

## HSSCo8 & HSS, 2 FLUTE REGULAR LENGTH

► Two flute end mills with metric cutting diameter are especially recommended for slotting operation, pocketing keyway cutting and other general purpose work including plunge cutting.



Unit : Inch

EDP No.		Mill Diameter		Shank Diameter	Length of Cut	Overall Length
8% COBALT (M42)	HSS (M2)	Metric	Inch			
15252	15002	2.0	.0787	3/8	5/16	2-5/16
15253	15003	2.5	.0984	3/8	5/16	2-5/16
15254	15004	3.0	.1181	3/8	5/16	2-5/16
15255	15005	3.5	.1378	3/8	7/16	2-5/16
15256	15006	4.0	.1575	3/8	7/16	2-5/16
15257	15007	4.5	.1772	3/8	1/2	2-5/16
15258	15008	5.0	.1969	3/8	1/2	2-5/16
15259	15009	5.5	.2165	3/8	1/2	2-5/16
15260	15010	6.0	.2362	3/8	1/2	2-5/16
15261	15011	7.0	.2756	3/8	9/16	2-5/16
15262	15012	8.0	.3150	3/8	9/16	2-5/16
15263	15013	9.0	.3543	3/8	9/16	2-5/16
15264	15014	10.0	.3937	3/8	13/16	2-1/2
15265	15015	11.0	.4330	3/8	13/16	2-1/2
15266	15016	12.0	.4724	3/8	13/16	2-1/2
15267	15017	12.5	.4921	1/2	1-1/8	3-1/8
15268	15018	13.0	.5118	1/2	1-1/8	3-1/8
15270	15020	14.0	.5512	1/2	1-1/8	3-1/8
15276	15026	16.0	.6299	5/8	1-5/16	3-7/16
15280	15030	18.0	.7087	5/8	1-5/16	3-7/16
15282	15032	20.0	.7874	5/8	1-1/2	3-3/4
15284	15034	22.0	.8661	3/4	1-1/2	3-3/4
15288	15038	24.0	.9449	3/4	2	4-1/2
15290	15040	25.0	.9843	1	2	4-1/2
15296	15046	32.0	1.2598	1	2	4-1/2
15298	15048	36.0	1.4173	1	2	4-1/2
15300	15050	40.0	1.5748	1-1/4	2	4-1/2
15302	15052	45.0	1.7717	1-1/4	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.

- The TiN coated, TiCN coated or TiAlN coated is available on your request.
- Coating Codes for Cobalt  
Uncoated EDP NO. + CN(TiN), CC(TiCN), CF(TiAlN F), CE(TiAlN E), CH(Hardslick)
- Coating Codes for HSS  
Uncoated EDP NO. + HN(TiN), HC(TiCN), HF(TiAlN F), HE(TiAlN E), HH(Hardslick)
- Coated Price Shown in Price List. Call for Availability.

◎ : 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

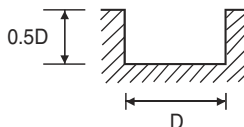
TANK-POWER END MILLS

STANDARD COBALT & HSS END MILLS

TECHNICAL DATA

**HSSCo8 & HSS, 2 FLUTE FINISH - SLOTTING**

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		ALUMINUM ALUMINUM ALLOYS	
HARDNESS			~HRc20		HRc20~HRc30		HRc30~HRc40			
STRENGTH	~ 500N/mm <sup>2</sup>		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
1/8	3500	2.2	3200	1.8	2500	1.6	1600	0.8	11000	9.8
1/4	1800	3.5	1600	3.1	1200	2.4	800	1.6	5600	12.2
3/8	1100	4.0	900	3.5	800	3.1	450	1.8	3100	15.8
1/2	900	4.3	800	4.0	630	3.1	400	2.0	2500	15.0
5/8	700	4.3	560	3.5	450	2.8	280	1.8	2000	13.8
3/4	630	4.0	500	3.5	400	2.8	250	1.8	1800	13.8
7/8	500	4.0	450	3.5	350	2.8	220	1.8	1400	11.8
1	450	3.5	400	3.1	310	2.4	180	1.4	1200	11.0
1-1/8	400	3.1	350	2.8	280	2.2	160	1.2	1100	10.5
1-3/8	310	2.4	250	2.0	200	1.6	120	1.0	900	8.7
1-1/2	310	2.4	250	2.0	200	1.6	120	1.0	900	8.7
1-3/4	280	2.4	220	2.0	180	1.6	110	1.0	800	7.8
2	250	2.0	190	1.8	110	1.0	80	0.8	630	6.3

