087	0.075	0.083	0.094	0.107	0.117	0.16
	RPM	707	637	651	573	512	424	398	354	318	255
	FEED	198	191	241	249	230	211	224	227	223	244
7	Vc	30	35	35	35	35	35	30	35	30	35
	fz	0.07	0.07	0.078	0.087	0.075	0.086	0.1	0.1	0.113	0.148
	RPM	531	557	506	446	398	371	298	309	239	223
	FEED	149	156	197	194	179	192	179	186	162	198
8-9	Vc	20	20	20	20	20	20	20	20	15	20
	fz	0.071	0.083	0.08	0.096	0.091	0.091	0.1	0.118	0.141	0.153
	RPM	354	318	289	255	227	212	199	177	119	127
	FEED	100	106	116	122	124	116	119	125	101	117
10	Vc	40	40	45	45	45	40	40	40	40	40
	fz	0.07	0.075	0.074	0.087	0.075	0.083	0.094	0.107	0.117	0.16
	RPM	707	637	651	573	512	424	398	354	318	255
	FEED	198	191	241	249	230	211	224	227	223	244
11.1	Vc	20	20	20	20	20	20	20	20	15	20
	fz	0.071	0.083	0.08	0.096	0.091	0.091	0.1	0.118	0.141	0.153
	RPM	354	318	289	255	227	212	199	177	119	127
	FEED	100	106	116	122	124	116	119	125	101	117
21 - 22	Vc	110	105	105	110	110	120	110	115	115	110
	fz	0.085	0.103	0.085	0.09	0.095	0.099	0.106	0.11	0.117	0.124
	RPM	1945	1671	1519	1401	1251	1273	1094	1017	915	700
	FEED	661	689	646	630	713	756	696	671	642	521
23 - 24	Vc	72	68	68	72	72	78	72	75	75	72
	fz	0.085	0.103	0.085	0.09	0.095	0.099	0.106	0.11	0.117	0.124
	RPM	1273	1082	984	917	819	828	716	663	597	458
	FEED	433	446	418	413	467	492	456	438	419	341



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
for material search



ISO	VDI 3323	Material Description	HB	HRc	STUB LENGTH	SHORT LENGTH	LONG LENGTH	SHORT LENGTH	SHORT LENGTH	LONG LENGTH	SHORT LENGTH	
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								
K	14	Grey cast iron	180	10								
	15		260	26								
	16		Nodular cast iron	160	3							
	17			250	25							
K	18	Malleable cast iron	130									
	19		230	21								
	20											
N	21	Aluminum- wrought alloy	60		○	○	○	○	○	○	◎	
	22		100		○	○	○	○	○	○	◎	
	23		75		○	○	○	○	○	○	◎	
	N	24	Aluminum-cast, alloyed	90		○	○	○	○	○	○	◎
		25		130		○	○	○	○	○	○	○
		26		110								
	N	27	Copper and Copper Alloys (Bronze / Brass)	90								
		28		100								
		29										
S	30	Non Metallic Materials										
	31		Heat Resistant Super Alloys	200	15							
	32			280	30							
	33			250	25							
	34			350	38							
35	320	34										
S	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							