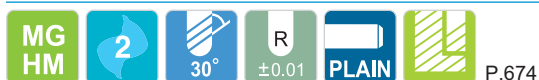
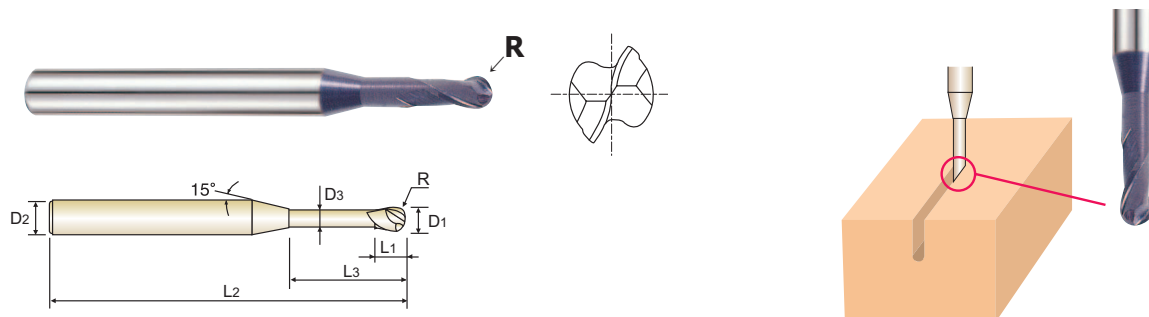


CARBIDE, 2 FLUTE BALL NOSE for RIB PROCESSING

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
EM886004	RO.2	0.4	4	0.6	1	45	0.37
EM886960	RO.2	0.4	4	0.6	2	45	0.37
EM886961	RO.2	0.4	4	0.6	3	45	0.37
EM886005	RO.25	0.5	4	0.7	2	45	0.45
EM886962	RO.25	0.5	4	0.7	4	45	0.45
EM886963	RO.25	0.5	4	0.7	6	45	0.45
EM886964	RO.25	0.5	4	0.7	8	45	0.45
EM886957	RO.3	0.6	4	0.9	2	45	0.55
EM886915	RO.3	0.6	4	0.9	4	45	0.55
EM886006	RO.3	0.6	3	0.9	6	35	0.55
EM886916	RO.3	0.6	4	0.9	6	45	0.55
EM886917	RO.3	0.6	4	0.9	8	45	0.55
EM886918	RO.4	0.8	4	1.2	2	45	0.75
EM886919	RO.4	0.8	4	1.2	4	45	0.75
EM886008	RO.4	0.8	4	1.2	6	45	0.75
EM886901	RO.4	0.8	4	1.2	8	45	0.75
EM886965	RO.4	0.8	4	1.2	10	45	0.75
EM886920	RO.5	1.0	4	1.5	3	45	0.95
EM886921	RO.5	1.0	4	1.5	4	45	0.95
EM886923	RO.5	1.0	4	1.5	5	45	0.95
EM886010	RO.5	1.0	4	1.5	6	45	0.95
EM886924	RO.5	1.0	4	1.5	7	45	0.95
EM886902	RO.5	1.0	4	1.5	8	45	0.95
EM886925	RO.5	1.0	4	1.5	9	45	0.95
EM886903	RO.5	1.0	4	1.5	10	45	0.95
EM886904	RO.5	1.0	4	1.5	12	45	0.95
EM886926	RO.5	1.0	4	1.5	14	50	0.95
EM886927	RO.5	1.0	4	1.5	16	50	0.95
EM886966	RO.5	1.0	4	1.5	20	55	0.95
EM886012	RO.6	1.2	4	1.8	8	45	1.15
EM886905	RO.6	1.2	4	1.8	12	45	1.15
EM886928	RO.7	1.4	4	2.1	8	45	1.35

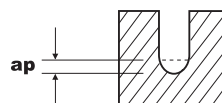
◎ : Excellent ○ : Good

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.