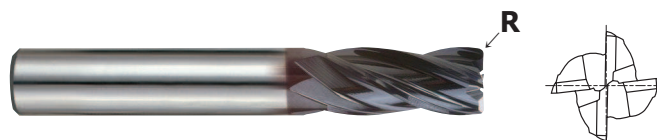


CARBIDE, 4 FLUTE MULTIPLE HELIX LONG LENGTH CORNER RADIUS VOLLHARTMETALL, 4 SCHNEIDEN LANG ECKENRADIUS

- ▶ 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.		Corner Radius R	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT					
EMD40030	EMD41030	RO.3	3.0	6	8	57
EMD40040	EMD41040	RO.3	4.0	6	11	57
EMD40050	EMD41050	RO.3	5.0	6	13	57
EMD40060	EMD41060	RO.4	6.0	6	13	57
EMD40080	EMD41080	RO.4	8.0	8	19	63
EMD40100	EMD41100	RO.4	10.0	10	22	72
EMD40120	EMD41120	RO.6	12.0	12	26	83
EMD40140	EMD41140	RO.6	14.0	14	26	83
EMD40160	EMD41160	RO.8	16.0	16	32	92
EMD40180	EMD41180	RO.8	18.0	18	32	92
EMD40200	EMD41200	RO.8	20.0	20	38	104
EMD40250	EMD41250	RO.8	25.0	25	38	104

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							
◎	◎	◎	○	○				○				

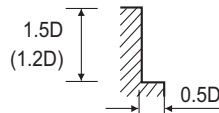
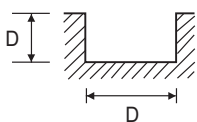


RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

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	
	RPM	FEED	RPM	FEED
HARDNESS	~ HB 300		HB 300 ~ HB 380	
STRENGTH	~ 1000N/mm ²		1000 ~ 1300N/mm ²	
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.