

CARBIDE, 2 FLUTE 42° HELIX REGULAR LENGTH - "BANSHEE"

- ▶ High velocity milling of aluminum & other non ferrous materials.
- ▶ Excellent plunging capabilities.
- ▶ Improved surface roughness-cylindrical margin which is controlled tightly.
- ▶ Maximum-metal removal rate.
- ▶ Superior chip evacuation.
- ▶ Mirror face-excellent surface finish.



MG
2
42°
PLAIN
P.722

◆ U.S.A Stock

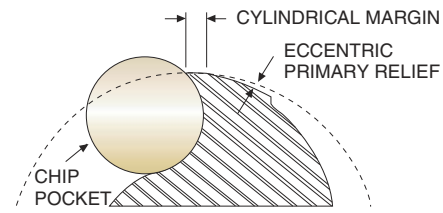
Unit : Inch

EDP No.					Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	TiN COATED	TiCN COATED	YG:TYLON F	YG:TYLON E				
21554	21554TN	21554TC	21554TF	21554TE	1/16	1/8	1/8	1-1/2
21556	21556TN	21556TC	21556TF	21556TE	3/32	1/8	1/4	1-1/2
21601	21601TN	21601TC	21601TF	21601TE	1/8	1/4	5/16	1-3/4
21566	21566TN	21566TC	21566TF	21566TE	3/16	1/4	7/16	2
21574	21574TN	21574TC	21574TF	21574TE	1/4	3/8	3/4	2-1/2
21580	21580TN	21580TC	21580TF	21580TE	5/16	3/8	13/16	2-1/2
21584	21584TN	21584TC	21584TF	21584TE	3/8	3/8	1	2-1/2
21588	21588TN	21588TC	21588TF	21588TE	7/16	7/16	1	2-3/4
21593	21593TN	21593TC	21593TF	21593TE	1/2	1/2	1	3
21904	21904TN	21904TC	21904TF	21904TE	1/2	1/2	1-1/4	3
21901	21901TN	21901TC	21901TF	21901TE	1/2	1/2	2	4
21595	21595TN	21595TC	21595TF	21595TE	5/8	5/8	1-1/4	3-1/2
21598	21598TN	21598TC	21598TF	21598TE	3/4	3/4	1-1/2	4
21902	21902TN	21902TC	21902TF	21902TE	3/4	3/4	3	5-1/2
21600	21600TN	21600TC	21600TF	21600TE	1	1	1-1/2	4
21903	21903TN	21903TC	21903TF	21903TE	1	1	3	5-1/2

Mill Dia. Tolerance (inch)	Shank Dia. Tolerance
0~- .0012	0~- .0003



- High performance in machining aluminum and non-ferrous materials
- Special designed geometry with high rigidity cutting edge
- Improved surface roughness - cylindrical margin which is controlled tightly.
- Excellent chip removal - higher rake angle, higher helix angle(42°), bigger chip pocket.



◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HRc20	HRc20~30	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
									◎			

CBN END MILL

i-Xmill END MILL

X5070 END MILLS

4G MILLS END MILLS

X-SPEED ROUGHER END MILLS

X-POWER END MILLS

JET-POWER END MILLS

V7 Mill STEEL END MILLS

V7 Mill INOX END MILLS

ALU-POWER END MILLS

D-POWER END MILLS

STANDARD CARBIDE END MILLS

TANK-POWER END MILLS

STANDARD COBALT & HSS END MILLS

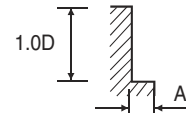
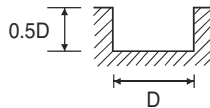
TECHNICAL DATA



CARBIDE, 2 FLUTE 42° HELIX - "BANSHEE"

E5253, E5254 SERIES

MATERIAL	ALUMINUM NONFERROUS METALS		ALUMINUM NONFERROUS METALS		
	DIAMETER	RPM	FEED	RPM	FEED
1/8	10000	27.6	10000	35.4	
5/32	10000	35.4	10000	43.3	
3/16	10000	39.4	10000	51.2	
1/4	10000	47.2	10000	59.1	
5/16	8000	55.1	8000	70.9	
3/8	8000	66.9	8000	82.7	
1/2	8000	82.7	8000	102.4	
9/16	6000	70.9	6000	86.6	
5/8	6000	74.8	6000	94.5	
11/16	4000	55.1	4000	70.9	
13/16	4000	63.0	4000	74.8	



A : $\varnothing 1/8 \sim \varnothing 3/8 = 0.25 \times D$
 $\varnothing 1/2 \sim \varnothing 13/16 = 0.5 \times D$

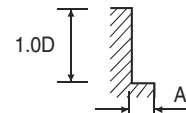
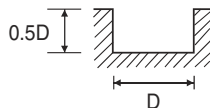
※ The Feed, in long & extra long types, should be reduced by around 50%.

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

CARBIDE, 2 FLUTE 42° HELIX TiCN COATED - "BANSHEE"

EG253, EG254 SERIES

MATERIAL	ALUMINUM NONFERROUS METALS		ALUMINUM NONFERROUS METALS		
	DIAMETER	RPM	FEED	RPM	FEED
1/8	15600	42.5	12000	56.7	
5/32	15600	56.7	12000	66.1	
3/16	15600	61.4	12000	80.3	
1/4	15600	70.9	12000	94.5	
5/16	12000	85.1	9600	108.7	
3/8	12000	103.9	9600	127.6	
1/2	12000	127.6	9600	160.6	
9/16	9600	108.7	7200	132.2	
5/8	9600	118.1	7200	146.5	
11/16	6000	85.0	4800	108.7	
13/16	6000	94.5	4800	118.1	



A : $\varnothing 1/8 \sim \varnothing 3/8 = 0.25 \times D$
 $\varnothing 1/2 \sim \varnothing 13/16 = 0.5 \times D$

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

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