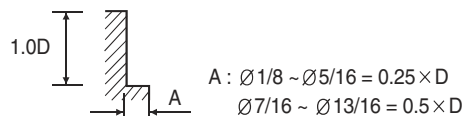
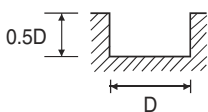


※ The Feed, in long &amp; extra long types, should be reduced by around 50%.

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

**HSS, 2 FLUTE, 42° HELIX FINISH for ALUMINUM**

MATERIAL	ALUMINUM NONFERROUS METALS		NON-ALLOYED STEELS ALLOY STEELS CAST IRON	
DIAMETER	RPM	FEED	RPM	FEED
1/8	8000	22.5	8000	29.0
3/16	7400	25.0	7400	32.5
1/4	6800	28.5	6800	37.0
5/16	5200	43.5	5200	55.0
7/16	5000	47.0	5000	47.0
1/2	4500	47.0	4500	61.0
9/16	3500	49.0	3500	63.0
5/8	3500	49.0	3500	63.0
3/4	2300	51.0	2300	67.0
13/16	2000	51.0	2000	67.0


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

 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

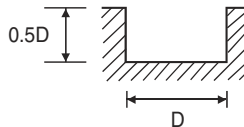
 TANK-POWER  
END MILLS

 STANDARD  
COBALT  
& HSS  
END MILLS

 TECHNICAL  
DATA

**HSSCo8 & HSS, 2 FLUTE FINISH TiN-COATED - SLOTTING**

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		ALUMINUM ALUMINUM ALLOYS	
HARDNESS			~HRc20		HRc20~HRc30		HRc30~HRc40			
STRENGTH	~ 500N/mm <sup>2</sup>		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
1/8	4200	2.6	3840	2.2	3000	1.9	1920	1.0	13200	11.8
1/4	2160	4.2	1920	3.7	1440	2.9	960	1.9	6720	14.6
3/8	1320	4.8	1080	4.2	960	3.7	540	2.2	3720	19.0
1/2	1090	5.2	960	4.8	756	3.7	480	2.4	3000	18.0
5/8	840	5.2	672	4.2	540	3.7	336	2.2	2400	16.6
3/4	756	4.8	600	4.2	480	3.4	300	2.2	2160	16.6
7/8	600	4.8	540	4.2	420	3.4	264	2.2	1680	14.2
1	540	4.2	480	3.7	372	2.9	260	2.2	1440	13.2
1-1/8	480	3.7	420	3.4	336	2.6	432	1.7	1320	12.6
1-3/8	372	2.9	300	2.4	240	1.9	144	1.2	1080	10.4
1-1/2	372	2.9	300	2.4	240	1.9	144	1.2	1080	10.4
1-3/4	336	2.9	264	2.4	216	1.9	132	1.2	960	9.5
2	300	2.4	228	2.2	132	1.2	96	1.0	756	7.6

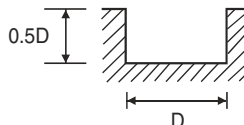


※ The Feed, in long &amp; extra long types, should be reduced by around 50%.

