



Being the best through innovation



HSS

SINE-POWER END MILLS

- High Performane HSS Rongher for Titanium and Titanium Alloys



E2F64 SERIES

4&6 FLUTE - SLOTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)						
						4FL			6FL			
						3/4	1	1 1/4	1	1 1/4	1 1/2	2
S	1-2	Titanium Alloys	1D	1D	SFM (Vc)	40	40	40	40	40	40	40
					IPT (fz)	.0025	.0033	.0041	.0022	.0027	.0033	.0066
					RPM	200	150	120	150	120	100	80
	IPM (FEED)		2	2	2	2	2	2	3			
	3-4		1D	1D	SFM (Vc)	65	65	65	65	65	65	65
					IPT (fz)	.0023	.0040	.0050	.0027	.0034	.0040	.0054
RPM		330			250	200	250	200	170	120		
IPM (FEED)	3	4	4	4	4	4	4					

4&6 FLUTE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)						
						4FL			6FL			
						3/4	1	1 1/4	1	1 1/4	1 1/2	2
S	1-2	Titanium Alloys	0.5D	1.5D	SFM (Vc)	60	60	60	60	60	60	60
					IPT (fz)	.0025	.0033	.0041	.0022	.0027	.0033	.0043
					RPM	310	230	180	230	180	150	120
	IPM (FEED)		3	3	3	3	3	3	3			
	3-4		0.5D	1.5D	SFM (Vc)	75	75	75	75	75	75	75
					IPT (fz)	.0026	.0035	.0044	.0023	.0029	.0035	.0047
RPM		380			290	230	290	230	190	140		
IPM (FEED)	4	4	4	4	4	4	4					

