



PLAIN SHANK  
GLATTER ZYLINDERSCHAFT

FLAT SHANK  
SEITLICHE MITNAHMEFLÄCHEN

## CARBIDE, 4 FLUTE LONG LENGTH BALL NOSE VOLLHARTMETALL, 4 SCHNEIDEN LANG STIRNRADIUS

- ▶ Special flute geometry eliminates vibrations
- ▶ Designed to mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material under HRc 40
- ▶ Excellent work piece finishes
- ▶ Higher speeds, deeper cuts and metal removal rates

- ▶ Spezielle Schneidengeometrie verhindert Vibrationen
- ▶ Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
- ▶ Bessere Werkstückoberflächen.
- ▶ Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen



Unit : mm

EDP No.		Radius of Ball Nose R (±0.01)	Mill Diameter	Shank Diameter h6	Length of Cut	Overall Length
PLAIN	FLAT					
EMB74030	EMB75030	R1.5	3.0	6	8	57
EMB74040	EMB75040	R2.0	4.0	6	11	57
EMB74050	EMB75050	R2.5	5.0	6	13	57
EMB74060	EMB75060	R3.0	6.0	6	13	57
EMB74080	EMB75080	R4.0	8.0	8	19	63
EMB74100	EMB75100	R5.0	10.0	10	22	72
EMB74120	EMB75120	R6.0	12.0	12	26	83
EMB74160	EMB75160	R8.0	16.0	16	32	92
EMB74200	EMB75200	R10.0	20.0	20	38	104
EMB74250	EMB75250	R12.5	25.0	25	38	104

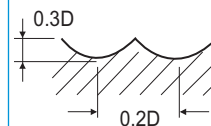
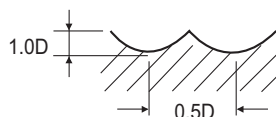
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6

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							
○	◎	○								◎	◎	○

◎ : Excellent ○ : Good

**CARBIDE, 4 FLUTE BALL NOSE  
VOLLHARTMETALL, 4 SCHNEIDEN STIRNRADIUS**
**EMB74, EMB75, EMB78, EMB79 SERIES**

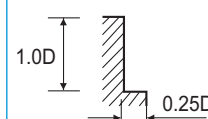
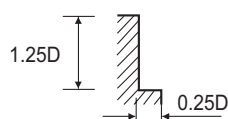
MATERIAL	ALLOY STEELS CAST IRON		STAINLESS STEELS 300SERIES		STAINLESS STEELS 400SERIES		TITANIUM		INCONEL	
HARDNESS	~HB 230									
STRENGTH	~1000N/mm <sup>2</sup>									
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
R1.5 × 3.0	14324	1430	8220	650	7420	440	5830	280	3180	140
R2.0 × 4.0	10740	1070	6160	490	5570	330	4370	210	2380	100
R2.5 × 5.0	8590	1030	4930	490	4450	440	3500	210	1910	80
R3.0 × 6.0	7460	1140	4110	670	3710	440	2910	230	1590	100
R4.0 × 8.0	5370	1280	3080	550	2780	440	2180	260	1190	120
R5.0 × 10.0	4290	1030	2460	490	2220	400	1750	210	950	100
R6.0 × 12.0	3580	1000	2050	450	1850	370	1450	230	790	120
R8.0 × 16.0	2680	800	1540	370	1390	300	1090	190	590	110
R9.0 × 18.0	2380	760	1370	350	1230	290	970	190	530	110
R10.0 × 20.0	2140	770	1230	320	1110	260	870	210	470	100
R12.5 × 25.0	1710	680	980	270	890	210	700	190	380	80



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

**CARBIDE, 5 FLUTE  
VOLLHARTMETALL, 5 SCHNEIDEN**
**EMB72, EMB73, EMB76, EMB77 SERIES**

MATERIAL	ALLOY STEELS CAST IRON		STAINLESS STEELS 300SERIES		STAINLESS STEELS 400SERIES		TITANIUM		INCONEL	
HARDNESS	~HB 230									
STRENGTH	~1000N/mm <sup>2</sup>									
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	7270	1240	6060	920	5660	860	4440	670	1450	120
8.0	5450	1040	4540	720	4240	670	3330	520	1090	110
10.0	4360	1100	3630	690	3390	640	2660	500	870	110
12.0	3630	1150	3030	960	3830	820	2220	560	720	130
14.0	3110	1080	2600	850	2420	770	1900	540	620	140
16.0	2720	1040	2270	780	2120	720	1660	520	540	130
18.0	2420	1000	2020	710	1880	670	1480	510	480	130
20.0	2180	970	1810	690	1690	640	1330	500	430	130
25.0	1740	880	1450	640	1350	600	1060	470	340	130



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