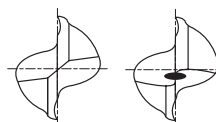


CARBIDE, 2 FLUTE SHORT LENGTH VOLLHARTMETALL, 2 SCHNEIDEN KURZ

- ▶ 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.
- ▶ Höhere Vorschübe.



up to Ø3mm over Ø3mm



P.656

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT				
EM810901	EM820901	1.0	6	2.5	40
EM810902	EM820902	1.5	6	4	40
EM810020	—	2.0	4	6	40
EM810903	EM820020	2.0	6	6	40
EM810025	—	2.5	4	8	40
EM810904	EM820903	2.5	6	8	40
EM810030	EM820030	3.0	6	8	45
EM810035	EM820035	3.5	6	10	45
EM810040	EM820040	4.0	6	11	45
EM810045	EM820045	4.5	6	11	45
EM810050	EM820050	5.0	6	13	50
EM810055	EM820055	5.5	6	13	50
EM810060	EM820060	6.0	6	13	50
EM810065	EM820065	6.5	8	16	60
EM810070	EM820070	7.0	8	16	60
EM810075	EM820075	7.5	8	16	60
EM810080	EM820080	8.0	8	19	60
EM810085	EM820085	8.5	10	19	70
EM810090	EM820090	9.0	10	19	70
EM810095	EM820095	9.5	10	19	70
EM810100	EM820100	10.0	10	22	70
EM810105	EM820105	10.5	12	22	75
EM810110	EM820110	11.0	12	22	75
EM810115	EM820115	11.5	12	22	75

◎ : 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							
○	◎	◎	◎	○				○		○		

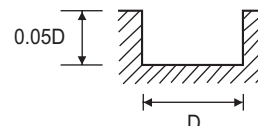
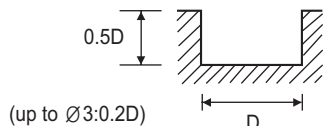


RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 2 FLUTE SHORT - SLOTTING
VOLLHARTMETALL, 2 SCHNEIDEN KURZ - NUTENFRÄSEN

EM810, EM820 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		STAINLESS 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	RPM	FEED
2.0	9250	190	6050	120	5050	90	4030	35		
3.0	7150	210	4450	140	3700	120	2690	40	1900	40
4.0	6050	300	3700	180	3100	150	2350	40	1480	40
5.0	5050	320	3020	190	2530	160	1860	50	1260	40
6.0	4450	350	2690	220	2270	180	1600	55	1100	40
8.0	3360	380	2020	200	1680	180	1350	75	840	40
10.0	2600	330	1600	160	1350	160	1090	60	680	35
12.0	2200	280	1350	130	1090	130	930	55	560	35
16.0	1760	220	1090	110	850	110	720	40	440	20
20.0	1350	170	850	80	670	80	550	30	320	20
25.0	1090	130	670	70	550	60	430	20	260	15



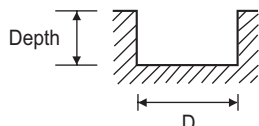
RPM = rev./min.
FEED = mm/min.

CARBIDE, 2 FLUTE MINIATURE - SLOTTING
VOLLHARTMETALL, 2 SCHNEIDEN MINI - NUTENFRÄSEN

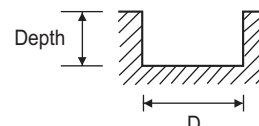
EM810 SERIES

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS		HARDENED STEELS	
HARDNESS	HRC30 ~ HRC45		HRC45 ~ HRC55	
STRENGTH	1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²	
DIAMETER	RPM	FEED	RPM	FEED
0.4	30000	90	23000	50
0.8	24000	150	18000	65
1.0	20000	160	15000	75
1.2	16000	160	12000	75
1.5	12000	150	9000	70

D < 1
Depth=0.15 × D
D > 1
Depth=0.25 × D



D < 1
Depth=0.02 × D
D > 1
Depth=0.05 × D



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