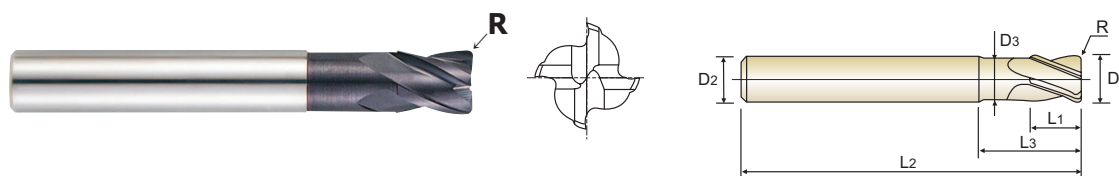


## CARBIDE, 4 FLUTE STUB LENGTH CORNER RADIUS VOLLHARTMETALL, 4 SCHNEIDEN EXTRA KURZ ECKENRADIUS

- ▶ 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.



Unit : mm

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
PLAIN	FLAT	R	D1	D2	L1	L3	L2	D3
EM839020	EM849020	RO.2	2.0	6	2.5	5	50	1.9
EM839025	EM849025	RO.25	2.5	6	3	6	50	2.4
EM839030	EM849030	RO.3	3.0	6	4	7	50	2.8
EM839035	EM849035	RO.35	3.5	6	4.5	8	50	3.2
EM839040	EM849040	RO.4	4.0	6	5	9	50	3.7
EM839050	EM849050	RO.5	5.0	6	6	12	50	4.6
EM839060	EM849060	RO.6	6.0	6	7	14	55	5.6
EM839080	EM849080	RO.8	8.0	8	10	18	60	7.4
EM839100	EM849100	R1.0	10.0	10	12	25	70	9.4
EM839120	EM849120	R1.2	12.0	12	15	30	80	11.4
EM839160	EM849160	R1.6	16.0	16	18	35	90	15.4

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							
○	◎	◎	◎	○				○				



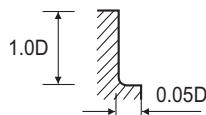
**X-POWER  
END MILLS**

**RECOMMENDED CUTTING CONDITIONS  
EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 4 FLUTE STUB CORNER RADIUS - SIDE CUTTING  
VOLLHARTMETALL, 4 SCHNEIDEN EXTRA KURZ ECKENRADIUS - SEITENFRÄSEN**

**EM839, EM849 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 <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>		1500 ~ 2000N/mm <sup>2</sup>		2000N/mm <sup>2</sup> ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.0	13870	340	9070	205	6050	60		
2.5	12290	360	7870	220	5040	65		
3.0	10700	385	6670	240	4030	70	2280	70
3.5	9890	535	6100	330	3780	70	2030	70
4.0	9070	685	5540	420	3530	70	1780	70
5.0	7560	720	4540	430	2780	85	1510	70
6.0	6670	790	4030	490	2400	95	1320	70
8.0	5040	850	3020	455	2020	130	1010	70
10.0	3910	730	2400	360	1630	110	820	60
12.0	3290	625	2020	300	1390	95	670	60
16.0	2640	490	1630	240	1080	70	530	35

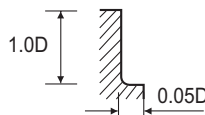


RPM = rev./min.  
FEED = mm/min.

**CARBIDE, 6 FLUTE STUB CORNER RADIUS - SIDE CUTTING  
VOLLHARTMETALL, 6 SCHNEIDEN EXTRA KURZ ECKENRADIUS - SEITENFRÄSEN**

**EM897, EM898 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 <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>		1500 ~ 2000N/mm <sup>2</sup>		2000N/mm <sup>2</sup> ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	6670	790	4030	490	2400	95	1320	70
8.0	5040	850	3020	455	2020	130	1010	70
10.0	3910	730	2400	360	1630	110	820	60
12.0	3290	625	2020	300	1390	95	670	60



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