

CARBIDE

HSS


**TANK-POWER
END MILLS**
E9985 SERIES

FLAT SHANK

PREMIUM HSS-PM, 4 FLUTE REGULAR LENGTH

► Faster feed & speed than normal HSS can be applied to hardened steels up to Rc 45. Accordingly, YPM made by powder metallurgy makes much higher productivity possible.



YPM



P.807

◆ U.S.A Stock

Unit : Inch

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	TANK-POWER COATED				
E9985008	E9985008TF	1/8	3/8	3/8	2-5/16
E9985012	E9985012TF	3/16	3/8	1/2	2-3/8
E9985016	E9985016TF	1/4	3/8	5/8	2-7/16
E9985020	E9985020TF	5/16	3/8	3/4	2-1/2
E9985024	E9985024TF	3/8	3/8	3/4	2-1/2
E9985032	E9985032TF	1/2	1/2	1-1/4	3-1/4
E9985040	E9985040TF	5/8	5/8	1-5/8	3-3/4
E9985048	E9985048TF	3/4	3/4	1-5/8	3-7/8
E9985056	E9985056TF	7/8	7/8	1-7/8	4-1/8
E9985064	E9985064TF	1	1	2	4-1/2

Mill Dia. Tolerance (inch)	
0~+.0010	* 0~+.0015

**The shank of end mills is the same diameter as the cutting portion.

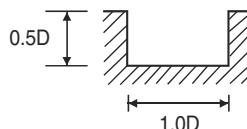
◎ : Excellent ○ : Good

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 MILLi-Xmill
END MILLX5070
END MILLS4G MILLS
END MILLSX-SPEED
ROUGHER
END MILLSX-POWER
END MILLSJET-POWER
END MILLSV7 Mill STEEL
END MILLSV7 Mill INOX
END MILLSALU-POWER
END MILLSD-POWER
END MILLSSTANDARD
CARBIDE
END MILLSTANK-POWER
END MILLSSTANDARD
COBALT
& HSS
END MILLSTECHNICAL
DATA

PREMIUM HSS-PM, 2 FLUTE FINISH - SLOTTING
E9983, E9984 SERIES

MATERIAL	STRUCTURAL STEELS, CARBON STEELS		STRUCTURAL STEELS, CARBON STEELS, CAST IRONS		CARBON STEELS, ALLOY STEELS, TOOL STEELS		PREHARDENED STEELS, ALLOY STEELS, TOOL STEELS		ALLOY STEELS, TOOL STEELS AUSTENITIC STAINLESS STEELS	
HARDNESS			~HRc20		HRc20~HRc30		HRc30~HRc35		HRc35~HRc40	
STRENGTH	~ 500N/mm ²		500~800N/mm ²		800~1000N/mm ²		1000~1100N/mm ²		1100~1300N/mm ²	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/8	4600	5.9	3800	5.0	3150	4.2	2150	2.8	1650	2.2
3/16	3800	8.5	3150	6.7	2600	6.1	1650	3.5	1350	2.6
1/4	3150	9.1	2650	7.5	2100	6.6	1350	3.8	1050	3.0
5/16	2500	9.4	2100	8.2	1700	6.9	1100	3.9	855	3.0
3/8	2100	10.1	1800	8.9	1450	7.6	910	4.2	715	3.4
1/2	1650	9.3	1350	8.1	1050	7.0	665	3.9	525	2.9
5/8	1300	9.1	1100	7.3	855	6.1	535	3.6	425	2.8
3/4	995	7.9	820	6.2	710	5.3	450	3.2	360	2.5
7/8	795	6.2	675	5.1	560	4.3	375	2.7	300	2.0
1	710	5.2	590	4.7	465	3.9	335	2.5	235	1.7

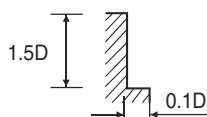


※ The Feed, in long & extra long types, should be reduced by around 50%.

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

PREMIUM HSS-PM, 4 FLUTE FINISH - SIDE CUTTING
E9985, E9986 SERIES

MATERIAL	STRUCTURAL STEELS, CARBON STEELS		STRUCTURAL STEELS, CARBON STEELS, CAST IRONS		CARBON STEELS, ALLOY STEELS, TOOL STEELS		PREHARDENED STEELS, ALLOY STEELS, TOOL STEELS		ALLOY STEELS, TOOL STEELS AUSTENITIC STAINLESS STEELS	
HARDNESS			~HRc20		HRc20~HRc30		HRc30~HRc35		HRc35~HRc40	
STRENGTH	~ 500N/mm ²		500~800N/mm ²		800~1000N/mm ²		1000~1100N/mm ²		1100~1300N/mm ²	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/8	6300	17.7	6000	14.4	4250	10.4	2700	7.2	2320	5.1
3/16	4600	19.7	4100	16.1	3040	12.6	2070	8.5	1780	6.2
1/4	3800	22.1	3300	18.1	2500	13.0	1700	9.7	1400	7.1
5/16	3100	22.4	2600	18.9	2000	14.2	1400	9.4	1150	7.2
3/8	2500	24.8	2200	20.5	1680	15.0	1180	10.2	960	7.7
1/2	1900	22.1	1720	18.5	1270	14.4	860	9.3	690	2.7
5/8	1600	20.1	1410	16.9	1000	13.3	690	8.9	620	6.7
3/4	1400	17.7	1150	15.2	830	11.5	580	7.3	470	5.7
7/8	1030	15.8	930	12.4	675	9.8	470	6.3	390	5.1
1	1000	14.6	830	11.8	620	8.8	420	5.6	360	4.9



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

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