

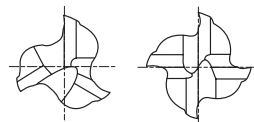
PLAIN SHANK  
GLATTER ZYLINDERSCHAFT

FLAT SHANK  
SEITLICHE MITNAHMEFLÄCHEN

## CARBIDE, 3&4 FLUTE 50° HELIX LONG LENGTH VOLLHARTMETALL, 3&4 SCHNEIDEN 50° RECHTSSPIRALE LANG

- ▶ Ultra micro grain carbide
- ▶ Reduces chipping of corner edges
- ▶ Suitable for low hardness materials (under HRC45), alloy steels, tool steels, carbon steels, prehardened steels, stainless steels, etc

- ▶ Ultra Feinstkorn - Vollhartmetall
- ▶ Verstärkte Schneidkante.
- ▶ zur Bearbeitung von: Werkstoffen bis 45 HRc, rostfreien Stählen, Titan und Nickellegierungen.

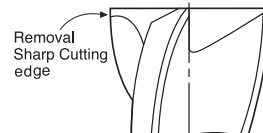


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Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
PLAIN	FLAT					
EH830060	EH840060	6.0	6	13	50	3
EH830080	EH840080	8.0	8	19	60	3
EH830100	EH840100	10.0	10	22	70	3
EH830120	EH840120	12.0	12	25	75	3
EH830160	EH840160	16.0	16	32	90	3
EH830180	EH840180	18.0	18	32	90	3
EH830200	EH840200	20.0	20	38	100	4
EH830250	EH840250	25.0	25	45	120	4

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

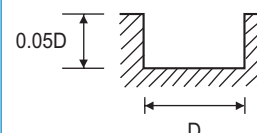
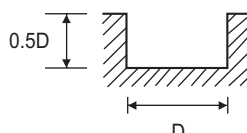


Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	○	○	○							○	○	○

◎ : Excellent ○ : Good

**CARBIDE, 3&4 FLUTE 50° HELIX LONG - SLOTTING  
VOLLHARTMETALL, 3&4 SCHNEIDEN 50° RECHTSSPIRALE LANG - NUTENFRÄSEN**
**EH830, EH840 SERIES**

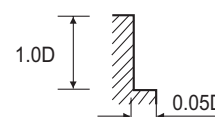
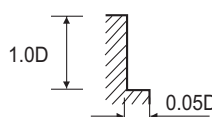
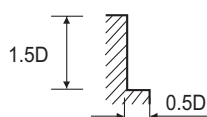
MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		STAINLESS STEELS TITANIUM ALLOY		INCONEL	
	~ HRc30		HRc30 ~ HRc45					
HARDNESS	~ HRc30		HRc30 ~ HRc45					
STRENGTH	1000N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>					
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	5560	310	3360	200	2840	160	1160	40
8.0	4200	340	2520	180	2100	160	840	40
10.0	3260	300	2000	140	1680	140	670	40
12.0	2740	250	1680	120	1370	120	560	30
16.0	2200	200	1360	100	1050	100	420	25
18.0	1940	175	1210	85	950	85	370	20
20.0	1680	150	1060	70	840	70	320	20
25.0	1360	115	840	60	670	60	270	15



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

**CARBIDE, 3&4 FLUTE 50° HELIX - SIDE CUTTING  
VOLLHARTMETALL, 3&4 SCHNEIDEN 50° RECHTSSPIRALE - SEITENFRÄSEN**
**EH830, EH840 SERIES**

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		STAINLESS STEELS TITANIUM ALLOY		INCONEL	
	~ HRc30		HRc30 ~ HRc45					
HARDNESS	~ HRc30		HRc30 ~ HRc45					
STRENGTH	1000N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>					
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	5560	400	3360	250	2840	250	1050	55
8.0	4200	420	2520	230	2100	265	840	50
10.0	3260	370	2000	180	1680	230	680	50
12.0	2740	310	1680	150	1370	180	560	45
16.0	2200	250	1360	120	1050	150	420	35
18.0	1940	220	1210	110	950	130	370	30
20.0	1680	190	1060	95	840	115	340	30
25.0	1360	150	840	75	670	90	270	25



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