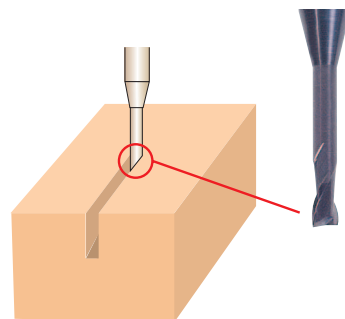
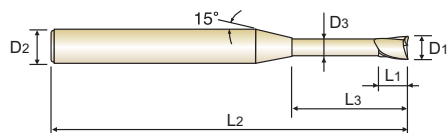
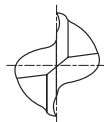



**X-POWER
END MILLS**
EM883 SERIES
**PLAIN SHANK
GLATTER ZYLINDERSCHAFT**

CARBIDE, 2 FLUTE for RIB PROCESSING **VOLLHARTMETALL, 2 SCHNEIDEN für SCHMALE RIPPEN**



P.673

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
EM883914	1.0	4	1.5	12	45	0.95
EM883997	1.0	4	1.5	16	50	0.95
EM883998	1.0	4	1.5	20	55	0.95
EM883012	1.2	4	1.8	6	45	1.15
EM883915	1.2	4	1.8	8	45	1.15
EM883916	1.2	4	1.8	10	45	1.15
EM883917	1.2	4	1.8	12	45	1.15
EM883999	1.2	4	1.8	16	50	1.15
EM883824	1.4	4	2.1	6	45	1.35
EM883918	1.4	4	2.1	8	45	1.35
EM883919	1.4	4	2.1	10	45	1.35
EM883920	1.4	4	2.1	12	45	1.35
EM883921	1.4	4	2.1	14	50	1.35
EM883922	1.4	4	2.1	16	50	1.35
EM883825	1.4	4	2.1	22	55	1.35
EM883015	1.5	4	2.3	6	45	1.45
EM883923	1.5	4	2.3	8	45	1.45
EM883924	1.5	4	2.3	10	45	1.45
EM883925	1.5	4	2.3	12	45	1.45
EM883926	1.5	4	2.3	14	50	1.45
EM883927	1.5	4	2.3	16	50	1.45
EM883928	1.5	4	2.3	18	55	1.45
EM883810	1.5	4	2.3	20	55	1.45
EM883930	1.6	4	2.4	6	45	1.55
EM883016	1.6	4	2.4	8	45	1.55
EM883931	1.6	4	2.4	10	45	1.55
EM883932	1.6	4	2.4	12	45	1.55
EM883826	1.6	4	2.4	14	50	1.55
EM883827	1.6	4	2.4	16	50	1.55
EM883828	1.6	4	2.4	18	55	1.55
EM883829	1.6	4	2.4	20	55	1.55
EM883830	1.6	4	2.4	26	60	1.55

◎ : 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
CARBIDE
HSS

 CBN
END MILLS

 i-Xmill
END MILLS

 X5070
END MILLS

**X-POWER
END MILLS**

 JET-POWER
END MILLS

 V7 Mill INOX
END MILLS

 V7 Mill STEEL
END MILLS

 ALU-POWER
END MILLS

 D-POWER
END MILLS

 K-2 CARBIDE
END MILLS

 GENERAL
CARBIDE
END MILLS

 TANK-POWER
END MILLS

 GENERAL
HSS
END MILLS

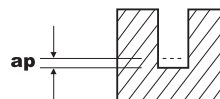
 MILLING
CUTTERS

 TECHNICAL
DATA

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.