











SELECTION GUIDE 选用指南



MILLING TOOLS

SERIES 系列	E2480	E2401	E2406	E2412	E2659	E2750	E2760	E2759	E2753	EL612
FLUTE 槽数	2	2	2	4	4	4	4-6 (Multi Flute)	4-6 (Multi Flute)	3-6 (Multi Flute)	1
HELIX ANGLE 螺旋角度	30°	30°	30°	30°	30°	30°	30°	30°	30°	≈ 30°
CUTTING EDGE SHAPE 类型	BALL NOSE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE	SQUARE ROUGHING-COARSE	SQUARE ROUGHING-COARSE	SQUARE ROUGHING-FINE	SQUARE
SIZE MIN 最小尺寸	R0.5	D1.0	D3.0	D1.0	D3.0	D16.0	D6.0	D10.0	D6.0	D3.0
SIZE MAX 最大尺寸	R25.0	D50.0	D50.0	D50.0	D50.0	D50.0	D50.0	D50.0	D40.0	D10.0
PAGE 页数	C582-583	C584-586	C587-588	C589-591	C592-593	C594	C595-596	C597	C598	C599
LENGTH	REGULAR LENGTH	REGULAR LENGTH	LONG LENGTH	REGULAR LENGTH CENTER CUTTING	LONG LENGTH CENTER CUTTING	EXTRA LONG LENGTH	SHORT LENGTH	LONG LENGTH	SHORT LENGTH	-
SURFACE TREATMENT	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated / TiAIN	Uncoated
Tool Material	HSSCo8	HSSCo8	HSSCo8	HSSCo8	HSSCo8	HSSCo8	HSSCo8	HSSCo8	HSSCo8	HSS-E

	E2480	E2401	E2406	E2412	E2659	E2750	E2760	E2759	E2753	EL612
										



Please visit globalyg1.com/mat for material search

◎ : Excellent (优秀)
○ : Good (良好)

ISO	VDI 3323	Material Description 工件材料	HB	HRc	E2480	E2401	E2406	E2412	E2659	E2750	E2760	E2759	E2753	EL612	
P	1	Non-alloy steel	125		◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○
	2		190	13	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○
	3		250	25	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	
	4		270	28	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	
	5	300	32	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		
	6	Low alloy steel	180	10	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○
	7		275	29	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	
	8		300	32	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	
	9		350	38	○	○	○	○	○	○	○	○	○	○	
	10		High alloyed steel, and tool steel	200	15	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
	11	325		35	○	○	○	○	○	○	○	○	○	○	
M	12	Stainless steel	200	15											
	13		240	23											
	14		180	10											
K	15	Grey cast iron	180	10											
	16		260	26											
	17	Nodular cast iron	160	3											
	18		250	25											
	19		130												
20	Malleable cast iron	230	21												
N	21	Aluminum-wrought alloy	60		○	○	○	○	○	○	○	○	○	○	◎
	22		100		○	○	○	○	○	○	○	○	○	○	◎
	23	Aluminum-cast, alloyed	75		○	○	○	○	○	○	○	○	○	○	◎
	24		90		○	○	○	○	○	○	○	○	○	○	◎
	25		130		○	○	○	○	○	○	○	○	○	○	○
	26		110												
	27	Copper and Copper Alloys (Bronze / Brass)	90												
	28		100												
	29		Non Metallic Materials												
	30	Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.													
S	31	Heat Resistant Super Alloys	200	15											
	32		280	30											
	33		250	25											
	34		350	38											
	35		320	34											
	36	Titanium Alloys	400 Rm												
	37		1050 Rm												
H	38	Hardened steel	550	55											
	39		630	60											
	40	Chilled Cast Iron	400	42											
	41	Hardened Cast Iron	550	55											