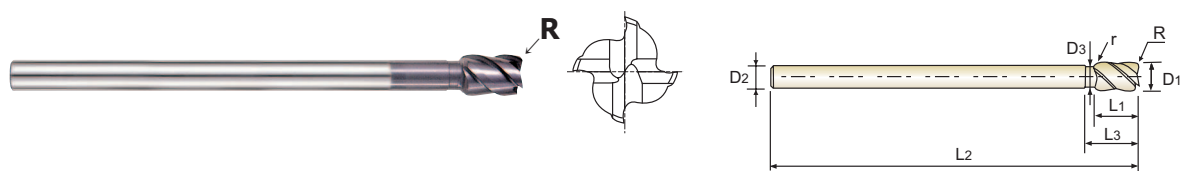


CARBIDE, 4 FLUTE 45° HELIX SHORT LENGTH CORNER RADIUS

VOLLHARTMETALL, 4 SCHNEIDEN 45° RECHTSSPIRALE KURZ ECKENRADIUS

- ▶ No line is marked on the boundary section during step milling because this tool has radius on the end faces of the shank
- ▶ High speed cutting in wide deep wall with step milling
- ▶ Suitable for deep side milling, Helical Milling, Contour Milling
- ▶ Hohe Oberflächengüte, auch an den Übergangsfächen, durch Radien am Auslauf der Schneidkanten.
- ▶ Hochgeschwindigkeitsfräsen auch bei grosser Auskraglänge.
- ▶ Geeignet für tiefes Seitenfräsen, Spiralfräsen und Konturfräsen.



Unit : mm

EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
PLAIN	R	D1	D2	L1	L3	L2	D3
EM905100	RO.5	10.0	8	19.2	15	130	7.5
EM905901	R1.0	10.0	8	19.2	15	130	7.5
EM905120	RO.5	12.0	10	22.2	18	150	9.5
EM905902	R1.0	12.0	10	22.2	18	150	9.5
EM905140	RO.5	14.0	12	25.2	21	160	11.5
EM905903	R1.0	14.0	12	25.2	21	160	11.5
EM905180	RO.5	18.0	16	31.2	27	180	15.5
EM905904	R1.0	18.0	16	31.2	27	180	15.5
EM905220	RO.5	22.0	20	37.2	33	200	19.5
EM905905	R1.0	22.0	20	37.2	33	200	19.5

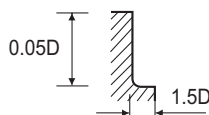
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6

◎ : 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							
○	◎	◎	◎	○				○		○		

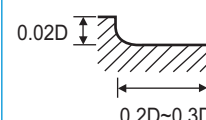
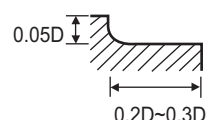
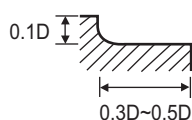
CARBIDE, 4 FLUTE 45° HELIX CORNER RADIUS - SIDE CUTTING
VOLLHARTMETALL, 4 SCHNEIDEN 45° RECHTSSPIRALE ECKENRADIUS - SEITENFRÄSEN
EM905 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		STAINLESS STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	~ HRC30		HRC30 ~ HRC45				HRC45 ~ HRC55		HRC55 ~ HRC65	
STRENGTH	~ 1000N/mm ²		1000 ~ 1500N/mm ²				1500 ~ 2000N/mm ²		2000N/mm ² ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
10.0	7690	2000	7690	1220	5680	920	5680	740	3840	480
12.0	5760	2000	5760	1220	4260	920	4260	740	2880	480
14.0	4600	1800	4600	1220	3410	920	3410	740	2300	480
18.0	3850	1530	3850	1220	2840	920	2840	740	1920	480
22.0	3300	1300	3300	1220	2430	920	2430	740	1650	480


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

CARBIDE, 4 FLUTE 45° HELIX CORNER RADIUS - CONTOURING
VOLLHARTMETALL, 4 SCHNEIDEN 45° RECHTSSPIRALE ECKENRADIUS
EM905 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		STAINLESS STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	~ HRC30		HRC30 ~ HRC45				HRC45 ~ HRC55		HRC55 ~ HRC65	
STRENGTH	~ 1000N/mm ²		1000 ~ 1500N/mm ²				1500 ~ 2000N/mm ²		2000N/mm ² ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
10.0	7690	1150	5680	920	5680	800	5680	460	3840	290
12.0	5760	1150	4260	920	4260	800	4260	460	2880	290
14.0	4600	1150	3410	920	3410	800	3410	460	2300	290
18.0	3850	1150	2840	920	2840	800	2840	460	1920	290
22.0	3300	1150	2430	920	2430	800	2430	460	1650	290


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