



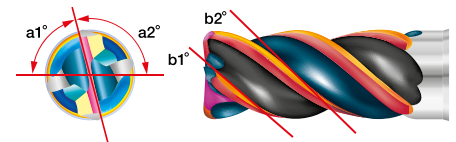
Solid Endmills – EPMS Type

Radius Endmills for Exotic Alloys

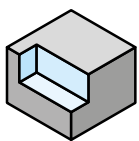


■ Features

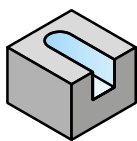
- Stable and reliable tool life
- Suitable for high efficiency milling process
- Suitable for Titanium structure parts for airplane
- Wide application range



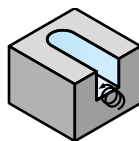
Irregular Pitch + Irregular Lead



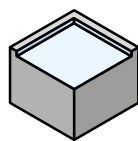
Side Milling



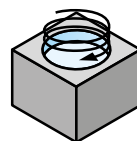
Slotting



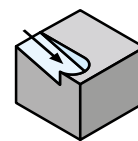
Trochoidal
Milling



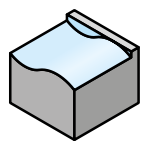
Face Milling



Helical Milling



Ramping

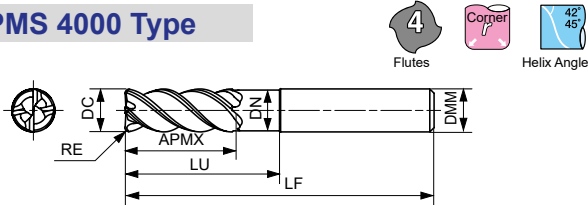


Profiling

EPMS Type

Body

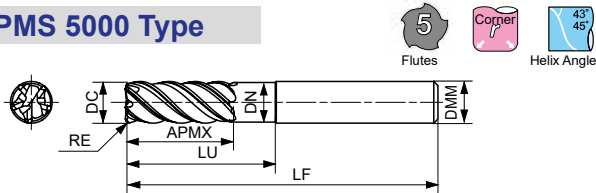
EPMS 4000 Type



Cat. No.	DC	RE	APMX	LU	DN	LF	DMM
EPMS 4100U2.5R10	10	1,0	25	32	9,5	72	10
4100U2.5R30	10	3,0	25	32	9,5	72	10
EPMS 4120U2.5R10	12	1,0	30	38	11,5	83	12
4120U2.5R30	12	3,0	30	38	11,5	83	12
4120U2.5R40	12	4,0	30	38	11,5	83	12
EPMS 4160U2.5R30	16	3,0	40	50	15,5	100	16
4160U2.5R40	16	4,0	40	50	15,5	100	16

Grade: ECS300

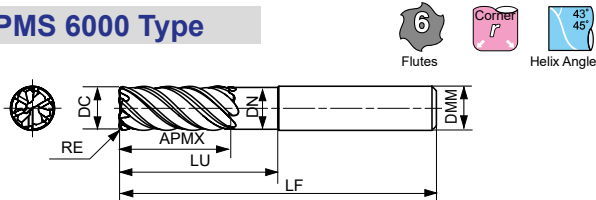
EPMS 5000 Type



Cat. No.	DC	RE	APMX	LU	DN	LF	DMM
EPMS 5100U2.5R025	10	0,25	25	32	9,5	72	10
5100U2.5R15	10	1,5	25	32	9,5	72	10
5100U2.5R25	10	2,5	25	32	9,5	72	10
EPMS 5120U2.5R025	12	0,25	30	38	11,5	83	12
5120U2.5R05	12	0,5	30	38	11,5	83	12
5120U2.5R15	12	1,5	30	38	11,5	83	12
5120U2.5R20	12	2,0	30	38	11,5	83	12
5120U2.5R25	12	2,5	30	38	11,5	83	12
EPMS 5160U2.5R30	16	3,0	40	50	15,5	100	16
5160U2.5R40	16	4,0	40	50	15,5	100	16
EPMS 5200U2.5R30	20	3,0	50	62	19,5	125	20
5200U2.5R40	20	4,0	50	62	19,5	125	20

