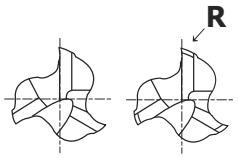
YG ALU-POWER END MILLS

E5981 SERIES PLAIN SHANK
E5983 SERIES PLAIN SHANK

CARBIDE, 3 FLUTE 45° HELIX REGULAR LENGTH & CORNER RADIUS

- ▶High velocity milling of aluminum & other non-ferrous materials.
- ▶3flute and 45° helix allow harmonic balance at high speed condition and smooth cutting.
- ▶Improved surface roughness-cylindrical margin which is controlled tightly
- ▶Maximum-metal removal rate.
- ▶Superior chip evacuation.
- ▶Mirror face-excellent surface finish.



MG | 3 | 45° | PLAIN P.723

◆ U.S.A Stock

■ SQUARE

Unit : Inch

EDP No. UNCOATED	EDP No. TiCN COATED	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
28558	**28558TC**	**1/8**	1/8	3/8	1-1/2
28565	**28565TC**	**3/16**	3/16	9/16	2
28573	**28573TC**	**1/4**	1/4	5/8	2-1/2
28579	**28579TC**	**5/16**	5/16	5/8	2-1/2
28584	**28584TC**	**3/8**	3/8	1	2-1/2
28588	**28588TC**	**7/16**	7/16	1-1/4	2-3/4
28593	**28593TC**	**1/2**	1/2	1-1/4	3
28595	**28595TC**	**5/8**	5/8	1-5/8	3-1/2
28598	**28598TC**	**3/4**	3/4	1-5/8	4
28600	**28600TC**	**1**	1	2	5

■ CORNER RADIUS

Unit : Inch

EDP No. UNCOATED	EDP No. TiCN COATED	Corner Radius R	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
EA50321	**EA50321C**	R.060	**1/2**	1/2	1-1/4	3
EA50401	**EA50401C**	R.060	**5/8**	5/8	1-5/8	3-1/2
EA50481	**EA50481C**	R.060	**3/4**	3/4	1-5/8	4
EA50641	**EA50641C**	R.065	**1**	1	2	5
EA20321	**EA20321C**	R.120	**1/2**	1/2	1-1/4	3
EA20401	**EA20401C**	R.120	**5/8**	5/8	1-5/8	3-1/2
EA20481	**EA20481C**	R.120	**3/4**	3/4	1-5/8	4
EA20641	**EA20641C**	R.120	**1**	1	2	5

Mill Dia. Tolerance (inch)	Shank Dia. Tolerance
0~-.0005	0~-.0003

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HRc20	HRc20~30	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
									◎			

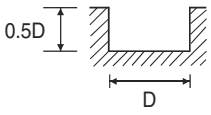
ALU-POWER END MILLS

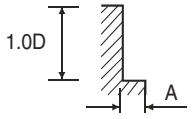
RECOMMENDED CUTTING CONDITIONS

CARBIDE, 3 FLUTE 45° HELIX FINISH

E5980, E5981, E5982, E5983, E5984 SERIES

MATERIAL	ALUMINUM NONFERROUS METALS		ALUMINUM NONFERROUS METALS	
DIAMETER	RPM	FEED	RPM	FEED
1/8	10000	33.1	10000	42.5
5/32	10000	42.5	10000	52.0
3/16	10000	47.3	10000	61.4
1/4	10000	56.7	10000	70.9
5/16	8000	66.2	8000	85.1
3/8	8000	80.3	8000	99.2
1/2	8000	99.2	8000	122.9
9/16	6000	85.1	6000	104.0
5/8	6000	89.8	6000	113.4
11/16	4000	66.2	4000	85.1
13/16	4000	75.6	4000	89.8





A : Ø1/8 ~ Ø3/8 = 0.25 × D
Ø1/2 ~ Ø13/16 = 0.5 × D

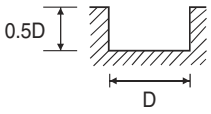
※ The Feed, in long & extra long types, should be reduced by around 50%.

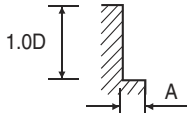
RPM = rev./min.
FEED = inch/min.

CARBIDE, 3 FLUTE 45° HELIX FINISH TiCN COATED

EG980, EG981, EG982, EG983, EG984 SERIES

MATERIAL	ALUMINUM NONFERROUS METALS		ALUMINUM NONFERROUS METALS	
DIAMETER	RPM	FEED	RPM	FEED
1/8	15600	43.0	12000	55.3
5/32	15600	55.3	12000	67.6
3/16	15600	61.4	12000	79.8
1/4	15600	73.7	12000	92.2
5/16	12000	86.0	9600	110.6
3/8	12000	104.4	9600	129.0
1/2	12000	128.9	9600	159.8
9/16	9600	110.6	7200	135.2
5/8	9600	116.7	7200	147.4
11/16	6000	86.0	4800	110.6
13/16	6000	98.3	4800	116.7





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RPM = rev./min.
FEED = inch/min.