








# Alu-POWER END MILLS

for ALUMINIUM

***Alu-POWER FRÄSER***  
*für ALUMINIUM*

EI926		CARBIDE, 2 FLUTE, 45° HELIX for ALUMINUM, DIAMOND COATED VHM, 2 SCHNEIDEN, 25° RECHTSSPIRALE für ALUMINIUM, DIAMANT-BESCHICHTETE <i>102</i>
EG930		CARBIDE, 2 FLUTE, 25° HELIX for ALUMINUM, TiCN COATED VHM, 2 SCHNEIDEN, 25° RECHTSSPIRALE für ALUMINIUM, TiCN-BESCHICHTETE <i>103</i>
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<b>SPEED &amp; FEED DATA</b>		<i>110~113</i>

# 2 FLUTE, 45° HELIX for ALUMINUM, DIAMOND COATED

## 2 SCHNEIDEN, 45° RECHTSSPIRALE für ALUMINIUM, DIAMANT-BESCHICHTETE

**SERIES EI926**

**PLAIN SHANK**

GLATTEM ZYLINDERSCHAFT

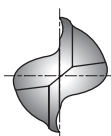
**MG  
HM**



**FLUTE  
2**



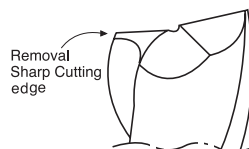
P.110



- ▶ Designed for the machining aluminum and its alloys, non-ferrous materials.  
Geeignet zum Fräsen von Aluminium, Aluminium-legierungen und anderen Nichteisen-Metallen.
- ▶ YG-1's newly developed diamond film coating increases the tool life surprisingly due to Hv4,500-5,500 high hardness of diamond film.  
Die von YG-1 neuentwickelte Diamantbeschichtung verlängert, dank der zwischen Hv4500 bis 5500 hohen Härte der Beschichtung die Werkzeuglebensdauer beachtlich.
- ▶ Maximum-stock removal, chip ejection, stability.  
Sehr gute Spanausfuhr.

Unit : mm

EDP No. PLAIN	MILL DIAMETER	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
EI926010	1.0	4	3	40
EI926015	1.5	4	4	40
EI926020	2.0	4	6	40
EI926025	2.5	4	8	40
EI926030	3.0	6	8	45
EI926035	3.5	6	10	45
EI926040	4.0	6	11	45
EI926045	4.5	6	11	50
EI926050	5.0	6	13	50
EI926055	5.5	6	13	50
EI926060	6.0	6	13	50
EI926070	7.0	8	16	60
EI926080	8.0	8	19	60
EI926090	9.0	10	19	70
EI926100	10.0	10	22	70
EI926110	11.0	12	22	75
EI926120	12.0	12	26	75
EI926160	16.0	16	32	90
EI926200	20.0	20	38	100



AL-POWER

MILL DIA. TOLERANCE		SHANK DIA. TOLERANCE
DIAMETER	TOL.	
from 1 to 3	—0.014 —0.028	h6
over 3 to 6	—0.020 —0.038	
over 6 to 10	—0.025 —0.047	
over 10 to 20	—0.032 —0.059	

# 2 FLUTE, 25° HELIX for ALUMINUM, TiCN COATED

## 2 SCHNEIDEN, 25° RECHTSSPIRALE für ALUMINIUM, TiCN-BESCHICHTETE

**SERIES EG930**

PLAIN SHANK

GLATTEM ZYLINDERSCHAFT

MG  
HM

25°

FLUTE  
2

PLAIN

P.110



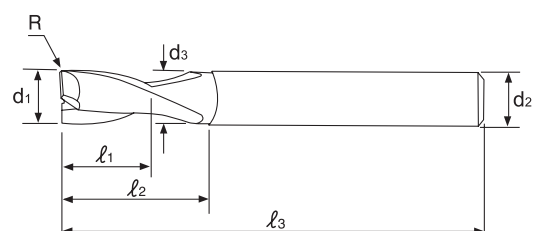
- ▶ Designed for the machining aluminum and its alloys, non-ferrous materials.  
Geeignet zum Fräsen von Aluminium, Aluminiumlegierungen und NE-Metallen.
- ▶ Increased tool Life and higher cutting accuracy.  
Längere Werkzeuglebensdauer und höherer Schnittgenauigkeit.
- ▶ Maximum-stock removal, chip ejection, stability.  
Sehr gute Spanausfuhr.
- ▶ Corner Radius for avoiding the chipping.  
Eckenradius für Vermeidung von Abbröckelungen.

