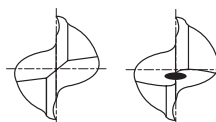


## CARBIDE, 2 FLUTE LONG LENGTH VOLLHARTMETALL, 2 SCHNEIDEN LANG

- ▶ Designed to machine tool steel, alloy steel, mold steel and other high hardened materials.
- ▶ Superior workpiece finishes.
- ▶ Increased feed rates.
- ▶ Zur Bearbeitung: Werkzeugstählen, Legierten Stählen, Stahlguß und gehärteten Stählen.
- ▶ Bessere Werkstückoberflächen
- ▶ Höhere Vorschübe.



up to Ø3mm over Ø3mm



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT				
EM816020	—	2.0	4	8	40
EM816030	EM826030	3.0	6	12	50
EM816040	EM826040	4.0	6	15	50
EM816050	EM826050	5.0	6	20	60
EM816060	EM826060	6.0	6	20	60
EM816080	EM826080	8.0	8	25	70
EM816100	EM826100	10.0	10	30	90
EM816120	EM826120	12.0	12	30	90
EM816140	EM826140	14.0	16	40	110
EM816160	EM826160	16.0	16	50	110
EM816180	EM826180	18.0	20	50	110
EM816200	EM826200	20.0	20	55	110
EM816250	EM826250	25.0	25	75	140

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

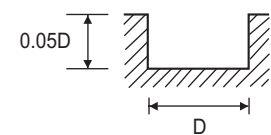
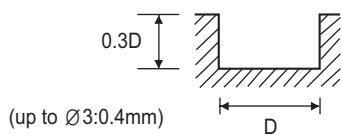
◎ : Excellent ○ : Good

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, 2 FLUTE LONG - SLOTTING VOLLHARTMETALL, 2 SCHNEIDEN LANG - NUTENFRÄSEN

### EM816, EM826 SERIES

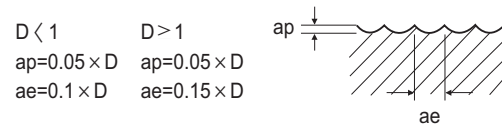
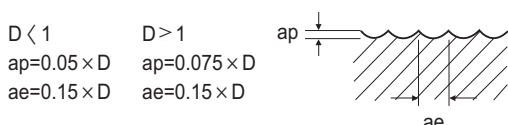
MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		HARDENED STEELS	
HARDNESS	~ HRC30		HRC30 ~ HRC45		HRC45 ~ HRC55	
STRENGTH	~ 1000N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>		1500 ~ 2000N/mm <sup>2</sup>	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED
2.0	7560	70	6050	60	3780	30
3.0	5290	85	4280	70	2640	35
4.0	4280	100	3410	85	2150	40
5.0	3660	125	2900	100	1900	45
6.0	3160	150	2520	125	1640	60
8.0	2400	160	1900	125	1260	60
10.0	2020	160	1640	125	1010	60
12.0	1640	125	1390	115	840	45
16.0	1390	115	1070	90	670	40
20.0	1010	85	820	60	500	30


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

## CARBIDE, 2 FLUTE MINIATURE BALL NOSE VOLLHARTMETALL, 2 SCHNEIDEN MINI STIRNRADIUS

### EM865 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON		HARDENED STEELS	
HARDNESS	HRC30 ~ HRC45		HRC45 ~ HRC55	
STRENGTH	1000 ~ 1500N/mm <sup>2</sup>		1500 ~ 2000N/mm <sup>2</sup>	
DIAMETER	RPM	FEED	RPM	FEED
R0.3 × 0.6	30000	510	30000	360
R0.4 × 0.8	27000	560	27000	330
R0.5 × 1.0	25000	560	25000	340
R0.6 × 1.2	24000	570	24000	350
R0.75 × 1.5	23000	600	23000	370
R1.0 × 2.0	19000	570	19000	320
R1.5 × 3.0	14000	480	14000	280


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