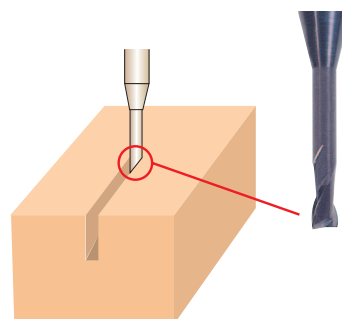
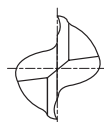
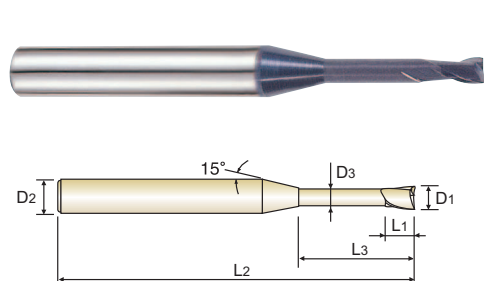


CARBIDE, 2 FLUTE for RIB PROCESSING

VOLLHARTMETALL, 2 SCHNEIDEN für SCHMALE RIPPEN



Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
EM883004	0.4	4	0.6	2	45	0.37
EM883984	0.4	4	0.6	3	45	0.37
EM883985	0.4	4	0.6	4	45	0.37
EM883986	0.4	4	0.6	5	45	0.37
EM883005	0.5	4	0.7	2	45	0.45
EM883988	0.5	4	0.7	4	45	0.45
EM883989	0.5	4	0.7	6	45	0.45
EM883990	0.5	4	0.7	8	45	0.45
EM883006	0.6	4	0.9	2	45	0.55
EM883991	0.6	4	0.9	4	45	0.55
EM883992	0.6	4	0.9	6	45	0.55
EM883993	0.6	4	0.9	8	45	0.55
EM883819	0.6	4	0.9	10	45	0.55
EM883007	0.7	4	1.0	2	45	0.65
EM883820	0.7	4	1.0	3	45	0.65
EM883906	0.7	4	1.0	4	45	0.65
EM883907	0.7	4	1.0	6	45	0.65
EM883821	0.7	4	1.0	8	45	0.65
EM883822	0.7	4	1.0	10	45	0.65
EM883008	0.8	4	1.2	4	45	0.75
EM883908	0.8	4	1.2	6	45	0.75
EM883909	0.8	4	1.2	8	45	0.75
EM883994	0.8	4	1.2	10	45	0.75
EM883995	0.8	4	1.2	12	45	0.75
EM883009	0.9	4	1.35	6	45	0.85
EM883910	0.9	4	1.35	8	45	0.85
EM883911	0.9	4	1.35	10	45	0.85
EM883823	0.9	4	1.35	15	50	0.85
EM883996	1.0	4	1.5	4	45	0.95
EM883010	1.0	4	1.5	6	45	0.95
EM883912	1.0	4	1.5	8	45	0.95
EM883913	1.0	4	1.5	10	45	0.95

◎ : 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							
○	◎	◎	◎	○			○				

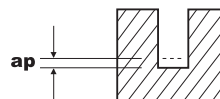
CARBIDE, 2 FLUTE for RIB PROCESSING

VOLLHARTMETALL, 2 SCHNEIDEN für SCHMALE RIPPEN

EM883 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)
0.4	31000~40000	200~440	0.007~0.018	22500~28000	85~340	0.007~0.018	14300~17000	30~90	0.004~0.008
0.5	31000~40000	200~440	0.009~0.022	22500~28000	85~340	0.009~0.022	14300~17000	30~90	0.004~0.009
0.6	31000~40000	250~570	0.011~0.026	22500~28000	110~430	0.011~0.026	14300~17000	40~110	0.005~0.011
0.7	31000~40000	250~570	0.012~0.031	22500~28000	110~430	0.012~0.031	14300~17000	40~110	0.006~0.013
0.8	27000~35000	280~630	0.014~0.035	19500~24500	120~480	0.014~0.035	12500~14800	45~125	0.007~0.015
0.9	25000~31500	280~720	0.030~0.060	17500~22500	160~540	0.030~0.060	11000~12500	55~130	0.008~0.016
1.0	22500~28000	280~810	0.045~0.090	15700~20000	190~600	0.045~0.090	10000~12500	65~130	0.009~0.018
1.2	18500~22500	280~900	0.055~0.100	13000~16500	190~600	0.055~0.100	8300~10500	65~130	0.010~0.022
1.4	16000~20000	280~900	0.062~0.125	11500~14000	190~600	0.062~0.125	7200~9000	65~130	0.012~0.025
1.5	14500~18500	280~900	0.070~0.135	10500~13500	190~600	0.070~0.135	6700~8200	65~130	0.014~0.028
1.6	14000~18000	280~900	0.075~0.145	10200~12800	190~600	0.075~0.145	6400~8000	65~130	0.015~0.030
1.8	13000~16500	280~900	0.080~0.160	9200~11500	190~600	0.080~0.160	5700~7200	65~130	0.016~0.032
2.0	12000~14500	280~900	0.090~0.180	8300~10500	190~600	0.090~0.180	5300~6600	65~130	0.018~0.035
2.5	9500~12000	280~900	0.112~0.235	6700~8500	190~600	0.112~0.235	4300~5300	65~130	0.022~0.045
3.0	8000~10000	280~900	0.135~0.270	5500~7000	190~600	0.135~0.270	3500~4400	65~130	0.028~0.055
2.0	6000~7500	280~900	0.180~0.36	4100~5300	190~600	0.180~0.36	2600~3300	65~130	0.036~0.072
5.0	4800~6000	280~900	0.225~0.450	3300~4200	190~600	0.225~0.450	2100~2600	65~130	0.045~0.090
6.0	4000~5000	280~900	0.270~0.540	2800~3500	190~600	0.270~0.540	1750~2600	65~130	0.054~0.108

(Depth of Cut per one pass)



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