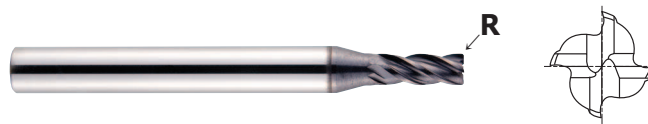


## CARBIDE, 4 FLUTE LONG LENGTH CORNER RADIUS VOLLHARTMETALL, 4 SCHNEIDEN LANG ECKENRADIUS

- ▶ Special flute geometry eliminates vibrations
  - ▶ Designed to mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material under HRc 40
  - ▶ Excellent work piece finishes
  - ▶ Higher speeds, deeper cuts and metal removal rates
- ▶ Spezielle Schneidengeometrie verhindert Vibrationen
  - ▶ Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
  - ▶ Bessere Werkstückoberflächen.
  - ▶ Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen



Unit : mm

EDP No.		Corner Radius R	Mill Diameter	Shank Diameter h6	Length of Cut	Overall Length
PLAIN	FLAT					
EMB15030	EMB40030	RO.25~RO.38	3.0	6	8	57
EMB15040	EMB40040	RO.25~RO.38	4.0	6	11	57
EMB15050	EMB40050	RO.25~RO.38	5.0	6	13	57
EMB15060	EMB40060	RO.38~RO.51	6.0	6	13	57
EMB15080	EMB40080	RO.38~RO.51	8.0	8	19	63
EMB15100	EMB40100	RO.38~RO.51	10.0	10	22	72
EMB15120	EMB40120	RO.64~RO.76	12.0	12	26	83
EMB15140	EMB40140	RO.64~RO.76	14.0	14	26	83
EMB15160	EMB40160	RO.89~R1.02	16.0	16	32	92
EMB15180	EMB40180	RO.89~R1.02	18.0	18	32	92
EMB15200	EMB40200	RO.89~R1.02	20.0	20	38	104
EMB15250	EMB40250	RO.89~R1.02	25.0	25	38	104

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

◎ : 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							
○	◎	○								◎	◎	○

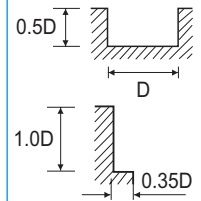
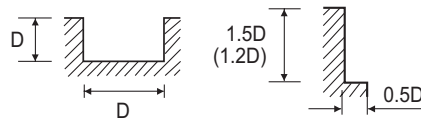


**RECOMMENDED CUTTING CONDITIONS**  
**EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 4 FLUTE**  
**VOLLHARTMETALL, 4 SCHNEIDEN**

**EMB41, EMB42, EMB43, EMB44, EMB14, EMB39, EMB15, EMB40, EMB12, EMB37, EMB13, EMB38 SERIES**

MATERIAL	ALLOY STEELS CAST IRON		ALLOY STEELS CAST IRON		STAINLESS STEELS 300SERIES		STAINLESS STEELS 400SERIES		TITANIUM		INCONEL	
	HARDNESS	~HB 300	HB 300~HB 380	STRENGTH	~1000N/mm <sup>2</sup>	1000~1300N/mm <sup>2</sup>	DIAMETER	RPM	FEED	RPM	FEED	RPM
3.0	13475	275	9430	190	10185	195	14260	205	10185	205	2715	55
4.0	10105	330	7070	230	7600	250	14260	255	7600	255	2005	55
5.0	8085	370	5660	260	6110	310	8655	310	6110	310	1630	80
6.0	6735	435	4715	385	5095	360	7130	360	5095	360	1355	95
8.0	5050	555	3535	385	3820	435	5345	465	3280	465	1015	125
10.0	4455	690	3115	480	3055	590	4275	585	3055	585	815	155
12.0	3710	695	2600	485	2545	565	3565	565	2545	565	675	150
14.0	3180	620	2225	435	2180	520	3055	520	2180	520	580	140
16.0	2785	590	1950	410	1910	480	2670	480	1910	480	505	130
18.0	2475	585	1730	410	1695	475	2375	475	1695	475	450	125
20.0	2225	580	1560	405	1525	470	2140	470	1525	470	405	125
25.0	1780	450	1245	315	1215	380	1710	380	1215	380	320	110



1.2 x D Axial cutting depth should be applied for Short length series DIA over 8mm

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