



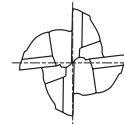
PLAIN SHANK  
GLATTER ZYLINDERSCHAFT

FLAT SHANK  
SEITLICHEN MITNAHMEFLÄCHEN

## CARBIDE, 4 FLUTE MULTIPLE HELIX SHORT LENGTH VOLLHARTMETALL, 4 SCHNEIDEN KURZ

- ▶ Special flute geometry and multiple helix eliminate vibrations
- ▶ Designed to machine mild steels, cast irons, tool steels, and low hardened steels up to HRc 40.
- ▶ Excellent work piece finishes.
- ▶ Higher speeds, deeper cuts, and higher metal removal rates.

- ▶ Besondere Nutenform und variable Drallsteigung verhindern Vibrationen.
- ▶ Für die Bearbeitung von Baustahl, Guss, Werkzeugstahl und niedrig legierten Stählen bis HRc40.
- ▶ Ausgezeichnete Werkstückoberfläche.
- ▶ Höhere Schnittgeschwindigkeit, tieferer Schnitt und größeres Entspannungsvolumen.



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT				
EMD42030	EMD43030	3.0	6	5	50
EMD42040	EMD43040	4.0	6	8	54
EMD42050	EMD43050	5.0	6	9	54
EMD42060	EMD43060	6.0	6	10	54
EMD42080	EMD43080	8.0	8	12	58
EMD42100	EMD43100	10.0	10	14	66
EMD42120	EMD43120	12.0	12	16	73
EMD42140	EMD43140	14.0	14	18	75
EMD42160	EMD43160	16.0	16	22	82
EMD42180	EMD43180	18.0	18	24	84
EMD42200	EMD43200	20.0	20	26	92

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



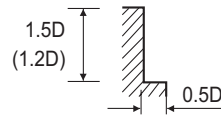
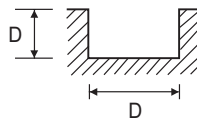
**V7 Mill STEEL  
END MILLS**

**RECOMMENDED CUTTING CONDITIONS  
EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 4 FLUTE  
VOLLHARTMETALL, 4 SCHNEIDEN**

**EMD42, EMD43, EMD44, EMD45, EMD38, EMD39, EMD40, EMD41, EMD46, EMD47, EMD48, EMD49** SERIES

MATERIAL	ALLOY STEELS CAST IRON		ALLOY STEELS CAST IRON	
HARDNESS	~ HB 300		HB 300 ~ HB 380	
STRENGTH	~ 1000N/mm <sup>2</sup>		1000 ~ 1300N/mm <sup>2</sup>	
DIAMETER	RPM	FEED	RPM	FEED
3.0	13475	275	9430	190
4.0	10105	330	7070	230
5.0	8085	370	5660	260
6.0	6735	435	4715	305
8.0	5050	555	3535	385
10.0	4455	690	3115	480
12.0	3710	695	2600	485
14.0	3180	620	2225	435
16.0	2785	590	1950	410
18.0	2475	585	1730	410
20.0	2225	580	1560	405
25.0	1780	450	1245	315



\* ( ) : Short length Type

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