



Aluminium endmill

# EPN-AL • EPA-AL

Volume 1.2



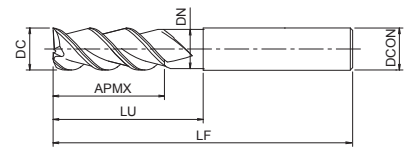
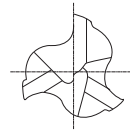
# KEY FEATURES: EPN-AL • EPA-AL SERIES

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# EPN-AL-3FS

Milling | Solid carbide



- Carbide end mill, bright finish
- For aluminium and copper alloys
- 3 flutes, short length of cut



line Plus
CARBIDE
40°
h6
h6
45°

EDP	ZEFP	DC	CHW	LU	LF	APMX	DCON	DN
EP019703	3	3	0,05	7	50	4	6	2,8
EP019704	3	4	0,05	8	54	5	6	3,8
EP019705	3	5	0,1	9	54	6	6	4,8
EP019706	3	6	0,1	15	54	7	6	5,8
EP019708	3	8	0,1	17	55	9	8	7,8
EP019710	3	10	0,1	20	60	11	10	9,8
EP019712	3	12	0,2	24	70	12	12	11,8
EP019716	3	16	0,2	28	80	16	16	15,8
EP019720	3	20	0,2	32	82	20	20	19,8

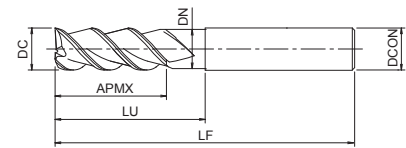
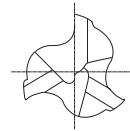
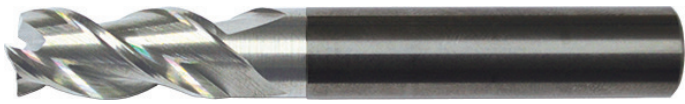
Milling | Solid carbide





# EPA-AL-3FS

Milling | Solid carbide



- Carbide end mill with ALC coating
- For aluminium and copper alloys
- 3 flutes, short length of cut



line  
**Plus**

CARBIDE

ALC

40°

h6

D=3  
-0,004 ~ +0,006

6 ≥ D > 3  
-0,006 ~ +0,006

10 ≥ D ≥ 8  
-0,007 ~ +0,006

16 ≥ D ≥ 12  
-0,009 ~ +0,006

D ≥ 20  
-0,011 ~ +0,006

45°

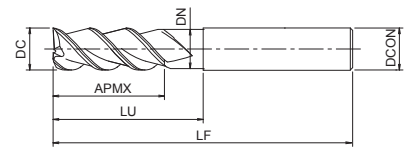
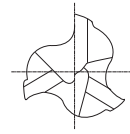
EDP	ZEFP	DC	CHW	LU	LF	APMX	DCON	DN
EP019903	3	3	0,05	7	50	4	6	2,8
EP019904	3	4	0,05	8	54	5	6	3,8
EP019905	3	5	0,1	9	54	6	6	4,8
EP019906	3	6	0,1	15	54	7	6	5,8
EP019908	3	8	0,1	17	55	9	8	7,8
EP019910	3	10	0,1	20	60	11	10	9,8
EP019912	3	12	0,2	24	70	12	12	11,8
EP019916	3	16	0,2	28	80	16	16	15,8
EP019920	3	20	0,2	32	82	20	20	19,8

Milling | Solid carbide



# EPA-AL-3FL

Milling | Solid carbide



- Carbide end mill with ALC coating
- For aluminium and copper alloys
- 3 flutes, long length of cut



CARBIDE

ALC

40°

h6



EDP	ZEFP	DC	CHW	LU	LF	APMX	DCON	DN
EP020003	3	3	0,05	12	57	9	6	2,9
EP020004	3	4	0,05	16	57	11	6	3,8
EP020005	3	5	0,1	18	57	13	6	4,8
EP020006	3	6	0,1	20	57	13	6	5,8
EP020008	3	8	0,1	25	63	19	8	7,8
EP020010	3	10	0,1	32	72	22	10	9,8
EP020012	3	12	0,2	38	83	26	12	11,8
EP020016	3	16	0,2	50	92	32	16	15,8
EP020020	3	20	0,2	62	104	38	20	19,8


Milling | Solid carbide

# CUTTING CONDITIONS


Milling | Endmills | Cutting conditions

## EPN-AL-3FS/FL

Side milling


	Aluminium wrought alloys	Aluminium cast alloy >5% Si <10% Si
Vc	400 - 600 (m/min)	350 - 500 (m/min)
Ø	fz (mm)	fz (mm)
3	0,027	0,024
4	0,036	0,032
5	0,045	0,041
6	0,054	0,049
8	0,072	0,065
10	0,090	0,081
12	0,108	0,097
16	0,144	0,130
20	0,195	0,175
ae max. 60% x D ap = 1xD		

Slotting


	Aluminium wrought alloys	Aluminium cast alloy >5% Si <10% Si
Vc	400 - 600 (m/min)	350 - 500 (m/min)
Ø	fz (mm)	fz (mm)
3	0,019	0,017
4	0,025	0,022
5	0,032	0,029
6	0,038	0,034
8	0,050	0,046
10	0,063	0,057
12	0,076	0,068
16	0,101	0,091
20	0,137	0,123
ap = 1xD		

## EPA-AL-3FS/FL

Side milling

	Aluminium wrought alloys	Aluminium cast alloy >5% Si <10% Si
Vc	500 - 800 (m/min)	400 - 700 (m/min)
Ø	fz (mm)	fz (mm)
3	0,027	0,024
4	0,036	0,032
5	0,045	0,041
6	0,054	0,049
8	0,072	0,065
10	0,090	0,081
12	0,108	0,097
16	0,144	0,130
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ap = 1xD		





shaping your dreams

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