

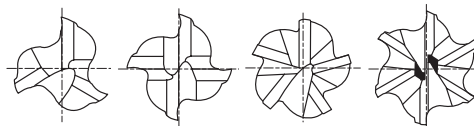
PLAIN SHANK
GLATTER ZYLINDERSCHAFT

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, MULTI FLUTE 45° HELIX LONG LENGTH ROUGHING - FINE
VOLLHARTMETALL, MULTI SCHNEIDEN 45° RECHTSSPIRALE LANG SCHRUPPFRÄSER - FEIN

- ▶ Ultra micro grain carbide
- ▶ High chip removal and minimizing breakages of cutting edges.
- ▶ Suitable for low hardness materials (under HRc45), alloy steels, tool steels, carbon steels, prehardened steels, stainless steels, etc

- ▶ Ultra Feinstkorn - Vollhartmetall
- ▶ Schnelle Spanausfuhr und Minimierung von Abbrechen von Schneidkanten.
- ▶ zur Bearbeitung von: Werkstoffen bis 45 HRc, rostfreien Stählen, Titan und Nickellegierungen..

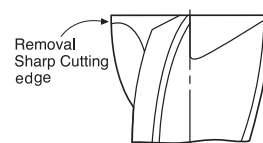


Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
PLAIN	FLAT	h10	h6			
EH919040	EH920040	4.0	6	11	57	3
EH919050	EH920050	5.0	6	13	57	4
EH919060	EH920060	6.0	6	16	57	4
EH919070	EH920070	7.0	8	16	63	4
EH919080	EH920080	8.0	8	16	63	4
EH919090	EH920090	9.0	10	19	72	4
EH919100	EH920100	10.0	10	22	72	4
EH919120	EH920120	12.0	12	26	83	4
EH919140	EH920140	14.0	14	26	83	5
EH919160	EH920160	16.0	16	32	92	5
EH919200	EH920200	20.0	20	38	104	6
EH919250	EH920250	25.0	25	45	121	6

Tolerances according to DIN 7160 & 7161
Toleranzen nach DIN 7160 & 7161

Tolerance range in μm / Toleranzwerte in μm					
Nominal-Diameter in mm / Nennmaßbereich in mm					
	from 1 to 3 von 1 bis 3	over 3 to 6 über 3 bis 6	over 6 to 10 über 6 bis 10	over 10 to 18 über 10 bis 18	over 18 to 30 über 18 bis 30
h10	0 - 40	0 - 48	0 - 58	0 - 70	0 - 84
h6	0 - 6	0 - 8	0 - 9	0 - 11	0 - 13



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

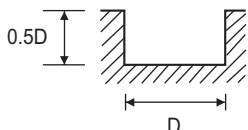


**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN**

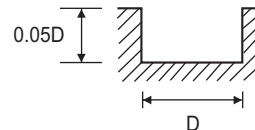
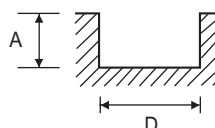
**CARBIDE, MULTI FLUTE ROUGHING - SLOTTING
VOLLHARTMETALL, MULTI SCHNEIDEN SCHRUPPFÄRER**

EH917, EH918, EH919, EH920, EH921, EH942, EH852, EH862, EH831, EH841 SERIES

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		STAINLESS STEELS TITANIUM ALLOY		INCONEL	
	~ HRc30		HRc30 ~ HRc45					
HARDNESS	~ HRc30		HRc30 ~ HRc45					
STRENGTH	1000N/mm ²		1000 ~ 1500N/mm ²					
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
4.0	23400	2320	18600	840	12600	570	3600	190
6.0	15600	2320	12400	840	8400	570	2400	190
8.0	11600	2320	9200	840	6300	570	1800	180
10.0	9200	2320	7600	840	5100	570	1300	190
12.0	8000	2400	6000	800	4200	570	1200	190
14.0	6800	2400	5200	840	3600	570	900	130
16.0	6000	2400	4800	760	3300	510	800	110
18.0	5200	2320	4400	720	2700	420	700	100
20.0	4800	2160	3600	560	2400	360	660	100
25.0	4300	2150	3200	620	2160	410	600	110



A: $\varnothing 4\text{-}\varnothing 10:0.25 \times D$
 $\varnothing 12\text{-}\varnothing 16:0.15 \times D$
 $\varnothing 18\text{-}\varnothing 25:0.10 \times D$

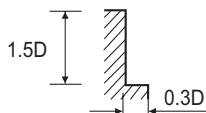


RPM = rev./min.
FEED = mm/min.

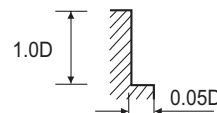
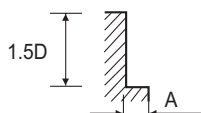
**CARBIDE, MULTI FLUTE ROUGHING - SIDE CUTTING
VOLLHARTMETALL, MULTI SCHNEIDEN SCHRUPPFÄRER**

EH917, EH918, EH919, EH920, EH921, EH942, EH852, EH862, EH831, EH841 SERIES

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		STAINLESS STEELS TITANIUM ALLOY		INCONEL	
	~ HRc30		HRc30 ~ HRc45					
HARDNESS	~ HRc30		HRc30 ~ HRc45					
STRENGTH	1000N/mm ²		1000 ~ 1500N/mm ²					
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
4.0	23400	2320	18600	840	12600	570	3600	190
6.0	15600	2320	12400	840	8400	570	2400	190
8.0	11600	2320	9200	840	6300	570	1800	180
10.0	9200	2320	7600	840	5100	570	1300	190
12.0	8000	2400	6000	800	4200	570	1200	190
14.0	6800	2400	5200	840	3600	570	900	130
16.0	6000	2400	4800	760	3300	510	800	110
18.0	5200	2320	4400	720	2700	420	700	100
20.0	4800	2160	3600	560	2400	360	660	100
25.0	4300	2150	3200	620	2160	410	600	110



A: $\varnothing 4\text{-}\varnothing 10:0.15 \times D$
 $\varnothing 12\text{-}\varnothing 16:0.10 \times D$
 $\varnothing 18\text{-}\varnothing 25:0.05 \times D$



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