Grade: ECS300

EPMS 6000 Type



Cat. No.	DC	RE	APMX	LU	DN	LF	DMM
EPMS 6100U2.5R10	10	1,0	25	32	9,5	72	10
6100U2.5R30	10	3,0	25	32	9,5	72	10
EPMS 6120U2.5R10	12	1,0	30	38	11,5	83	12
6120U2.5R30	12	3,0	30	38	11,5	83	12
6120U2.5R40	12	4,0	30	38	11,5	83	12
EPMS 6160U2.5R15	16	1,5	40	50	15,5	100	16
6160U2.5R30	16	3,0	40	50	15,5	100	16
6160U2.5R40	16	4,0	40	50	15,5	100	16
EPMS 6200U2.5R30	20	3,0	50	62	19,5	125	20
6200U2.5R40	20	4,0	50	62	19,5	125	20

Grade: ECS300

Cutting Conditions

Side Milling

Work Material	Titanium Alloy, Stainless Steel				
	Cond.	Spindle Speed (mm ⁻¹)	Feed Rate (mm/min)		
DC (mm)		EPMS4000	EPMS5000	EPMS6000	
10,0	3.200	1.280	1.920	3.840	
12,0	2.700	1.080	1.620	3.240	
16,0	2.000	800	1.200	2.400	
20,0	1.600	640	960	1.920	
a _e (mm), Standard -Max.		0,2-0,4 DC	0,1-0,3 DC	0,06-0,1 DC	
a _p (mm), Standard -Max.		2,0-2,5 DC			

Work Material	Heat-resistant Alloy				
	Cond.	Spindle Speed (mm ⁻¹)	Feed Rate (mm/min)		
DC (mm)		EPMS4000	EPMS5000	EPMS6000	
10,0	1.600	380	640	960	
12,0	1.300	310	520	780	
16,0	1.000	240	400	600	
20,0	800	190	320	480	
a _e (mm), Standard -Max.		0,2-0,4 DC	0,1-0,3 DC	0,06-0,1 DC	
a _p (mm), Standard -Max.		2,0-2,5 DC			

Slotting

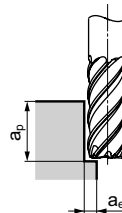
Work Material	Titanium Alloy, Stainless Steel				
	Cond.	Spindle Speed (mm ⁻¹)	Feed Rate (mm/min)		
DC (mm)		EPMS4000	EPMS5000	EPMS6000	
10,0	1.900	460	570	Not recommended	
12,0	1.600	380	480		
16,0	1.200	290	360		
20,0	960	230	290		
a _p (mm), Standard -Max.		1,0-1,5 DC	0,5-1,0 DC		

Work Material	Heat-resistant Alloy				
	Cond.	Spindle Speed (mm ⁻¹)	Feed Rate (mm/min)		
DC (mm)		EPMS4000	EPMS5000	EPMS6000	
10,0	960	230	290	Not recommended	
12,0	800	190	240		
16,0	600	140	180		
20,0	480	120	140		
a _p (mm), Standard -Max.		0,3-0,5 DC	0,2-0,4 DC		

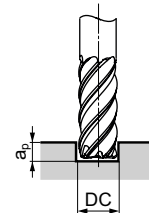
Ramping / Helical Milling

Body Type	EPMS4000	EPMS5000	EPMS6000
RPMX, Standard -Max.	2,0°-3,0°		

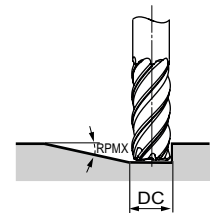
Side Milling



Slotting



Ramping



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