Unit : mm

EDP No. PLAIN	R	MILL DIAMETER h10	SHANK DIAMETER h6	LENGTH OF CUT $l_1$	LENGTH BELOW SHANK $l_2$	OVERALL LENGTH $l_3$	NECK DIAMETER d3
EG930020	R0.2	2.0	3	3	6	40	1.9
EG930030	R0.2	3.0	3	4	8	40	2.9
EG930040	R0.2	4.0	4	5	12	50	3.8
EG930050	R0.2	5.0	5	8	14	50	4.8
EG930060	R0.2	6.0	6	8	18	65	5.7
EG930080	R0.2	8.0	8	10	22	70	7.7
EG930100	R0.2	10.0	10	14	28	80	9.7
EG930120	R0.2	12.0	12	16	35	90	11.5
EG930160	R0.2	16.0	16	20	40	90	15.5
EG930200	R0.2	20.0	20	25	50	100	19.5

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

Toleranzwerte in $\mu\text{m}$ / Tolerance range in $\mu\text{m}$					
Nennmaßbereich in mm / Nominal-Diameter in mm					
	von 1 bis 3 from 1 to 3	über 3 bis 6 over 3 to 6	über 6 bis 10 over 6 to 10	über 10 bis 18 over 10 to 18	über 18 bis 30 over 18 to 30
<b>h10</b>	0 - 40	0 - 48	0 - 58	0 - 70	0 - 84
<b>h6</b>	0 - 6	0 - 8	0 - 9	0 - 11	0 - 13



# 2 FLUTE, 45° HELIX for ALUMINUM 2 SCHNEIDEN, 45° RECHTSSPIRALE für ALUMINIUM

## SERIES E5522 PLAIN SHANK

GLATTEM ZYLINDERSCHAFT

MG  
HM



FLUTE  
2



P.111

## SERIES E5521 FLAT SHANK

SEITLICHEN MITNAHMEFLÄCHEN

► Suitable for high speed machining in aluminum and other non-ferrous materials, excellent surface finishes, superior chip removal.  
Geeignet zum Hochgeschwindigkeitsfräsen von Aluminium und anderen NE-Metallen. Exzellente Oberflächenbearbeitung und Spanausfuhr.



Unit : mm

EDP No.		MILL DIAMETER h10	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
PLAIN	FLAT				
E5522030	E5521030	3.0	6	8	57
E5522040	E5521040	4.0	6	11	57
E5522050	E5521050	5.0	6	13	57
E5522060	E5521060	6.0	6	13	57
E5522080	E5521080	8.0	8	19	63
E5522100	E5521100	10.0	10	22	72
E5522120	E5521120	12.0	12	26	83
E5522140	E5521140	14.0	14	26	83
E5522160	E5521160	16.0	16	32	92
E5522180	E5521180	18.0	18	32	92
E5522200	E5521200	20.0	20	38	104

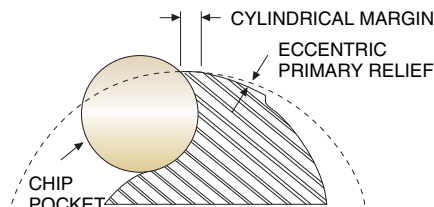
►TiN, TiCN - coating & TiAlN - coating is available on your request.



- High performance in machining aluminum and non-ferrous materials
- Special designed geometry with high rigidity cutting edge
- Improved surface roughness - cylindrical margin which is controlled tightly.
- Excellent chip removal - higher rake angle, higher helix angle(45°), bigger chip pocket.

- Corner radius, Corner chamfer, Neck design is available on your request.
- TiN, TiCN & TiAlN coating is available on your request.

