

## CARBIDE, 2&4 FLUTE LONG LENGTH

► Suitable for cutting hardened & high alloy steels, steel casting, chill casting, malleable cast iron, CrNi-steels, brass, copper, aluminum with a high percentage of silicon and abrasive plastics.



### E5011(2 FLUTE) Series

Unit : Inch

EDP No.					Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	TIN COATED	TiCN COATED	YG:TYLON F	YG:TYLON E				
02558	02558TN	02558TC	02558TF	02558TE	1/8	1/8	3/4	2-1/4
02565	02565TN	02565TC	02565TF	02565TE	3/16	3/16	3/4	2-1/2
02573	02573TN	02573TC	02573TF	02573TE	1/4	1/4	1-1/8	3
02579	02579TN	02579TC	02579TF	02579TE	5/16	5/16	1-1/8	3
02584	02584TN	02584TC	02584TF	02584TE	3/8	3/8	1-1/8	3
02588	02588TN	02588TC	02588TF	02588TE	7/16	7/16	2	4
02593	02593TN	02593TC	02593TF	02593TE	1/2	1/2	2	4
02595	02595TN	02595TC	02595TF	02595TE	5/8	5/8	2-1/4	5
02598	02598TN	02598TC	02598TF	02598TE	3/4	3/4	2-1/4	5
02600	02600TN	02600TC	02600TF	02600TE	1	1	2-1/4	5

### E5012(4 FLUTE) Series

Unit : Inch

EDP No.					Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	TIN COATED	TiCN COATED	YG:TYLON F	YG:TYLON E				
08558	08558TN	08558TC	08558TF	08558TE	1/8	1/8	3/4	2-1/4
08565	08565TN	08565TC	08565TF	08565TE	3/16	3/16	3/4	2-1/2
08573	08573TN	08573TC	08573TF	08573TE	1/4	1/4	1-1/8	3
08579	08579TN	08579TC	08579TF	08579TE	5/16	5/16	1-1/8	3
08584	08584TN	08584TC	08584TF	08584TE	3/8	3/8	1-1/8	3
08588	08588TN	08588TC	08588TF	08588TE	7/16	7/16	2	4
08593	08593TN	08593TC	08593TF	08593TE	1/2	1/2	2	4
08595	08595TN	08595TC	08595TF	08595TE	5/8	5/8	2-1/4	5
08598	08598TN	08598TC	08598TF	08598TE	3/4	3/4	2-1/4	5
08600	08600TN	08600TC	08600TF	08600TE	1	1	2-1/4	5

Mill Dia. Tolerance (inch)	Shank Dia. Tolerance
0~-.0012	0~-.0005

◎ : Excellent ○ : Good

P				H	M	K	N				S		
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Stainless Steels	Cast Iron	Copper	Graphite	Aluminum	Acrylic	CFRP	Titanium	High Temperature Alloy
~HRc20	HRc20~30	HRc30~40	HRc40~45 HRc45~55	HRc55~70									
◎	◎	◎			○	○	○		○				