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

**HSSCo8 & HSS, 3 FLUTE FINISH TiN-COATED - SLOTTING**

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		ALUMINUM ALUMINUM ALLOYS	
HARDNESS			~HRc20		HRc20~HRc30		HRc30~HRc40			
STRENGTH	~ 500N/mm <sup>2</sup>		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
3/32	6720	2.8	5400	2.2	4800	2.2	2640	1.0	14400	11.3
1/5	4200	3.7	3840	3.1	3000	2.9	1920	1.4	13200	18.0
1/4	2160	6.4	1920	5.6	1440	4.2	960	2.9	6720	21.7
3/8	1320	7.2	1080	6.4	960	5.6	540	3.1	3720	28.3
1/2	1080	7.8	960	7.2	756	5.6	480	3.6	3000	26.9
5/8	840	7.8	672	6.4	540	4.9	336	3.1	2400	25.1
11/16	756	7.2	600	6.4	480	4.9	300	3.1	2160	25.1
7/8	600	7.2	540	6.4	420	4.9	264	3.1	1680	21.2
1	540	6.4	480	5.6	372	4.2	216	2.4	1440	19.8
1-1/8	430	5.6	420	4.9	336	3.7	192	2.2	1320	19.0
1-3/16	420	4.9	372	4.2	300	3.6	192	2.2	1320	19.0



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

 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

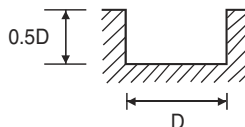
 TANK-POWER  
END MILLS

 STANDARD  
COBALT  
& HSS  
END MILLS

 TECHNICAL  
DATA

**HSSCo8 & HSS, 2 FLUTE FINISH TiCN-COATED - SLOTTING**

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		ALUMINUM ALUMINUM ALLOYS	
	HARDNESS	~HRc20		HRc20~HRc30		HRc30~HRc40				
STRENGTH	~ 500N/mm <sup>2</sup>		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
1/8	4550	2.9	3840	2.3	3250	2.1	2048	1.0	14300	12.7
1/4	2340	4.6	2080	4.0	1560	3.1	1040	3.2	7280	15.9
3/8	1430	5.2	1170	4.6	1040	4.0	585	3.2	4030	20.5
1/2	1170	5.6	1040	5.2	819	4.0	520	2.8	3250	19.5
5/8	910	5.6	728	4.6	585	3.6	364	2.3	2600	17.9
3/4	819	5.2	650	4.6	520	3.6	325	2.3	2340	17.9
7/8	650	5.2	585	4.6	455	3.6	286	2.3	1820	15.3
1	585	4.6	520	4.0	403	3.1	234	1.8	1560	14.3
1-1/8	520	4.0	455	3.6	364	2.9	208	1.6	1430	13.7
1-3/8	403	3.1	325	2.6	260	2.1	156	1.3	1170	11.3
1-1/2	403	3.1	325	2.6	260	2.1	156	1.3	1170	11.3
1-3/4	364	3.1	286	2.6	234	2.1	143	1.3	1040	10.3
2	325	2.6	228	2.3	143	1.3	104	1.0	819	8.2

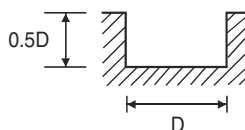


※ The Feed, in long &amp; extra long types, should be reduced by around 50%.

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

**HSSCo8, 3 FLUTE FINISH TiCN-COATED - SLOTTING**

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		ALUMINUM ALUMINUM ALLOYS	
	HARDNESS	~HRc20		HRc20~HRc30		HRc30~HRc40				
STRENGTH	~ 500N/mm <sup>2</sup>		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
3/32	7280	3.1	5850	2.3	5200	2.3	2860	1.0	15600	12.2
1/8	4550	4.0	2340	3.4	3250	3.1	2080	1.6	14300	19.5
1/4	2340	6.9	2080	6.1	1560	4.6	1040	3.1	7280	23.5
3/8	1430	7.8	1170	6.9	1040	6.1	585	3.4	4030	30.7
1/2	1170	8.5	1040	7.8	819	6.1	520	3.8	3250	29.1
9/16	1040	8.5	910	6.9	728	6.1	455	3.8	2860	27.2
5/8	910	8.5	728	6.9	585	5.3	364	3.4	2600	27.2
7/8	650	7.8	585	6.9	455	5.3	286	3.4	1820	23.0
1	585	6.9	520	6.1	403	4.6	234	2.6	1560	21.5
1-1/8	520	6.9	455	5.3	364	4.3	208	2.3	1430	20.5



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

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

 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