	UNCOATED	TiN	TiCN	TiAlN
PLAIN SHANK	E5522	E6522	EG522	EH522
FLAT SHANK	E5521	E6521	EG521	EH521



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

Toleranzwerte in $\mu\text{m}$ / Tolerance range in $\mu\text{m}$					
Nennmaßbereich in mm / Nominal-Diameter in mm					
	von 1 bis 3 from 1 to 3	über 3 bis 6 over 3 to 6	über 6 bis 10 over 6 to 10	über 10 bis 18 over 10 to 18	über 18 bis 30 over 18 to 30
h10	0 -40	0 -48	0 -58	0 -70	0 -84
h6	0 -6	0 -8	0 -9	0 -11	0 -13

# 2 FLUTE, CORNER RADIUS for ALUMINUM, TiCN COATED 2 SCHNEIDEN, ECKENRADIUS für ALUMINIUM, TiCN-BESCHICHTETE

**SERIES EG909**

PLAIN SHANK

GLATTEM ZYLINDERSCHAFT

MG  
HM



FLUTE  
2



P.112



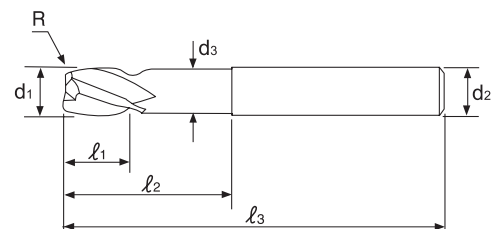
- ▶ Excellent cutting qualities on stainless steel, Aluminum, copper.  
Ausgezeichnete Leistung bei der Bearbeitung von Edelstahl, Aluminium und Kupfer.
- ▶ Increased tool life and higher cutting accuracy.  
Längere Werkzeuglebensdauer und höhere Schnittgenauigkeit.

Unit : mm

EDP No. PLAIN	R	MILL DIAMETER d <sub>1</sub> (e8)	SHANK DIAMETER d <sub>2</sub> (h6)	LENGTH OF CUT l <sub>1</sub>	LENGTH BELOW SHANK l <sub>2</sub>	OVERALL LENGTH l <sub>3</sub>	NECK DIAMETER d <sub>3</sub>
EG909040	R0.3	4.0	6	5	10	50	3.6
EG909060	R0.5	6.0	6	8	20	60	5.4
EG909080	R0.6	8.0	8	10	30	70	7.2
EG909100	R0.8	10.0	10	12	36	80	9.0
EG909120	R1.0	12.0	12	14	40	90	11.0
EG909160	R1.3	16.0	16	18	45	100	14.5
EG909200	R1.6	20.0	20	24	45	100	18.0

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

Toleranzwerte in $\mu\text{m}$ / Tolerance range in $\mu\text{m}$					
Nennmaßbereich in mm / Nominal-Diameter in mm					
	von 1 bis 3 from 1 to 3	über 3 bis 6 over 3 to 6	über 6 bis 10 over 6 to 10	über 10 bis 18 over 10 to 18	über 18 bis 30 over 18 to 30
e8	-14 -28	-20 -38	-25 -47	-32 -59	-40 -73
h6	0 -6	0 -8	0 -9	0 -11	0 -13





# 2 FLUTE, BALL NOSE for ALUMNUM, TiCN COATED

## 2 SCHNEIDEN, STIRNRADIUS für ALUMINIUM, TiCN-BESCHICHTETE

**SERIES EG910**

PLAIN SHANK

GLATTEM ZYLINDERSCHAFT

MG  
HM

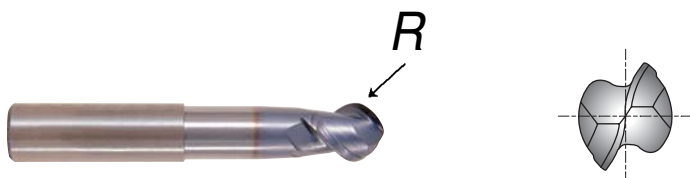


FLUTE  
2



P.112

- ▶ Excellent cutting qualities on stainless steel, Aluminum, copper.  
Ausgezeichnete Fräsleistung von rostfreien Stählen, Aluminium und Kupfer.
- ▶ Increased tool life and higher cutting accuracy.  
Längere Werkzeuglebensdauer und höhere Schnittgenauigkeit.

