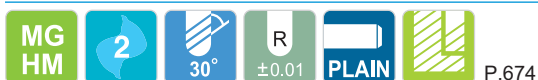
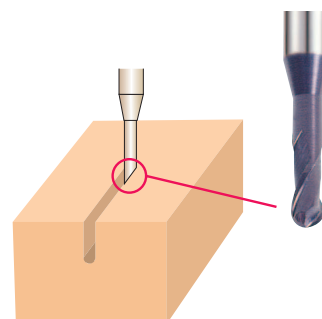
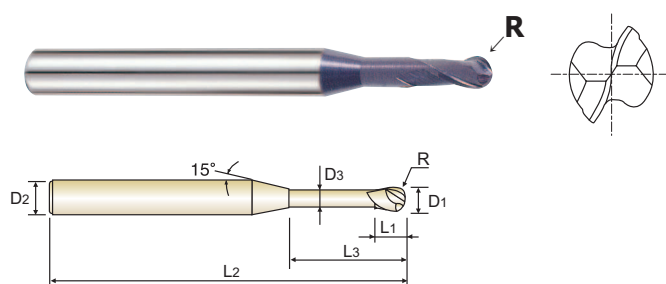


CARBIDE, 2 FLUTE BALL NOSE for RIB PROCESSING

VOLLHARTMETALL, 2 SCHNEIDEN STIRNRADIUS für SCHMALE RIPPEN



Unit : mm

EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
PLAIN	R (±0.01)	D1	D2	L1	L3	L2	D3
EM886968	R1.5	3.0	6	4.5	25	65	2.85
EM886969	R1.5	3.0	6	4.5	30	70	2.85
EM886970	R1.5	3.0	6	4.5	35	80	2.85
EM886949	R2.0	4.0	6	6	10	60	3.85
EM886950	R2.0	4.0	6	6	12	60	3.85
EM886040	R2.0	4.0	6	6	16	60	3.85
EM886912	R2.0	4.0	6	6	20	65	3.85
EM886913	R2.0	4.0	6	6	25	70	3.85
EM886971	R2.0	4.0	6	6	30	70	3.85
EM886972	R2.0	4.0	6	6	35	80	3.85
EM886973	R2.0	4.0	6	6	40	90	3.85
EM886974	R2.0	4.0	6	6	45	90	3.85
EM886975	R2.0	4.0	6	6	50	100	3.85
EM886050	R2.5	5.0	6	7.5	16	60	4.85
EM886951	R2.5	5.0	6	7.5	20	60	4.85
EM886952	R2.5	5.0	6	7.5	25	70	4.85
EM886953	R2.5	5.0	6	7.5	30	80	4.85
EM886976	R2.5	5.0	6	7.5	35	80	4.85
EM886060	R3.0	6.0	6	9	20	80	5.85
EM886954	R3.0	6.0	6	9	30	90	5.85
EM886955	R3.0	6.0	6	9	40	100	5.85
EM886956	R3.0	6.0	6	9	50	110	5.85

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.02	h6

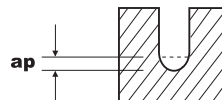
◎ : Excellent ○ : Good

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							
○	◎	◎	◎	○			○				

CARBIDE, 2 FLUTE BALL NOSE for RIB PROCESSING
VOLLHARTMETALL, 2 SCHNEIDEN STIRNRADIUS für SCHMALE RIPPEN
EM886 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON			ALLOY STEELS HEAT RESISTANT STEELS			HARDENED STEELS		
HARDNESS	~ HRc30			HRc30 ~ HRc45			HRc45 ~ HRc55		
STRENGTH	~ 1000N/mm ²			1000 ~ 1500N/mm ²			1500 ~ 2000N/mm ²		
DIAMETER	RPM	FEED	ap (mm)	RPM	FEED	ap (mm)	RPM	FEED	ap (mm)
R0.2 × 0.4	31000~40000	175~490	0.018~0.036	22500~28500	88~270	0.018~0.036	14300~18000	88~175	0.004~0.007
R0.25 × 0.5	31000~40000	175~490	0.023~0.045	22500~28500	88~270	0.023~0.045	14300~18000	88~175	0.005~0.009
R0.3 × 0.6	31000~40000	225~630	0.027~0.054	22500~28500	110~350	0.027~0.054	14300~18000	110~225	0.005~0.011
R0.4 × 0.8	31000~40000	225~630	0.036~0.072	22500~28500	110~350	0.036~0.072	14300~18000	110~225	0.007~0.014
R0.5 × 1.0	29000~36500	250~700	0.045~0.090	20500~26000	125~390	0.045~0.090	13000~16300	125~250	0.009~0.018
R0.6 × 1.2	24000~30500	250~780	0.055~0.100	17000~21500	125~390	0.055~0.100	10800~13700	125~250	0.010~0.022
R0.7 × 1.4	21000~26000	250~780	0.062~0.125	15000~18000	125~390	0.062~0.125	9400~11700	125~250	0.012~0.025
R0.75 × 1.5	19000~24000	250~780	0.070~0.135	13500~17500	125~390	0.070~0.135	8700~10700	125~250	0.014~0.028
R0.8 × 1.6	18000~23500	250~780	0.075~0.145	13200~16500	125~390	0.075~0.145	8300~10400	125~250	0.015~0.030
R0.9 × 1.8	17000~21500	250~780	0.080~0.160	12000~15000	125~390	0.080~0.160	7400~9400	125~250	0.016~0.032
R1.0 × 2.0	15500~19000	250~780	0.090~0.180	11000~13500	125~390	0.090~0.180	6900~8600	125~250	0.018~0.035
R1.5 × 3.0	10500~13000	250~780	0.135~0.270	7000~9000	125~390	0.135~0.270	4600~5700	125~250	0.028~0.055
R2.0 × 4.0	8500~11000	250~780	0.180~0.360	5800~7800	125~390	0.180~0.360	3900~4900	125~250	0.035~0.070
R2.5 × 5.0	6800~8800	250~780	0.225~0.450	4600~6200	125~390	0.225~0.450	3100~3900	125~250	0.044~0.088
R3.0 × 6.0	5700~7300	250~780	0.270~0.540	3900~5200	125~390	0.270~0.540	2600~3300	125~250	0.053~0.105

(Depth of Cut per one pass)


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