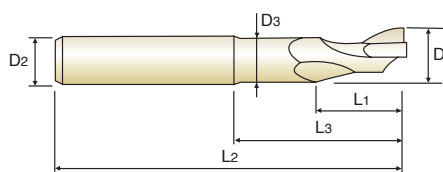


HSS-E, 1 FLUTE
HSS-E, 1 SCHNEIDEN
for ALUMINUM
für ALUMINIUM


Unit : mm

EDP No.	ITEM No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
UNCOATED	UNCOATED	js14	h6		
EL612030	M1NRA-03001	3.0	8	12	60
EL612040	M1NRA-04001	4.0	8	12	60
EL612050	M1NRA-05001	5.0	8	14	60
EL612060	M1NRA-06001	6.0	8	14	60
EL612070	M1NRA-07001	7.0	8	14	60
EL612080	M1NRA-08001	8.0	8	14	80
EL612090	M1NRA-09001	9.0	8	14	80
EL612100	M1NRA-10001	10.0	8	14	80



Unit : mm

EDP No.	ITEM No.	Mill Diameter	Shank Diameter	Length of Cut	LENGTH BELOW SHANK	Overall Length	NECK DIAMETER
UNCOATED	UNCOATED	D1(js14)	D2(h6)	L1	L3	L2	D3
EL612904	M1NRA-05002	5.0	8	18	35	80	4.8
EL612909	M1NRA-05009	5.0	8	40	—	100	—
EL612932	M1NRA-08007	8.0	8	14	68	120	7.5

Tolerances according to DIN 7160 & 7161
Toleranzen nach DIN 7160 & 7161

Tolerance range in μm / Toleranzwerte in μm						
Nominal-Diameter in mm / Nennmaßbereich in mm						
	from 1 to 3 von 1 bis 3	over 3 to 6 über 3 bis 6	over 6 to 10 über 6 bis 10	over 10 to 18 über 10 bis 18	over 18 to 30 über 18 bis 30	over 30 to 50 über 30 bis 50
js14	± 125	± 150	± 180	± 215	± 260	± 310
h6	0 - 6	0 - 8	0 - 9	0 - 11	0 - 13	0 - 16

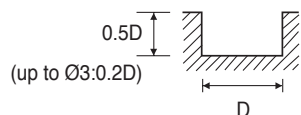
◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRc30~40	HRc40~45 HRc45~55	HRc55~70									
○								◎					

HSS-E, 1 FLUTE
HSS-E, 1 SCHNEIDEN

EL612, EL623 SERIES

MATERIAL	ALUMINUM ALUMINUM ALLOYS			
	DIAMETER	RPM	FEED	Vc
3.0	20000	1100	188	0.055
4.0	18000	950	226	0.053
5.0	14000	750	220	0.054
6.0	11000	600	207	0.055
7.0	10000	550	220	0.055
8.0	8500	450	214	0.053
10.0	7000	380	220	0.054



RPM = rev./min.
 FEED = mm/min.
 Vc = m/min.
 fz = mm/t

CARBIDE

HSS

CBN
END MILLS

i-Xmill
END MILLS

i-HS mill
END MILLS

X5070
END MILLS

4G MILL
END MILLS

X-SPEED
ROUGHER
END MILLS

X-POWER
END MILLS

JET-POWER
END MILLS

TN MILL
END MILLS

V7 Mill
END MILLS

ALU-POWER
END MILLS

CRX S
END MILLS

D-POWER
GRAPHITE
END MILLS

D-POWER
CFRP
END MILLS

ROUTERS

K-2 CARBIDE
END MILLS

GENERAL
CARBIDE
END MILLS

TANK-POWER
END MILLS

GENERAL
HSS
END MILLS

MILLING
CUTTERS

TECHNICAL
DATA