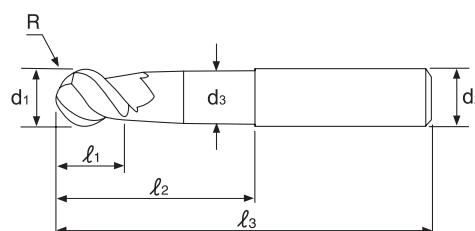


Unit : mm

EDP No. PLAIN	R ±0.01	MILL DIAMETER d <sub>1</sub>	SHANK DIAMETER d <sub>2</sub> (h6)	LENGTH OF CUT l <sub>1</sub>	LENGTH BELOW SHANK l <sub>2</sub>	OVERALL LENGTH l <sub>3</sub>	NECK DIAMETER d <sub>3</sub>
EG910060	R3.0	6.0	6	5.5	25	55	5.4
EG910080	R4.0	8.0	8	7	30	65	7.2
EG910100	R5.0	10.0	10	8.5	35	75	9.0
EG910120	R6.0	12.0	12	10.5	40	75	11.0
EG910160	R8.0	16.0	16	14	50	90	14.5
EG910200	R10.0	20.0	20	17	50	100	18.0

AL-POWER

MILL DIA. TOLERANCE	SHANK DIA. TOLERANCE
± 0.02	h6



# 3 FLUTE, BALL NOSE for ALUMINUM, TiCN COATED

## 3 SCHNEIDEN, STIRNRADIUS für ALUMINIUM, TiCN-BESCHICHTETE

**SERIES EG908**

PLAIN SHANK

GLATTEM ZYLINDERSCHAFT

MG  
HM



FLUTE  
3

PLAIN



P.113

- ▶ Excellent cutting qualities on stainless steel, Aluminum, copper.  
Ausgezeichnete Fräsleistung von rostfreien Stählen, Aluminium und Kupfer.
- ▶ Increased tool life and higher cutting accuracy.  
Längere Werkzeuglebensdauer und höhere Schnittgenauigkeit.

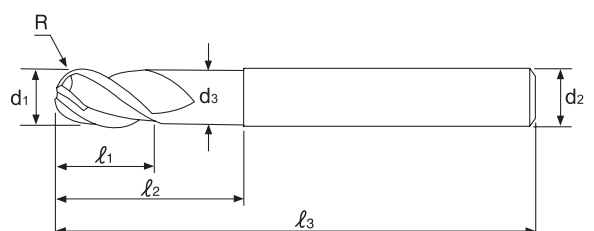


Unit : mm

EDP No. PLAIN	R ±0.01	MILL DIAMETER d1 (e8)	SHANK DIAMETER d2 (h6)	LENGTH OF CUT l1	LENGTH BELOW SHANK l2	OVERALL LENGTH l3	NECK DIAMETER d3
EG908020	R1.0	2.0	6	3	5	60	1.9
EG908025	R1.25	2.5	6	4	6	60	2.4
EG908030	R1.5	3.0	6	4.5	6.5	60	2.8
EG908035	R1.75	3.5	6	5	7	65	3.2
EG908040	R2.0	4.0	6	6	8	65	3.7
EG908050	R2.5	5.0	6	7.5	10	65	4.6
EG908060	R3.0	6.0	6	9	12	75	5.6
EG908080	R4.0	8.0	8	12	25	75	7.4
EG908100	R5.0	10.0	10	15	30	80	9.4
EG908120	R6.0	12.0	12	18	36	90	11.4
EG908160	R8.0	16.0	16	24	40	100	15.4

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

Toleranzwerte in $\mu\text{m}$ / Tolerance range in $\mu\text{m}$					
Nennmaßbereich in mm / Nominal-Diameter in mm					
	von 1 bis 3 from 1 to 3	über 3 bis 6 over 3 to 6	über 6 bis 10 over 6 to 10	über 10 bis 18 over 10 to 18	über 18 bis 30 over 18 to 30
e8	-14 -28	-20 -38	-25 -47	-32 -59	-40 -73
h6	0 -6	0 -8	0 -9	0 -11	0 -13



