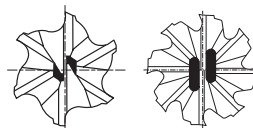


CARBIDE, 6&8 FLUTE 45° HELIX LONG LENGTH (Positive Rake Angle) VOLLHARTMETALL, 6&8 SCHNEIDEN 45° RECHTSSPIRALE LANG

- ▶ Ultra micro grain carbide
- ▶ Reduces chipping of corner edges
- ▶ Suitable for low hardness materials (under HRc45), alloy steels, tool steels, carbon steels, prehardened steels, stainless steels, etc

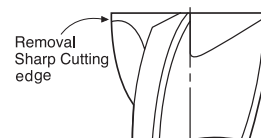
- ▶ Ultra Feinstkorn - Vollhartmetall
- ▶ Verstärkte Schneidkante.
- ▶ zur Bearbeitung von: Werkstoffen bis 45 HRc, rostfreien Stählen, Titan und Nickellegierungen.



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
PLAIN	FLAT					
EH915060	EH916060	6.0	6	13	57	6
EH915070	EH916070	7.0	8	16	63	6
EH915080	EH916080	8.0	8	19	63	6
EH915090	EH916090	9.0	10	19	72	6
EH915100	EH916100	10.0	10	22	72	6
EH915120	EH916120	12.0	12	26	83	6
EH915140	EH916140	14.0	14	26	83	6
EH915160	EH916160	16.0	16	32	92	6
EH915180	EH916180	18.0	18	32	92	8
EH915200	EH916200	20.0	20	38	104	8
EH915250	EH916250	25.0	25	44	104	8

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6



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							
○	○	○	○							○	○	○

◎ : Excellent ○ : Good



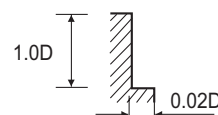
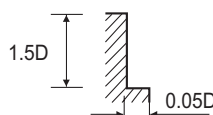
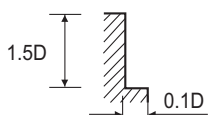
RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 6&8 FLUTE 45° HELIX LONG - SIDE CUTTING
VOLLHARTMETALL, 6&8 SCHNEIDEN 45° RECHTSSPIRALE LANG - SEITENFRÄSEN

EH915, EH916 SERIES

■ NORMAL SPEED

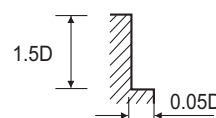
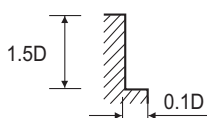
MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		STAINLESS STEELS TITANIUM ALLOY		INCONEL	
	~ HRc30		HRc30 ~ HRc45					
STRENGTH	1000N/mm ²		1000 ~ 1500N/mm ²					
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	5560	2000	3880	1370	3370	1100	1350	280
8.0	4200	2000	2940	1370	2490	1100	1000	280
10.0	3360	2000	2320	1370	1920	1100	440	280
12.0	2840	1680	2000	1160	1610	1000	400	250
16.0	2100	1260	1480	880	1160	770	310	190
20.0	1680	1010	1160	690	900	620	250	155
25.0	1500	900	1100	600	850	540	220	135



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

■ HIGH SPEED

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS	
	~ HRc30		HRc30 ~ HRc45	
STRENGTH	1000N/mm ²		1000 ~ 1500N/mm ²	
DIAMETER	RPM	FEED	RPM	FEED
6.0	22200	8000	16800	6090
8.0	16800	8000	12600	6090
10.0	13400	8000	9980	5990
12.0	11350	6720	8400	5040
16.0	8400	5040	6300	3780
20.0	6700	4040	5040	3050
25.0	6000	3600	4500	2700



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