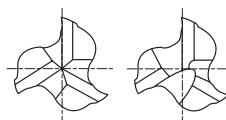


CARBIDE, 3 FLUTE 38° HELIX SHORT LENGTH VOLLHARTMETALL, 3 SCHNEIDEN 38° RECHTSSPIRALE KURZ

- ▶ Designed to machine tool steel, alloy steel, mold steel and other high hardened materials.
- ▶ Possesses the advantage of 2 flute and 4 flute end mill.
- ▶ Superior workpiece finishes.

- ▶ Zur Bearbeitung: Werkzeugstählen, Legierten Stählen, Stahlguß und gehärteten Stählen.
- ▶ Besitzt die Vorteile von 2 und 4 Schneiden Fräsern
- ▶ Bessere Werkstückoberflächen



up to Ø3mm over Ø3mm



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT				
EM895010	—	1.0	3	2.5	38
EM895015	—	1.5	4	5	50
EM895025	—	2.5	3	7	38
EM895030	—	3.0	3	10	38
EM895901	EM896901	3.0	6	10	50
EM895035	—	3.5	4	12	50
EM895902	EM896902	3.5	6	12	50
EM895040	—	4.0	4	12	50
EM895903	EM896040	4.0	6	12	50
EM895045	EM896045	4.5	6	14	57
EM895050	—	5.0	5	14	50
EM895904	EM896903	5.0	6	14	57
EM895060	EM896060	6.0	6	16	57
EM895080	EM896080	8.0	8	20	63
EM895100	EM896100	10.0	10	22	72
EM895120	EM896120	12.0	12	25	73
EM895140	EM896140	14.0	14	25	75
EM895160	EM896160	16.0	16	32	82
EM895180	EM896180	18.0	18	32	92
EM895200	EM896200	20.0	20	38	92

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							
○	◎	◎	◎	○				○		○		

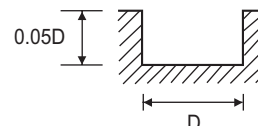
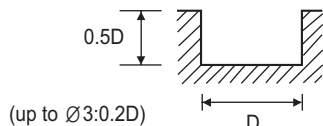


RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 3 FLUTE - SLOTTING
VOLLHARTMETALL, 3 SCHNEIDEN - NUTENFRÄSEN

EM895, EM896, EM836, EM846 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
2.0	11560	170	7560	110	6300	80	5040	30		
3.0	8920	190	5560	130	4620	110	3360	35	1900	40
4.0	7560	270	4620	160	3880	130	2940	35	1480	35
5.0	6300	280	3780	170	3160	140	2320	45	1260	35
6.0	5560	310	3360	200	2840	160	2000	50	1100	35
8.0	4200	340	2520	180	2100	160	1680	65	840	35
10.0	3260	300	2000	140	1680	145	1360	55	680	30
12.0	2740	250	1680	120	1360	120	1160	50	560	30
16.0	2200	200	1360	100	1060	100	900	35	440	20
18.0	1940	175	1210	85	950	85	790	30	380	20
20.0	1680	150	1060	70	840	70	680	25	320	20

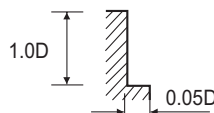


RPM = rev./min.
FEED = mm/min.

CARBIDE, 3 FLUTE - SIDE CUTTING
VOLLHARTMETALL, 3 SCHNEIDEN - SEITENFRÄSEN

EM895, EM896, EM836, EM846 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
2.0	11560	210	7560	140	6300	115	5040	30		
3.0	8920	240	5560	150	4620	125	3360	40	1900	45
4.0	7560	430	4620	260	3880	210	2940	45	1480	45
5.0	6300	450	3780	270	3160	230	2320	55	1260	45
6.0	5560	500	3360	310	2840	250	2000	60	1100	45
8.0	4200	530	2520	290	2100	265	1680	80	840	45
10.0	3260	460	2000	230	1680	230	1360	70	680	35
12.0	2740	390	1680	190	1360	180	1160	60	560	35
16.0	2200	310	1360	150	1060	150	900	45	440	20
18.0	1940	280	1210	135	950	130	790	35	380	20
20.0	1680	240	1060	120	840	115	680	30	320	20



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