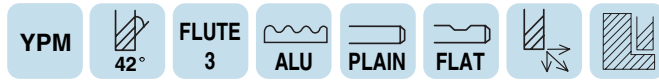


# 3 FLUTE, SHORT, ROUGHING END MILL for ALUMINUM, TiAIN COATED

## 3 SCHNEIDEN, KURZ, SCHRUPPFRÄSER für ALUMINIUM, TiAIN-BESCHICHTETE

**SERIES EP922** PLAIN SHANK  
GLATTEM ZYLINDERSCHAFT

**SERIES EP923** FLAT SHANK  
SEITLICHEN MITNAHMEFLÄCHEN



P.113

- ▶ Maximum stock removal rates at High Speed Condition.  
Sehr gute Spanausfuhr auch bei Hochgeschwindigkeitsfräsen.
- ▶ Reduces vibrations and improves surface roughness.  
Verringert Vibrationen und verbessert Oberflächengrobheit.



Unit : mm

EDP No.		MILL DIAMETER js12	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
PLAIN	FLAT				
EP922120	EP923120	12.0	12	26	83
EP922140	EP923140	14.0	12	26	83
EP922160	EP923160	16.0	16	32	92
EP922180	EP923180	18.0	16	32	92
EP922200	EP923200	20.0	20	38	104
EP922220	EP923220	22.0	20	38	104
EP922250	EP923250	25.0	25	45	121
EP922280	EP923280	28.0	25	45	121
EP922320	EP923320	32.0	32	53	133

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

Toleranzwerte in $\mu\text{m}$ / Tolerance range in $\mu\text{m}$						
Nennmaßbereich in mm / Nominal-Diameter in mm						
	von 1 bis 3 from 1 to 3	über 3 bis 6 over 3 to 6	über 6 bis 10 over 6 to 10	über 10 bis 18 over 10 to 18	über 18 bis 30 over 18 to 30	über 30 bis 50 over 30 to 50
js12	±50	±60	±75	±90	±105	±125
h6	$\begin{matrix} 0 \\ -6 \end{matrix}$	$\begin{matrix} 0 \\ -8 \end{matrix}$	$\begin{matrix} 0 \\ -9 \end{matrix}$	$\begin{matrix} 0 \\ -11 \end{matrix}$	$\begin{matrix} 0 \\ -13 \end{matrix}$	$\begin{matrix} 0 \\ -16 \end{matrix}$

# 3 FLUTE, LONG, ROUGHING END MILL for ALUMINUM, TiAIN COATED

## 3 SCHNEIDEN, LANG, SCHRUPPFÄRÄSER für ALUMINIUM, TiAIN-BESCHICHTETE

**SERIES EP924**

PLAIN SHANK

GLATTEM ZYLINDERSCHAFT

**SERIES EP925**

FLAT SHANK

SEITLICHEN MITNAHMEFLÄCHEN

YPM

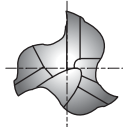


FLUTE  
3



P.113

- ▶ Maximum stock removal rates at High Speed Condition.  
Sehr gute Spanausfuhr auch bei Hochgeschwindigkeitfräsen.
- ▶ Reduces vibrations and improves surface roughness.  
Verringert Vibrationen und verbessert.



Unit : mm

EDP No.		MILL DIAMETER js12	SHANK DIAMETER h6	LENGTH OF CUT	OVERALL LENGTH
PLAIN	FLAT				
EP924120	EP925120	12.0	12	53	110
EP924140	EP925140	14.0	12	53	110
EP924160	EP925160	16.0	16	63	123
EP924180	EP925180	18.0	16	63	123
EP924200	EP925200	20.0	20	75	141
EP924220	EP925220	22.0	20	75	141
EP924250	EP925250	25.0	25	90	166
EP924280	EP925280	28.0	25	90	166
EP924320	EP925320	32.0	32	106	186

