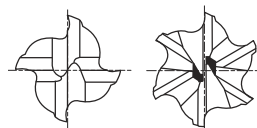
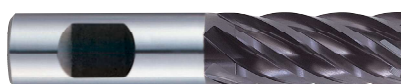


## PREMIUM HSS-PM, 4&6 FLUTE SHORT LENGTH

- Designed to machine low hardness materials (under HRC45), alloy steels, tool steels, carbon steels, prehardened steels, stainless steel, inconel, nimonic, etc.
- High velocity milling operation and good surface finishes.



◇ Call for Availability

Unit : mm

| EDP No.  | Mill Diameter |       | Shank Diameter | Length of Cut | Overall Length | No. of Flute |
|----------|---------------|-------|----------------|---------------|----------------|--------------|
|          | Metric        | Inch  |                |               |                |              |
| EE515030 | 3.0           | .1181 | 6              | 8             | 52             | 4            |
| EE515040 | 4.0           | .1575 | 6              | 11            | 55             | 4            |
| EE515050 | 5.0           | .1969 | 6              | 13            | 57             | 4            |
| EE515060 | 6.0           | .2362 | 6              | 13            | 57             | 4            |
| EE515080 | 8.0           | .3150 | 10             | 19            | 69             | 4            |
| EE515100 | 10.0          | .3937 | 10             | 22            | 72             | 4            |
| EE515120 | 12.0          | .4724 | 12             | 26            | 83             | 4            |
| EE515140 | 14.0          | .5512 | 12             | 26            | 83             | 4            |
| EE515160 | 16.0          | .6299 | 16             | 32            | 92             | 6            |
| EE515180 | 18.0          | .7087 | 16             | 32            | 92             | 6            |
| EE515200 | 20.0          | .7874 | 20             | 38            | 104            | 6            |
| EE515250 | 25.0          | .9843 | 25             | 45            | 121            | 6            |

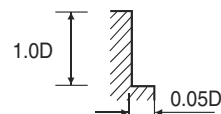
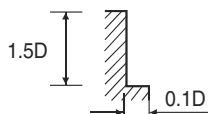
| Mill Dia.<br>Tolerance(mm) | Shank Dia.<br>Tolerance |
|----------------------------|-------------------------|
| 0~+0.03                    | h6                      |

◎ : 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             |        |          |           |          |                  |          |         |
| ○             | ◎            | ◎                  | ○               |          |                      |        |          |           |          | ◎                | ◎        | ○       |


**YPM, 6 FLUTE - SIDE CUTTING**
**EE882 SERIES**

| MATERIAL | CARBON STEELS<br>ALLOY STEELS<br>TOOL STEELS |      | CARBON STEELS<br>ALLOY STEELS<br>TOOL STEELS |      | STAINLESS STEELS |      | TITANIUM ALLOY |      | INCONEL |      |
|----------|----------------------------------------------|------|----------------------------------------------|------|------------------|------|----------------|------|---------|------|
| HARDNESS | ~HRc30                                       |      | HRc30 ~ HRc45                                |      |                  |      |                |      |         |      |
| STRENGTH | ~1000N/mm <sup>2</sup>                       |      | 1000 ~ 1500N/mm <sup>2</sup>                 |      |                  |      |                |      |         |      |
| DIAMETER | RPM                                          | FEED | RPM                                          | FEED | RPM              | FEED | RPM            | FEED | RPM     | FEED |
| 3/4      | 960                                          | 8.0  | 215                                          | 0.8  | 480              | 4.8  | 220            | 1.4  | 170     | 1.0  |
| 7/8      | 730                                          | 7.3  | 180                                          | 0.7  | 365              | 4.4  | 190            | 1.1  | 145     | 0.8  |
| 1        | 640                                          | 6.6  | 165                                          | 0.6  | 320              | 4.0  | 170            | 1.0  | 130     | 0.7  |
| 1-1/4    | 520                                          | 5.3  | 130                                          | 0.5  | 260              | 3.2  | 140            | 0.8  | 105     | 0.6  |
| 1-1/2    | 430                                          | 4.4  | 105                                          | 0.4  | 215              | 2.6  | 110            | 0.6  | 85      | 0.5  |

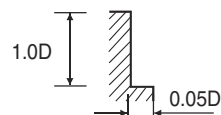
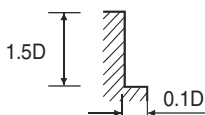


※ The Feed, in long & extra long types, should be reduced by around 50%.

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

**PREMIUM HSS-PM, 4&6 FLUTE SHORT- SIDE CUTTING**
**EE515 SERIES**

| MATERIAL | CARBON STEELS<br>ALLOY STEELS<br>TOOL STEELS |      | CARBON STEELS<br>ALLOY STEELS<br>TOOL STEELS |      | STAINLESS STEELS<br>TITANIUM ALLOY |      | INCONEL |      |
|----------|----------------------------------------------|------|----------------------------------------------|------|------------------------------------|------|---------|------|
| HARDNESS | ~ HRc30                                      |      | HRc30 ~ HRc45                                |      |                                    |      |         |      |
| DIAMETER | RPM                                          | FEED | RPM                                          | FEED | RPM                                | FEED | RPM     | FEED |
| 3.0      | 4400                                         | 7.3  | 1100                                         | 0.9  | 2200                               | 4.3  | 880     | 1.1  |
| 4.0      | 3600                                         | 8.3  | 900                                          | 1.2  | 1800                               | 4.9  | 720     | 1.5  |
| 5.0      | 3000                                         | 8.9  | 750                                          | 1.2  | 1500                               | 5.3  | 600     | 1.4  |
| 6.0      | 2600                                         | 9.3  | 600                                          | 1.1  | 1300                               | 5.5  | 480     | 1.4  |
| 8.0      | 2000                                         | 9.8  | 500                                          | 1.1  | 1000                               | 5.9  | 400     | 1.3  |
| 10.0     | 1600                                         | 11.2 | 410                                          | 1.2  | 800                                | 6.7  | 330     | 1.4  |
| 12.0     | 1320                                         | 9.8  | 340                                          | 1.1  | 660                                | 5.9  | 270     | 1.4  |
| 14.0     | 1160                                         | 9.3  | 290                                          | 1.1  | 580                                | 5.5  | 230     | 1.3  |
| 16.0     | 1000                                         | 8.9  | 250                                          | 1.0  | 500                                | 5.3  | 200     | 1.2  |
| 18.0     | 900                                          | 8.3  | 225                                          | 0.9  | 450                                | 4.9  | 180     | 1.1  |
| 20.0     | 800                                          | 7.9  | 200                                          | 0.7  | 400                                | 4.7  | 160     | 0.8  |
| 25.0     | 640                                          | 6.5  | 165                                          | 0.6  | 320                                | 3.9  | 130     | 0.7  |



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