



EM818 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

EM828 SERIES

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 2 FLUTE LONG LENGTH CORNER RADIUS VOLLHARTMETALL, 2 SCHNEIDEN LANG ECKENRADIUS

- ▶ Designed to machine tool steel, alloy steel, mold steel and other high hardened materials.
- ▶ Superior workpiece finishes.
- ▶ Increased feed rates.

- ▶ Zur Bearbeitung: Werkzeugstählen, Legierten Stählen, Stahlguß und gehärteten Stählen.
- ▶ Bessere Werkstückoberflächen.
- ▶ Gesteigerte Vorschubrate.



P.671

Unit : mm

EDP No.		Corner Radius R	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT	R				
EM818030	EM828030	RO.3	3.0	6	12	50
EM818040	EM828040	RO.3	4.0	6	15	50
EM818911	EM828911	RO.5	4.0	6	15	50
EM818050	EM828050	RO.3	5.0	6	20	60
EM818912	EM828912	RO.5	5.0	6	20	60
EM818913	EM828913	RO.3	6.0	6	20	60
EM818060	EM828060	RO.5	6.0	6	20	60
EM818901	EM828901	R1.0	6.0	6	20	70
EM818914	EM828914	RO.3	8.0	8	25	70
EM818080	EM828080	RO.5	8.0	8	25	70
EM818902	EM828902	R1.0	8.0	8	25	70
EM818903	EM828903	R1.5	8.0	8	25	70
EM818904	EM828904	R2.0	8.0	8	25	70
EM818915	EM828915	RO.3	10.0	10	30	90
EM818100	EM828100	RO.5	10.0	10	30	90
EM818905	EM828905	R1.0	10.0	10	30	90
EM818906	EM828906	R1.5	10.0	10	30	90
EM818907	EM828907	R2.0	10.0	10	30	90
EM818120	EM828120	RO.5	12.0	12	30	90
EM818908	EM828908	R1.0	12.0	12	30	90
EM818909	EM828909	R1.5	12.0	12	30	90
EM818910	EM828910	R2.0	12.0	12	30	90
EM818160	EM828160	RO.5	16.0	16	50	110
EM818916	EM828916	R1.0	16.0	16	50	110
EM818917	EM828917	R1.5	16.0	16	50	110
EM818918	EM828918	R2.0	16.0	16	50	110
EM818200	EM828200	RO.5	20.0	20	55	110
EM818919	EM828919	R1.0	20.0	20	55	110
EM818920	EM828920	R1.5	20.0	20	55	110
EM818921	EM828921	R2.0	20.0	20	55	110

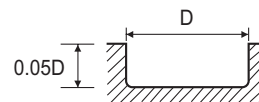
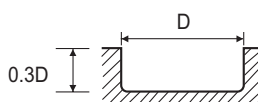
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRC30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	◎	◎	○								

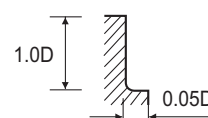
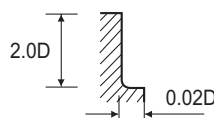
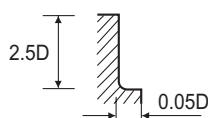
CARBIDE, 2 FLUTE LONG CORNER RADIUS - SLOTTING
VOLLHARTMETALL, 2 SCHNEIDEN LANG ECKENRADIUS - NUTENFRÄSEN
CARBIDE
HSS
CBN
END MILLS
i-Xmill
END MILLS
X5070
END MILLS
X-POWER
END MILLS
JET-POWER
END MILLS
V7 Mill INOX
END MILLS
V7 Mill STEEL
END MILLS
ALU-POWER
END MILLS
D-POWER
END MILLS
K-2 CARBIDE
END MILLS
GENERAL
CARBIDE
END MILLS
TANK-POWER
END MILLS
GENERAL
HSS
END MILLS
MILLING
CUTTERS
TECHNICAL
DATA
EM818, EM828 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55		HRc55 ~ HRc65	
STRENGTH	~ 1000N/mm ²		1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²		2000N/mm ² ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3.0	6620	140	4280	70	2640	35	1870	18
4.0	5360	170	3410	85	2150	40	1470	20
5.0	4580	210	2900	100	1900	50	1260	25
6.0	3950	250	2520	125	1640	60	1160	35
8.0	3000	270	1900	125	1260	60	840	35
10.0	2520	270	1640	125	1010	60	670	35
12.0	2060	210	1390	115	840	50	550	25
16.0	1740	190	1070	90	670	40	440	20
20.0	1260	140	820	60	500	30	340	15


RPM = rev./min.
FEED = mm/min.

CARBIDE, 4 FLUTE LONG CORNER RADIUS - SIDE CUTTING
VOLLHARTMETALL, 4 SCHNEIDEN LANG ECKENRADIUS - SEITENFRÄSEN
EM819, EM829 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55		HRc55 ~ HRc65	
STRENGTH	~ 1000N/mm ²		1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²		2000N/mm ² ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3.0	6620	170	4280	130	2640	65	1870	30
4.0	5360	210	3410	150	2150	70	1470	35
5.0	4580	215	2900	180	1900	85	1260	40
6.0	3950	215	2520	180	1640	85	1160	50
8.0	3000	230	1900	180	1260	85	840	50
10.0	2520	230	1640	180	1010	85	670	50
12.0	2060	180	1390	160	840	70	550	40
16.0	1740	160	1070	125	670	60	440	35
20.0	1260	115	820	90	500	45	340	25


RPM = rev./min.
FEED = mm/min.