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

Toleranzwerte in $\mu\text{m}$ / Tolerance range in $\mu\text{m}$						
Nennmaßbereich in mm / Nominal-Diameter in mm						
	von 1 bis 3 from 1 to 3	über 3 bis 6 over 3 to 6	über 6 bis 10 over 6 to 10	über 10 bis 18 over 10 to 18	über 18 bis 30 over 18 to 30	über 30 bis 50 over 30 to 50
js12	± 50	± 60	± 75	± 90	± 105	± 125
h6	$\frac{0}{-6}$	$\frac{0}{-8}$	$\frac{0}{-9}$	$\frac{0}{-11}$	$\frac{0}{-13}$	$\frac{0}{-16}$

## 2 FL. FINISH for ALUMINUM, DIAMOND COATED

### ■ EI926

MATERIAL	ALUMINUM LOW SILICON ALUMINUM		ALUMINUM DIECAST		COPPER ALLOY	
	DIAMETER	RPM	FEED(mm/min)	RPM	FEED(mm/min)	RPM
3	45000	1100	24000	700	14000	280
4	35000	1500	20000	950	11000	380
5	25000	1600	13000	1100	7500	400
6	25000	1900	13000	1200	7500	480
8	20000	2300	11000	1500	6000	580
10	16000	2800	8500	1800	4800	700
12	13000	3400	7200	2200	3900	850
16	11000	3100	6000	2000	3300	780
20	6500	2500	3600	1600	2000	630

<p>A: D3 ~ D10=0.25 × D D12 ~ D20=0.5 × D</p>		<p>A: D3 ~ D10=0.1 × D D12 ~ D20=0.25 × D</p>		<p>A: D3 ~ D10=0.25 × D D12 ~ D20=0.5 × D</p>	
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RPM=REVOLUTION PER MIN.  
FEED=mm/min.

## 2 FL. FINISH for ALUMINUM, TiCN COATED

### ■ EG930

MATERIAL	ALUMINUM LOW SILICON ALUMINUM			
	DIAMETER	RPM	FEED	RPM
R0.2 × 3	13000	900	13000	1200
R0.2 × 4	13000	1200	13000	1400
R0.2 × 5	13000	1300	13000	1700
R0.2 × 6	13000	1500	13000	2000
R0.2 × 8	10000	1800	10000	2300
R0.2 × 10	10000	2200	10000	2700
R0.2 × 12	10000	2700	10000	3400
R0.2 × 16	8000	2500	8000	3100
R0.2 × 20	5000	2000	5000	2500

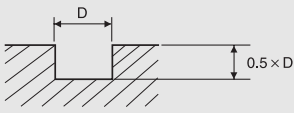
	<p>A: φ3 ~ φ10=0.25 × D φ12 ~ φ20=0.5 × D</p>
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RPM=REVOLUTION PER MIN.  
FEED=mm/min.

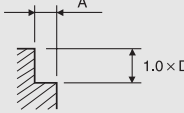
## 2 FL. 45° HELIX for ALUMINUM

### ■ E5522, E5521

MATERIAL	ALUMINUM LOW SILICON ALUMINUM				
	DIAMETER	RPM	FEED	RPM	FEED
	3	10000	700	10000	900
	4	10000	900	10000	1100
	5	10000	1000	10000	1300
	6	10000	1200	10000	1500
	8	8000	1400	8000	1800
	10	8000	1700	8000	2100
	12	8000	2100	8000	2600
	14	6000	1800	6000	2200
	16	6000	1900	6000	2400
	18	4000	1400	4000	1800
	20	4000	1600	4000	1900



A:  $\phi 3 \sim \phi 10 = 0.25 \times D$   
 $\phi 12 \sim \phi 20 = 0.5 \times D$

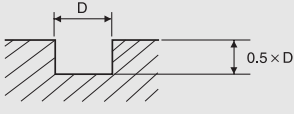


RPM=REVOLUTION PER MIN.  
FEED=mm/min.

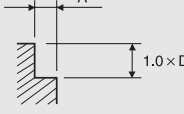
## 2 FL. 45° HELIX for ALUMINUM, TiCN COATED

### ■ EG522, EG521

MATERIAL	ALUMINUM LOW SILICON ALUMINUM				
	DIAMETER	RPM	FEED	RPM	FEED
	3	13000	900	13000	1200
	4	13000	1200	13000	1400
	5	13000	1300	13000	1700
	6	13000	1500	13000	2000
	8	10000	1800	10000	2300
	10	10000	2200	10000	2700
	12	10000	2700	10000	3400
	14	8000	2300	8000	2800
	16	8000	2500	8000	3100
	18	5000	1800	5000	2300
	20	5000	2000	5000	2500



A:  $\phi 3 \sim \phi 10 = 0.25 \times D$   
 $\phi 12 \sim \phi 20 = 0.5 \times D$



RPM=REVOLUTION PER MIN.  
FEED=mm/min.

