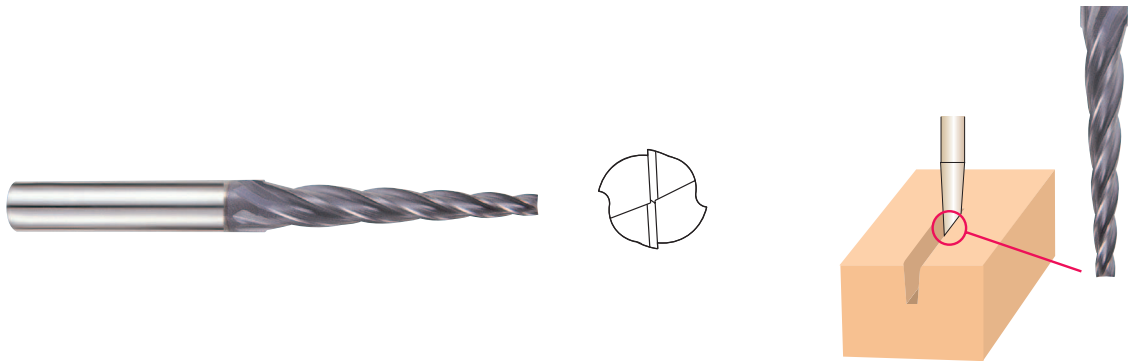




CARBIDE, 4 FLUTE 25° HELIX TAPER for RIB PROCESSING
VOLLHARTMETALL, 4 SCHNEIDEN 25° RECHTSSPIRALE KONISCH für SCHMALE RIPPEN



Unit : mm

EDP No. PLAIN	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	Taper Angle
EM889952	1.0	4	8	45	30'
EM889954	1.0	4	12	45	30'
EM889010	1.0	4	8	45	1°
EM889959	1.0	4	12	45	1°
EM889960	1.0	4	8	45	1° 30'
EM889962	1.0	4	12	45	1° 30'
EM889963	1.0	4	8	45	2°
EM889965	1.0	4	12	45	2°
EM889968	1.2	4	8	45	30'
EM889970	1.2	4	12	45	30'
EM889012	1.2	4	8	45	1°
EM889977	1.2	4	12	45	1°
EM889979	1.2	4	8	45	1° 30'
EM889981	1.2	4	12	45	1° 30'
EM889983	1.2	4	8	45	2°
EM889985	1.2	4	12	45	2°
EM889987	1.5	4	8	45	30'
EM889991	1.5	4	12	45	30'
EM889992	1.5	4	16	50	30'
EM889015	1.5	4	8	45	1°
EM889801	1.5	4	12	45	1°
EM889802	1.5	4	16	50	1°
EM889804	1.5	4	8	45	1° 30'
EM889806	1.5	4	12	45	1° 30'
EM889807	1.5	4	16	50	1° 30'
EM889809	1.5	4	8	45	2°
EM889811	1.5	4	12	45	2°
EM889812	1.5	4	16	50	2°

◎ : Excellent ○ : Good

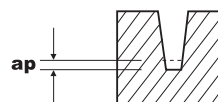
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	◎	◎	○				○				

CARBIDE, 4 FLUTE TAPER for RIB PROCESSING
VOLLHARTMETALL, 4 SCHNEIDEN KONISCH für SCHMALE RIPPEN

EM889 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)
1.0	20000	700	0.020~0.040	15000	500	0.020~0.030	10000	300	0.010~0.020
1.2	16000	700	0.025~0.050	13000	500	0.025~0.040	8000	300	0.012~0.025
1.5	13000	700	0.030~0.060	10000	500	0.030~0.050	6500	300	0.015~0.030
2.0	10000	700	0.040~0.080	8000	500	0.040~0.060	5000	300	0.020~0.040

(Depth of Cut per one pass)



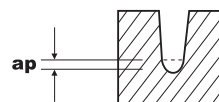
RPM = rev./min.
FEED = mm/min.

CARBIDE, 4 FLUTE TAPER BALL NOSE for RIB PROCESSING
VOLLHARTMETALL, 4 SCHNEIDEN KONISCH STIRNRADIUS für SCHMALE RIPPEN

EM890 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)
R0.5 × 1.0	20000	700	0.020~0.040	15000	500	0.020~0.030	10000	300	0.010~0.020
R0.6 × 1.2	16000	700	0.025~0.050	13000	500	0.025~0.040	8000	300	0.012~0.025
R0.75 × 1.5	13000	700	0.030~0.060	10000	500	0.030~0.050	6500	300	0.015~0.030
R1.0 × 2.0	10000	700	0.040~0.080	8000	500	0.040~0.060	5000	300	0.020~0.040

(Depth of Cut per one pass)



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