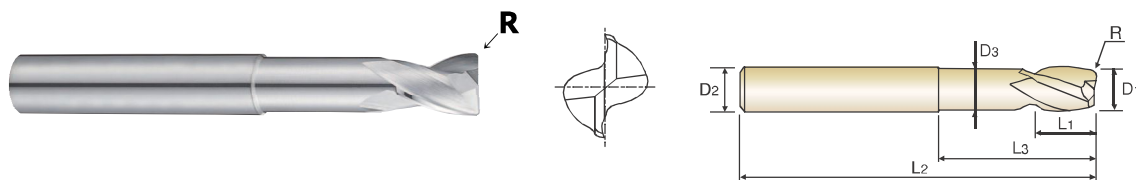


## CARBIDE, 2 FLUTE CORNER RADIUS with NECK

### VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS mit ABGESETZTEM SCHAFTTETTEL

- ▶ Excellent cutting qualities on aluminum, copper
- ▶ Increased tool life and higher cutting accuracy
- ▶ Mirror surface - Excellent surface finishes

- ▶ Ausgezeichnete Schneideigenschaften in Aluminium, Kupfer
- ▶ Verbesserte Standzeiten und höhere Fräsgenauigkeit.
- ▶ Spiegel-Oberfläche - Hervorragendes Oberflächenfinishing.



Unit : mm

| EDP No.         | Corner Radius | Mill Diameter | Shank Diameter | Length of Cut | Length Below Shank | Overall Length | Neck Diameter |
|-----------------|---------------|---------------|----------------|---------------|--------------------|----------------|---------------|
|                 | R             | D1            | D2             | L1            | L3                 | L2             | D3            |
| <b>E5909040</b> | RO.3          | <b>4.0</b>    | 6              | 5             | 10                 | 50             | 3.6           |
| <b>E5909060</b> | RO.5          | <b>6.0</b>    | 6              | 8             | 20                 | 60             | 5.4           |
| <b>E5909080</b> | RO.6          | <b>8.0</b>    | 8              | 10            | 30                 | 70             | 7.2           |
| <b>E5909100</b> | RO.8          | <b>10.0</b>   | 10             | 12            | 36                 | 80             | 9             |
| <b>E5909120</b> | R1.0          | <b>12.0</b>   | 12             | 14            | 40                 | 90             | 11            |
| <b>E5909160</b> | R1.3          | <b>16.0</b>   | 16             | 18            | 45                 | 100            | 14.5          |
| <b>E5909200</b> | R1.6          | <b>20.0</b>   | 20             | 24            | 45                 | 100            | 18            |

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

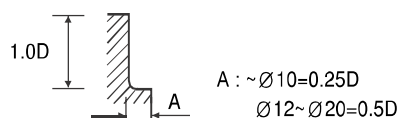
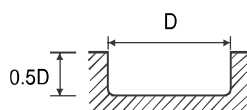
| Mill Dia.<br>Tolerance(mm) | Shank Dia.<br>Tolerance |
|----------------------------|-------------------------|
| 0~-0.03                    | h6                      |

◎ : Excellent ○ : Good

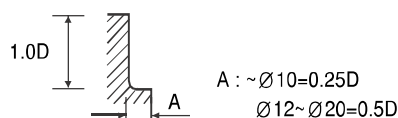
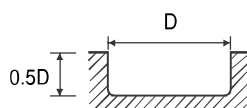
| Carbon Steels | Alloy Steels | Prehardened Steels | Hardened Steels |          | High Hardened Steels | Copper | Graphite | Cast Iron | Aluminum | Stainless Steels | Titanium | Inconel | Acrylic | CFRP |
|---------------|--------------|--------------------|-----------------|----------|----------------------|--------|----------|-----------|----------|------------------|----------|---------|---------|------|
| ~HB225        | HB225~325    | HRC30~40           | HRc40~45        | HRc45~55 | HRc55~70             |        |          |           |          |                  |          |         |         |      |
|               |              |                    |                 |          |                      | ○      |          |           | ◎        |                  |          |         |         |      |

**CARBIDE, 2 FLUTE CORNER RADIUS with NECK**  
**VOLLHARTMETALL, 2 SCHNEIDEN ECKENRADIUS mit ABGESETZTEM SCHAFTTETEL**
**E5909** SERIES

| MATERIAL | ALUMINUM<br>ALUMINUM ALLOY |      |     |       |       |      |     |       |
|----------|----------------------------|------|-----|-------|-------|------|-----|-------|
| DIAMETER | RPM                        | FEED | Vc  | Fz    | RPM   | FEED | Vc  | Fz    |
| 4.0      | 10400                      | 960  | 130 | 0.046 | 10400 | 1120 | 130 | 0.054 |
| 6.0      | 10400                      | 1200 | 195 | 0.058 | 10400 | 1600 | 195 | 0.077 |
| 8.0      | 8000                       | 1440 | 200 | 0.090 | 8000  | 1840 | 200 | 0.115 |
| 10.0     | 8000                       | 1760 | 250 | 0.110 | 8000  | 2160 | 250 | 0.135 |
| 12.0     | 8000                       | 2160 | 300 | 0.135 | 8000  | 2720 | 300 | 0.170 |
| 16.0     | 6400                       | 2000 | 320 | 0.156 | 6400  | 2480 | 320 | 0.194 |
| 20.0     | 4000                       | 1600 | 250 | 0.200 | 4000  | 2000 | 250 | 0.250 |



| MATERIAL | COPPER ALLOY |      |    |       |      |      |    |       |
|----------|--------------|------|----|-------|------|------|----|-------|
| DIAMETER | RPM          | FEED | Vc | Fz    | RPM  | FEED | Vc | Fz    |
| 4.0      | 3120         | 240  | 40 | 0.038 | 3120 | 280  | 40 | 0.045 |
| 6.0      | 3120         | 305  | 60 | 0.049 | 3120 | 400  | 60 | 0.064 |
| 8.0      | 2400         | 360  | 60 | 0.075 | 2400 | 465  | 60 | 0.097 |
| 10.0     | 2400         | 440  | 75 | 0.092 | 2400 | 545  | 75 | 0.114 |
| 12.0     | 2400         | 545  | 90 | 0.114 | 2400 | 680  | 90 | 0.142 |
| 16.0     | 1920         | 505  | 95 | 0.132 | 1920 | 625  | 95 | 0.163 |
| 20.0     | 1200         | 400  | 75 | 0.167 | 1200 | 505  | 75 | 0.210 |



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