



PLAIN SHANK
GLATTER ZYLINDERSCHAFT

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 6 FLUTE 45° HELIX LONG LENGTH CORNER RADIUS
VOLLHARTMETALL, 6 SCHNEIDEN 45° RECHTSSPIRALE LANG ECKENRADIUS

- ▶ Designed to machine high hardened materials.
- ▶ High speed cutting and finish milling with high feed rates.
- ▶ Superior workpiece finishes.
- ▶ Superior wear resistant.
- ▶ Suitable for dry milling.
- ▶ Geeignet zum Fräsen von Hochgehärteten Stählen.
- ▶ Hochgeschwindigkeitsfräsen und Finishing mit erhöhtem Vorschub.
- ▶ Bessere Werkstückoberflächen.
- ▶ Höhere Verschleißfestigkeit.
- ▶ Geeignet zum Trocken-Fräsen.



Unit : mm

EDP No.		Corner Radius R	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT					
EM835060	EM845060	RO.5	6.0	6	13	70
EM835080	EM845080	RO.5	8.0	8	19	90
EM835100	EM845100	RO.5	10.0	10	22	100
EM835901	EM845901	R1.0	10.0	10	22	100
EM835120	EM845120	RO.5	12.0	12	26	110
EM835902	EM845902	R1.0	12.0	12	26	110
EM835160	EM845160	R1.0	16.0	16	32	130
EM835903	EM845903	R1.5	16.0	16	32	130
EM835200	EM845200	R1.0	20.0	20	38	140
EM835904	EM845904	R1.5	20.0	20	38	140
EM835905	EM845905	R2.0	20.0	20	38	140

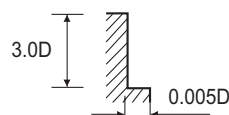
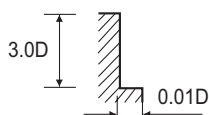
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6

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							
○	○	○	○	○				○				

◎ : Excellent ○ : Good

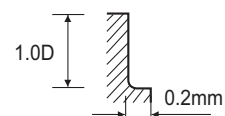
CARBIDE, 6 FLUTE 45° HELIX EXTRA LONG - SIDE CUTTING
VOLLHARTMETALL, 6 SCHNEIDEN 45° RECHTSSPIRALE EXTRA LANG - SEITENFRÄSEN
EM834, EM844 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS		ALLOY STEELS HEAT RESISTANT STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	~ HRc40		HRc40 ~ HRc50		HRc50 ~ HRc60		HRc60 ~ HRc65	
STRENGTH	~ 1250N/mm ²		1250 ~ 1750N/mm ²		1750 ~ 2080N/mm ²		2080N/mm ² ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	2230	470	1670	350	1390	250	1110	200
8.0	1670	450	1250	330	1050	240	840	180
10.0	1330	440	1000	300	840	230	680	160
12.0	1110	400	840	270	690	210	560	150
16.0	840	330	630	230	530	170	420	130
20.0	670	280	500	200	420	150	320	120
25.0	540	240	400	170	340	130	270	95


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

CARBIDE, 6 FLUTE 45° HELIX CORNER RADIUS - SIDE CUTTING
VOLLHARTMETALL, 6 SCHNEIDEN 45° RECHTSSPIRALE ECKENRADIUS - SEITENFRÄSEN
EM835, EM845 SERIES
HIGH SPEED

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	~ HRc50		HRc50 ~ HRc60		HRc60 ~ HRc65	
STRENGTH	~ 1750N/mm ²		1750 ~ 2080N/mm ²		2080N/mm ² ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED
6.0	16800	6090	8400	3050	4200	1470
8.0	12600	6090	6300	3050	3150	1470
10.0	9980	5990	5040	3050	2520	1470
12.0	8400	5040	4200	2520	2100	1260
16.0	6300	3780	3150	1890	1580	950
20.0	5040	3050	2520	1470	1260	760


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