## 2 FL. CORNER RADIUS for ALUMINUM, TiCN COATED

### ■ EG909

MATERIAL	ALUMINUM ALUMINUM ALLOY				COPPER ALLOY			
	DIAMETER	RPM	FEED(mm/min)	RPM	FEED(mm/min)	RPM	FEED(mm/min)	RPM
R0.3 ×4	13000	1200	13000	1400	3900	300	3900	350
R0.5 ×6	13000	1500	13000	2000	3900	380	3900	500
R0.6 ×8	10000	1800	10000	2300	3000	450	3000	580
R0.8 ×10	10000	2200	10000	2700	3000	550	3000	680
R1.0 ×12	10000	2700	10000	3400	3000	680	3000	850
R1.3 ×16	8000	2500	8000	3100	2400	630	2400	780
R1.6 ×20	5000	2000	5000	2500	1500	500	1500	630

A: ~  $\phi 10=0.25D$   
 $\phi 12 \sim \phi 20=0.5D$

A: ~  $\phi 10=0.25D$   
 $\phi 12 \sim \phi 20=0.5D$

RPM=REVOLUTION PER MIN.  
FEED=mm/min.

## 2 FL. BALL NOSE for ALUMINUM, TiCN COATED

### ■ EG910

MATERIAL	ALUMINUM ALUMINUM ALLOY		COPPER ALLOY	
	DIAMETER	FEED	RPM	FEED
R3.0 ×6	18000	1750	5500	440
R4.0 ×8	14000	2000	4200	500
R5.0 ×10	14000	2350	4200	580
R6.0 ×12	14000	3000	4200	750
R8.0 ×16	11000	2700	3300	670
R10.0 ×20	7000	2200	2100	550

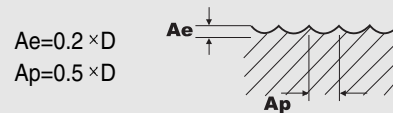
$A_e=0.2 \times D$   
 $A_p=0.5 \times D$

RPM=REVOLUTION PER MIN.  
FEED=mm/min.

### 3 FL. BALL NOSE for ALUMINUM, TiCN COATED

#### ■ EG908

MATERIAL	ALUMINUM LOW SILICON ALUMINUM		COPEER ALLOYS	
	RPM	FEED	RPM	FEED
<b>R1.0 × 2</b>	27000	950	8000	240
<b>R1.25 × 2.5</b>	22000	950	6500	240
<b>R1.5 × 3</b>	18000	950	5500	240
<b>R2.0 × 4</b>	18000	1250	5500	310
<b>R2.5 × 5</b>	18000	1350	5500	340
<b>R3.0 × 6</b>	18000	1750	5500	440
<b>R4.0 × 8</b>	14000	2000	4200	500
<b>R5.0 × 10</b>	14000	2350	4200	580
<b>R6.0 × 12</b>	14000	3000	4200	750
<b>R8.0 × 16</b>	11000	2700	3300	670

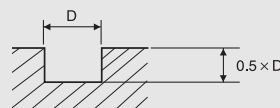
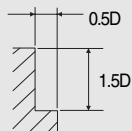


RPM=REVOLUTION PER MIN.  
FEED=mm/min.

### 3 FL. ROUGHING for ALUMINUM, TiCN COATED

#### ■ EP922, EP923, EP924, EP925

MATERIAL	ALUMINUM ALUMINUM ALLOY			
	RPM	FEED	RPM	FEED
<b>12</b>	2800	550	2800	410
<b>16</b>	2200	625	2200	465
<b>20</b>	1700	700	1700	525
<b>25</b>	1400	625	1400	465
<b>32</b>	1100	700	1100	525



RPM=REVOLUTION PER MIN.  
FEED=mm/min.