

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 3 FLUTE LONG LENGTH ROUGHING
VOLLHARTMETALL, 3 SCHNEIDEN LANG SCHRUPPFRÄSER

for ALUMINUM
für ALUMINIUM



Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
E5742060	6.0	6	16	57
E5742070	7.0	8	16	63
E5742080	8.0	8	16	63
E5742090	9.0	10	19	72
E5742100	10.0	10	22	72
E5742120	12.0	12	26	83
E5742140	14.0	14	26	83
E5742160	16.0	16	32	92
E5742180	18.0	18	32	92
E5742200	20.0	20	38	104
E5742250	25.0	25	45	121

► TiN, TiCN-COATING & TiAlN-COATING are available on your request.

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
h10	0 - 40	0 - 48	0 - 58	0 - 70	0 - 84
h6	0 - 6	0 - 8	0 - 9	0 - 11	0 - 13

◎ : Excellent ○ : Good

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

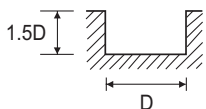


RECOMMENDED CUTTING CONDITIONS
EMPHOHLENE SCHNEIDKONDITIONEN

CARBIDE, 3 FLUTE ROUGHING
VOLLHARTMETALL, 3 SCHNEIDEN SCHRUPPFÄRER

E5742, E5711 SERIES <Slotting>

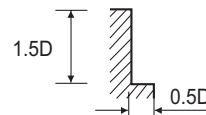
MATERIAL	ALUMINUM NONFERROUS METALS	
DIAMETER	RPM	FEED
6.0	10500	800
8.0	8000	700
10.0	6500	750
12.0	5250	800
16.0	4000	800
20.0	3200	800



RPM = rev./min.
FEED = mm/min.

E5742, E5711 SERIES <Side Cutting>

MATERIAL	ALUMINUM NONFERROUS METALS	
DIAMETER	RPM	FEED
6.0	10500	800
8.0	8000	700
10.0	6500	750
12.0	5250	800
16.0	4000	800
20.0	3200	800

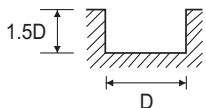


RPM = rev./min.
FEED = mm/min.

CARBIDE, 3 FLUTE ROUGHING TiCN-COATED
VOLLHARTMETALL, 3 SCHNEIDEN SCHRUPPFÄRER TiCN-BESCHICHTET

E5742, E5711 SERIES <Slotting>

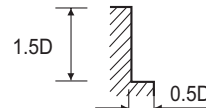
MATERIAL	ALUMINUM NONFERROUS METALS	
DIAMETER	RPM	FEED
6.0	13500	1050
8.0	10500	900
10.0	8500	1000
12.0	6800	1050
16.0	5200	1050
20.0	4200	1050



RPM = rev./min.
FEED = mm/min.

E5742, E5711 SERIES <Side Cutting>

MATERIAL	ALUMINUM NONFERROUS METALS	
DIAMETER	RPM	FEED
6.0	13500	1050
8.0	10500	900
10.0	8500	950
12.0	6800	1050
16.0	5200	1050
20.0	4200	1050



RPM = rev./min.
FEED = mm/min.