# ALU-POWER END MILLS

PLAIN SHANK **E5908 SERIES**

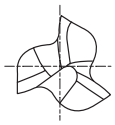
## CARBIDE, 3 FLUTE 40° HELIX BALL NOSE with NECK

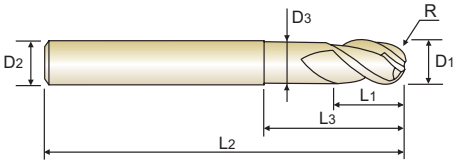
**VOLLHARTMETALL, 3 SCHNEIDEN 40° RECHTSSPIRALE STIRNRADIUS MIT ABGESETZTEM SCHAFTTETL**
**FRAISE CARBURE, 3 DENTS, HÉMISPHÉRIQUE, HÉLICE 40°, DÉTALONNÉE**
**3 TAGLIENTI, ELICA 40°, SEMISFERICA, SCARICATA**

- Excellent cutting qualities on aluminum and copper
- Increased tool life and higher cutting accuracy
- Mirror surface - Excellent surface finish

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






CARBIDE | 3 | 40° | R ±0.02 | PLAIN | UNCOATED

p.C536

| Recommended ToolHolder | Flat Shank | Plain Shank |
|---|---|---|
| | END MILL HOLDER | HYDRAULIC CHUCK |
| | | SHRINK FIT HOLDER |
| | | POWER MILLING CHUCK |
| | - | ER COLLET CHUCK |

Unit : mm

| EDP No. | Radius of Ball Nose | Mill Diameter | Shank Diameter | Length of Cut | Length Below Shank | Overall Length | Neck Diameter |
|---|---|---|---|---|---|---|---|
| | R(±0.02) | $D_1$ | $D_2$ | $L_1$ | $L_3$ | $L_2$ | $D_3$ |
| **E5908020** | R1.0 | **2.0** | 6 | 3 | 5 | 60 | 1.9 |
| **E5908025** | R1.25 | **2.5** | 6 | 4 | 6 | 60 | 2.4 |
| **E5908030** | R1.5 | **3.0** | 6 | 4.5 | 6.5 | 60 | 2.8 |
| **E5908035** | R1.75 | **3.5** | 6 | 5 | 7 | 65 | 3.2 |
| **E5908040** | R2.0 | **4.0** | 6 | 6 | 8 | 65 | 3.7 |
| **E5908050** | R2.5 | **5.0** | 6 | 7.5 | 10 | 65 | 4.6 |
| **E5908060** | R3.0 | **6.0** | 6 | 9 | 12 | 75 | 5.6 |
| **E5908080** | R4.0 | **8.0** | 8 | 12 | 25 | 75 | 7.4 |
| **E5908100** | R5.0 | **10.0** | 10 | 15 | 30 | 80 | 9.4 |
| **E5908120** | R6.0 | **12.0** | 12 | 18 | 36 | 90 | 11.4 |
| **E5908160** | R8.0 | **16.0** | 16 | 24 | 40 | 100 | 15.4 |

- TiN, TiCN and TiAlN Coatings are available on your request.

| Mill Dia. Tolerance(mm) | Shank Dia. Tolerance |
|---|---|
| 0 ~ - 0.03 | h5 |

◎ : Excellent ○ : Good

| ISO | P | | | | | | | | | | | M | | | K | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Material Description | Non-alloy steel | | | | | Low alloy steel | | | | High alloyed steel, and tool steel | | Stainless steel | | | Grey cast iron | | Nodular cast iron | | Malleable cast iron | |
| VDI 3323 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 |
| HRc | | 13 | 25 | 28 | 32 | 10 | 29 | 32 | 38 | 15 | 35 | 15 | 23 | 10 | 10 | 26 | 3 | 25 | | 21 |
| HB | 125 | 190 | 250 | 270 | 300 | 180 | 275 | 300 | 350 | 200 | 325 | 200 | 240 | 180 | 180 | 260 | 160 | 250 | 130 | 230 |
| Recommend | | | | | | | | | | | | | | | | | | | | |

| ISO | N | | | | | | | | | | S | | | | | | | H | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Material Description | Aluminum-wrought alloy | | Aluminum-cast, alloyed | | | Copper and Copper Alloys (Bronze / Brass) | | | Non Metallic Materials | | Heat Resistant Super Alloys | | | | | Titanium Alloys | | Hardened steel | | Chilled Cast Iron | Hardened Cast Iron |
| VDI 3323 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 | 41 |
| HRc | | | | | | | | | | | 15 | 30 | 25 | 38 | 34 | | | 55 | 60 | 42 | 55 |
| HB | 60 | 100 | 75 | 90 | 130 | 110 | 90 | 100 | | | 200 | 280 | 250 | 350 | 320 | 400 Rm | 1050 Rm | 550 | 630 | 400 | 550 |
| Recommend | ◎ | ◎ | ◎ | ◎ | ○ | ○ | ○ | ○ | | | | | | | | | | | | | |