



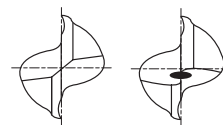
PLAIN SHANK  
GLATTER ZYLINDERSCHAFT

FLAT SHANK  
SEITLICHE MITNAHMEFLÄCHEN

## CARBIDE, 2 FLUTE 35° HELIX SHORT LENGTH VOLLHARTMETALL, 2 SCHNEIDEN 35° RECHTSSPIRALE KURZ

- ▶ 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.



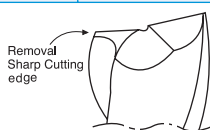
up to Ø3mm over Ø3mm



Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
EH911010	1.0	4	2.5	40
EH911901	1.0	6	2.5	40
EH911015	1.5	4	4	40
EH911902	1.5	6	4	40
EH911020	2.0	4	6	40
EH911903	2.0	6	6	40
EH911025	2.5	4	8	40
EH911904	2.5	6	8	40
EH911030	3.0	6	8	45
EH911035	3.5	6	10	45
EH911040	4.0	6	11	45
EH911045	4.5	6	11	45
EH911050	5.0	6	13	50
EH911055	5.5	6	13	50
EH911060	6.0	6	13	50
EH911065	6.5	8	16	60
EH911070	7.0	8	16	60
EH911075	7.5	8	16	60
EH911080	8.0	8	19	60
EH911085	8.5	10	19	70
EH911090	9.0	10	19	70
EH911095	9.5	10	19	70
EH911100	10.0	10	22	70
EH911110	11.0	12	22	75
EH911120	12.0	12	26	75
EH911140	14.0	16	26	85
EH911160	16.0	16	32	100
EH911180	18.0	16	32	100
EH911200	20.0	20	38	105
EH911220	22.0	20	38	105
EH911250	25.0	25	45	120

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							
○	◎	◎	◎						◎	◎	

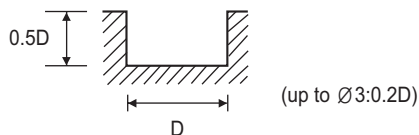


**RECOMMENDED CUTTING CONDITIONS**  
**EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 2 FLUTE SHORT - SLOTTING**  
**VOLLHARTMETALL, 2 SCHNEIDEN KURZ - NUTENFRÄSEN**

**EH911, EH912 SERIES**

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		STAINLESS STEELS TITANIUM ALLOY	
	~ HRc30		HRc30 ~ HRc45			
STRENGTH	1000N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>			
DIAMETER	RPM	FEED	RPM	FEED		
2.0	11560	190	7560	120	6300	90
3.0	8920	210	5560	140	4620	120
4.0	7560	300	4620	180	3880	150
5.0	6300	320	3780	190	3160	160
6.0	5560	350	3360	220	2840	180
8.0	4200	380	2520	200	2100	180
10.0	3260	330	2000	160	1680	160
12.0	2740	280	1680	130	1360	130
16.0	2200	220	1360	110	1060	110
20.0	1680	170	1060	80	840	80
25.0	1360	130	840	70	680	60

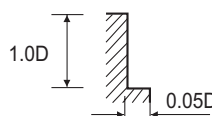


RPM = rev./min.  
FEED = mm/min.

**CARBIDE, 4 FLUTE SHORT - SIDE CUTTING**  
**VOLLHARTMETALL, 4 SCHNEIDEN KURZ - SEITENFRÄSEN**

**EH913, EH914 SERIES**

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS		CARBON STEELS ALLOY STEELS TOOL STEELS		STAINLESS STEELS TITANIUM ALLOY	
	~ HRc30		HRc30 ~ HRc45			
STRENGTH	1000N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>			
DIAMETER	RPM	FEED	RPM	FEED		
2.0	11560	280	7560	170	6300	140
3.0	8920	320	5560	200	4620	170
4.0	7560	570	4620	350	3880	280
5.0	6300	600	3780	360	3160	300
6.0	5560	660	3360	410	2840	330
8.0	4200	710	2520	380	2100	350
10.0	3260	610	2000	300	1680	300
12.0	2740	520	1680	250	1360	240
16.0	2200	410	1360	200	1060	200
20.0	1680	320	1060	160	840	150
25.0	1360	250	840	130	680	120



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