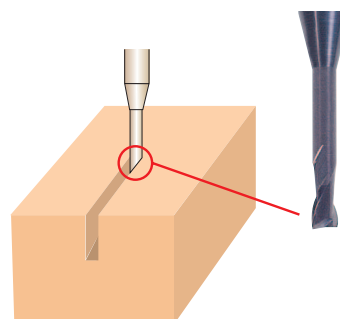
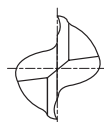
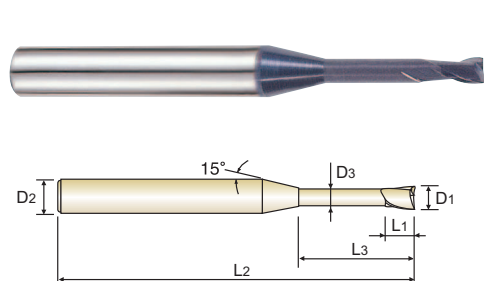


CARBIDE, 2 FLUTE for RIB PROCESSING VOLLHARTMETALL, 2 SCHNEIDEN für SCHMALE RIPPEN



Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
EM883018	1.8	4	2.7	6	45	1.75
EM883944	1.8	4	2.7	8	45	1.75
EM883945	1.8	4	2.7	10	45	1.75
EM883946	1.8	4	2.7	12	45	1.75
EM883947	1.8	4	2.7	14	50	1.75
EM883948	1.8	4	2.7	16	50	1.75
EM883949	1.8	4	2.7	18	55	1.75
EM883950	1.8	4	2.7	20	55	1.75
EM883831	1.8	4	2.7	25	60	1.75
EM883958	2.0	4	3.0	6	45	1.95
EM883020	2.0	4	3.0	8	45	1.95
EM883959	2.0	4	3.0	10	45	1.95
EM883960	2.0	4	3.0	12	45	1.95
EM883961	2.0	4	3.0	14	50	1.95
EM883962	2.0	4	3.0	16	50	1.95
EM883963	2.0	4	3.0	18	55	1.95
EM883964	2.0	4	3.0	20	55	1.95
EM883966	2.0	4	3.0	25	60	1.95
EM883814	2.0	4	3.0	30	70	1.95
EM883967	2.5	4	3.7	8	45	2.40
EM883025	2.5	4	3.7	10	45	2.40
EM883968	2.5	4	3.7	12	45	2.40
EM883969	2.5	4	3.7	14	50	2.40
EM883970	2.5	4	3.7	16	55	2.40
EM883971	2.5	4	3.7	18	55	2.40
EM883972	2.5	4	3.7	20	60	2.40
EM883973	2.5	4	3.7	25	70	2.40
EM883974	2.5	4	3.7	30	80	2.40
EM883030	3.0	6	4.5	8	45	2.85
EM883975	3.0	6	4.5	10	45	2.85
EM883976	3.0	6	4.5	12	45	2.85
EM883977	3.0	6	4.5	14	50	2.85

◎ : 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							
○	◎	◎	◎	○				○				

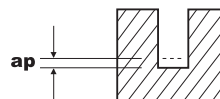
CARBIDE, 2 FLUTE for RIB PROCESSING

VOLLHARTMETALL, 2 SCHNEIDEN für SCHMALE RIPPEN

EM883 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)
0.4	31000~40000	200~440	0.007~0.018	22500~28000	85~340	0.007~0.018	14300~17000	30~90	0.004~0.008
0.5	31000~40000	200~440	0.009~0.022	22500~28000	85~340	0.009~0.022	14300~17000	30~90	0.004~0.009
0.6	31000~40000	250~570	0.011~0.026	22500~28000	110~430	0.011~0.026	14300~17000	40~110	0.005~0.011
0.7	31000~40000	250~570	0.012~0.031	22500~28000	110~430	0.012~0.031	14300~17000	40~110	0.006~0.013
0.8	27000~35000	280~630	0.014~0.035	19500~24500	120~480	0.014~0.035	12500~14800	45~125	0.007~0.015
0.9	25000~31500	280~720	0.030~0.060	17500~22500	160~540	0.030~0.060	11000~12500	55~130	0.008~0.016
1.0	22500~28000	280~810	0.045~0.090	15700~20000	190~600	0.045~0.090	10000~12500	65~130	0.009~0.018
1.2	18500~22500	280~900	0.055~0.100	13000~16500	190~600	0.055~0.100	8300~10500	65~130	0.010~0.022
1.4	16000~20000	280~900	0.062~0.125	11500~14000	190~600	0.062~0.125	7200~9000	65~130	0.012~0.025
1.5	14500~18500	280~900	0.070~0.135	10500~13500	190~600	0.070~0.135	6700~8200	65~130	0.014~0.028
1.6	14000~18000	280~900	0.075~0.145	10200~12800	190~600	0.075~0.145	6400~8000	65~130	0.015~0.030
1.8	13000~16500	280~900	0.080~0.160	9200~11500	190~600	0.080~0.160	5700~7200	65~130	0.016~0.032
2.0	12000~14500	280~900	0.090~0.180	8300~10500	190~600	0.090~0.180	5300~6600	65~130	0.018~0.035
2.5	9500~12000	280~900	0.112~0.235	6700~8500	190~600	0.112~0.235	4300~5300	65~130	0.022~0.045
3.0	8000~10000	280~900	0.135~0.270	5500~7000	190~600	0.135~0.270	3500~4400	65~130	0.028~0.055
2.0	6000~7500	280~900	0.180~0.36	4100~5300	190~600	0.180~0.36	2600~3300	65~130	0.036~0.072
5.0	4800~6000	280~900	0.225~0.450	3300~4200	190~600	0.225~0.450	2100~2600	65~130	0.045~0.090
6.0	4000~5000	280~900	0.270~0.540	2800~3500	190~600	0.270~0.540	1750~2600	65~130	0.054~0.108

(Depth of Cut per one pass)



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