



**ALU-POWER  
END MILLS**

**E5981** SERIES

PLAIN SHANK

**E5983** SERIES

PLAIN SHANK

**CARBIDE, 3 FLUTE 45° HELIX REGULAR LENGTH & CORNER RADIUS**

- ▶ High velocity milling of aluminum & other non-ferrous materials.
- ▶ 3flute and 45° helix allow harmonic balance at high speed condition and smooth cutting.
- ▶ Improved surface roughness-cylindrical margin which is controlled tightly
- ▶ Maximum-metal removal rate.
- ▶ Superior chip evacuation.
- ▶ Mirror face-excellent surface finish.



MG 3 45° PLAIN P.723

◆ U.S.A Stock

■ SQUARE

Unit : Inch

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	TiCN COATED				
28558	28558TC	1/8	1/8	3/8	1-1/2
28565	28565TC	3/16	3/16	9/16	2
28573	28573TC	1/4	1/4	5/8	2-1/2
28579	28579TC	5/16	5/16	5/8	2-1/2
28584	28584TC	3/8	3/8	1	2-1/2
28588	28588TC	7/16	7/16	1-1/4	2-3/4
28593	28593TC	1/2	1/2	1-1/4	3
28595	28595TC	5/8	5/8	1-5/8	3-1/2
28598	28598TC	3/4	3/4	1-5/8	4
28600	28600TC	1	1	2	5

■ CORNER RADIUS

Unit : Inch

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	TiCN COATED	R				
EA50321	EA50321C	R.060	1/2	1/2	1-1/4	3
EA50401	EA50401C	R.060	5/8	5/8	1-5/8	3-1/2
EA50481	EA50481C	R.060	3/4	3/4	1-5/8	4
EA50641	EA50641C	R.065	1	1	2	5
EA20321	EA20321C	R.120	1/2	1/2	1-1/4	3
EA20401	EA20401C	R.120	5/8	5/8	1-5/8	3-1/2
EA20481	EA20481C	R.120	3/4	3/4	1-5/8	4
EA20641	EA20641C	R.120	1	1	2	5

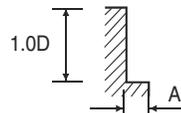
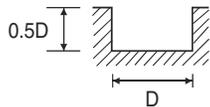
Mill Dia. Tolerance (inch)	Shank Dia. Tolerance
0~-.0005	0~-.0003

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				◎			

◎ : Excellent ○ : Good

**CARBIDE, 3 FLUTE 45° HELIX FINISH**
**E5980, E5981, E5982, E5983, E5984 SERIES**

MATERIAL	ALUMINUM NONFERROUS METALS		ALUMINUM NONFERROUS METALS	
	DIAMETER	RPM	FEED	RPM
1/8	10000	33.1	10000	42.5
5/32	10000	42.5	10000	52.0
3/16	10000	47.3	10000	61.4
1/4	10000	56.7	10000	70.9
5/16	8000	66.2	8000	85.1
3/8	8000	80.3	8000	99.2
1/2	8000	99.2	8000	122.9
9/16	6000	85.1	6000	104.0
5/8	6000	89.8	6000	113.4
11/16	4000	66.2	4000	85.1
13/16	4000	75.6	4000	89.8



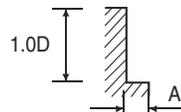
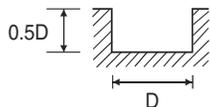
A :  $\varnothing 1/8 \sim \varnothing 3/8 = 0.25 \times D$   
 $\varnothing 1/2 \sim \varnothing 13/16 = 0.5 \times D$

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

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

**CARBIDE, 3 FLUTE 45° HELIX FINISH TiCN COATED**
**EG980, EG981, EG982, EG983, EG984 SERIES**

MATERIAL	ALUMINUM NONFERROUS METALS		ALUMINUM NONFERROUS METALS	
	DIAMETER	RPM	FEED	RPM
1/8	15600	43.0	12000	55.3
5/32	15600	55.3	12000	67.6
3/16	15600	61.4	12000	79.8
1/4	15600	73.7	12000	92.2
5/16	12000	86.0	9600	110.6
3/8	12000	104.4	9600	129.0
1/2	12000	128.9	9600	159.8
9/16	9600	110.6	7200	135.2
5/8	9600	116.7	7200	147.4
11/16	6000	86.0	4800	110.6
13/16	6000	98.3	4800	116.7



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.