



7-fluted Carbide End Mills for Aerospace Alloys

EPL-TI-7FL-(CB)

Volume 1.1



KEY FEATURES: EPL-TI-7FL



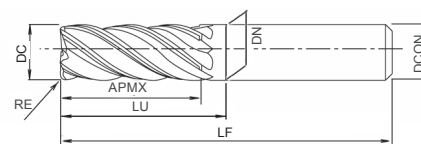
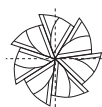
1 7-fluted carbide end mills for faster and more efficient material removal while reducing the potential of chip buildup and tool wear.

2 Low cutting force and high productivity

3 AlCrN coating.
Also available with chip breaker.



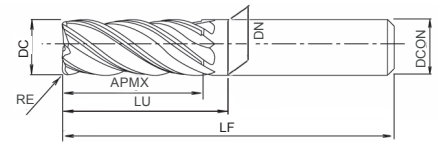
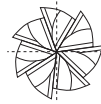
Milling | Solid carbide



- | | | | | |
|--|--|--|--|--|
| P  | M  | K  | S  | S  |
| ~45 HRC | | GGG | Ti | Ni |

[illegible]

Milling | Solid carbide



- Carbide end mills with AlCrN coating
- For Aerospace Alloys
- 7 flutes, centre cutting, square end and corner radius
- With Chipbreaker

[illegible]

CUTTING CONDITIONS

Milling | Endmills | Cutting conditions

EPL-TI-7FL

Side Milling

7 flute variable lead carbide endmill

		Mild Steels - Carbon Steels - Cast Iron Ap = up to Max LOC, Ae = 0.15xD			Tool Steel - Alloy Steel <30 HRC Ap = up to Max LOC, Ae = 0.15xD			Stainless Steel Ap = up to Max LOC, Ae = 0.1xD			Titanium Ap = up to Max LOC, Ae = 0.1xD			Inconel Ap = up to Max LOC, Ae = 0.1xD		
Vc		120 m/min			120 m/min			120 m/min			100 m/min			50 m/min		
Ø	Z	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)
10	7	3.820	2.675	0,100	3.820	2.675	0,100	3.180	1.560	0,070	3.180	1.560	0,070	1.590	780	0,070
12	7	3.180	2.450	0,110	3.180	2.450	0,110	2.650	1.575	0,085	2.650	1.575	0,085	1.330	700	0,075
16	7	2.390	2.010	0,120	2.390	2.010	0,120	1.990	1.395	0,100	1.990	1.395	0,100	990	555	0,080
20	7	1.910	1.740	0,130	1.910	1.740	0,130	1.590	1.335	0,120	1.590	1.335	0,120	800	505	0,090

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