## CARBIDE, 2 FLUTE - SLOTTING

 CBN  
END MILLS

 i-XmII  
END MILLS

 i-SMART  
MODULAR  
TYPE END MILLS

 X5070  
END MILLS

 4G MILL  
END MILLS

 X-POWER  
END MILLS

 JET-POWER  
END MILLS

 TiAlN  
-POWER  
END MILLS

 V7 PLUS A  
END MILLS

 V7 MILL INOX  
END MILLS

 ALU-POWER  
END MILLS

 D-POWER  
GRAPHITE  
END MILLS

 D-POWER  
CFRP  
END MILLS

ROUTERS

 STANDARD  
CARBIDE  
END MILLS

 ONLY ONE  
COATED PWBC  
END MILLS

 SINE-POWER  
END MILLS

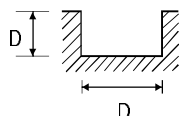
 TANK-POWER  
END MILLS

 STANDARD  
COBALT & HSS  
END MILLS

 TECHNICAL  
DATA

### E5020, E5244, E5011, E5026, E5022, E5025 SERIES

MATERIAL	P						M		K		N			
	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		STAINLESS STEELS TITANIUM ALLOYS		CAST IRON		ALUMINUM ALLOYS		COPPER, BRASS NON-FERROUS METALS	
HARDNESS	~ HRc 20		HRc 20 ~ HRc 30		HRc 30 ~ HRc 40									
STRENGTH	500 ~ 800N/mm <sup>2</sup>		800 ~ 1000N/mm <sup>2</sup>		1000 ~ 1300N/mm <sup>2</sup>									
DIAMETER	RPM	FEED	RPM	FEED	FEED	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3/32	5500	3.2	4800	2.8	4000	2.2	8000	2.6	6500	5.9	16000	12.6	12000	9.5
1/8	3700	3.5	3200	3.2	2600	2.4	5300	2.6	4200	5.9	11000	12.6	8000	9.5
5/32	2800	3.5	2400	3.2	2000	2.4	4000	2.6	3200	5.9	8000	12.6	6000	9.5
3/16	2200	3.5	1900	3.2	1600	2.4	3200	2.6	2500	5.9	6400	12.6	4800	9.5
1/4	1800	3.5	1600	3.2	1300	2.4	2600	2.6	2100	7.1	5300	13.4	4000	10.2
5/16	1400	3.5	1200	3.2	1000	2.4	2000	2.6	1600	7.5	4000	13.4	3000	10.2
3/8	1100	3.5	950	3.2	800	2.4	1600	2.6	1300	7.9	3200	13.4	2400	10.2
1/2	900	3.5	800	3.2	660	2.4	1300	2.6	1000	8.3	2600	13.4	2000	10.2
9/16	800	3.5	700	3.2	570	2.4	1100	2.6	900	8.7	2300	13.4	1700	10.2
5/8	700	3.9	600	3.4	500	3.0	1000	3.0	800	8.9	2000	13.4	1500	10.2
13/16	550	3.9	480	3.4	400	3.0	800	3.2	640	9.5	1600	13.4	1200	10.2



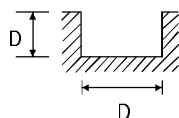
※ The Feed, in long &amp; extra long types, should be reduced by around 50%.

RPM = rev./min. FEED = inch/min.

## CARBIDE, 2 FLUTE TiAlN "F" COATED - SLOTTING

### EH020, EH244, EH011, EH026, EH022, EH025 SERIES

MATERIAL	P						M		K		N			
	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		STAINLESS STEELS TITANIUM ALLOYS		CAST IRON		ALUMINUM ALLOYS		COPPER, BRASS NON-FERROUS METALS	
HARDNESS	~ HRc 20		HRc 20 ~ HRc 30		HRc 30 ~ HRc 40									
STRENGTH	500 ~ 800N/mm <sup>2</sup>		800 ~ 1000N/mm <sup>2</sup>		1000 ~ 1300N/mm <sup>2</sup>									
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3/32	8640	4.7	7440	4.3	6240	3.3	12000	4.0	10200	9.4	24000	19.9	18000	14.6
1/8	5760	5.7	5040	5.0	4080	3.8	8280	4.0	6600	9.4	16800	19.9	12000	14.6
5/32	4370	5.7	3720	5.0	3120	3.8	6240	4.0	5040	9.4	12000	19.9	9600	14.6
3/16	3430	5.7	3000	5.0	2400	3.8	5040	4.0	3960	9.4	9960	19.9	7440	14.6
1/4	2880	5.7	2400	5.0	2040	3.8	4080	4.0	3240	10.9	8280	20.8	6240	16.1
5/16	2160	5.7	1800	5.0	1560	3.8	3120	4.0	2400	11.8	6240	20.8	4800	16.1
3/8	1680	5.7	1440	5.0	1200	3.8	2400	4.0	2040	12.3	5040	20.8	3720	16.1
1/2	1440	5.7	1200	5.0	1030	3.8	2040	4.0	1560	12.8	4080	20.8	3120	16.1
9/16	1200	5.7	1080	5.0	890	3.8	1680	4.0	1440	13.2	3600	20.8	2640	16.1
5/8	1080	6.1	960	5.2	780	4.7	1560	4.8	1200	13.7	3120	20.8	2400	16.1
13/16	880	6.1	740	5.2	620	4.7	1200	4.8	1000	14.6	2400	20.8	1870	16.1



※ The Feed, in long &amp; extra long types, should be reduced by around 50%.

RPM = rev./min. FEED = inch/min.