



EP922 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

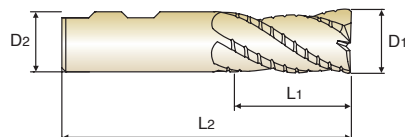
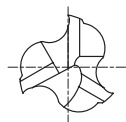
EP923 SERIES

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

YPM, 3 FLUTE 42° HELIX SHORT LENGTH ROUGHING TiAIN COATED PREMIUM HSS-PM, 3 SCHNEIDEN 42° RECHTSSPIRALE KURZ SCHRUPPFÄRÄSER TiAIN-BESCHICHTET

- ▶ Maximum metal removal rate at High Speed Condition
- ▶ Reduces vibrations and improves surface roughness
- ▶ Reduces chipping of corner edges

- ▶ Maximale Zerspanungsleistung bei der High-Speed-Bearbeitung (HSC)
- ▶ Reduziert Vibrationen und verbessert die Oberflächenrauigkeit
- ▶ Reduzierung von Schneideckenausbrüchen.



P.981

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT	D1(js12)	D2(h6)	L1	L2
EP922120	EP923120	12.0	12	26	83
EP922140	EP923140	14.0	12	26	83
EP922160	EP923160	16.0	16	32	92
EP922180	EP923180	18.0	16	32	92
EP922200	EP923200	20.0	20	38	104
EP922220	EP923220	22.0	20	38	104
EP922250	EP923250	25.0	25	45	121
EP922280	EP923280	28.0	25	45	121
EP922320	EP923320	32.0	32	53	133

Tolerances according to DIN 7160 & 7161

Toleranzen nach DIN 7160 & 7161

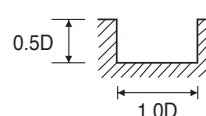
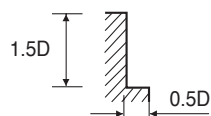
Tolerance range in μm / Toleranzwerte in μm						
Nominal-Diameter in mm / Nennmaßbereich in mm						
	from 1 to 3 von 1 bis 3	over 3 to 6 über 3 bis 6	over 6 to 10 über 6 bis 10	over 10 to 18 über 10 bis 18	over 18 to 30 über 18 bis 30	over 30 to 50 über 30 bis 50
js12	± 50	± 60	± 75	± 90	± 105	± 125
h6	0 — 6	0 — 8	0 — 9	0 — 11	0 — 13	0 — 16

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRC30~40	HRC40~45	HRC45~55	HRC55~70									
								○	◎					

YPM, 3 FLUTE 42° HELIX ROUGHING TiAIN COATED
PREMIUM HSS-PM, 3 SCHNEIDEN 42° RECHTSSPIRALE SCHRUPPFÄRÄSER TiAIN-BESCHICHTET
EP922, EP923, EP924, EP925 SERIES

MATERIAL	ALUMINUM ALUMINUM ALLOY							
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
12.0	2800	550	105	0.065	2800	410	105	0.049
14.0	2500	600	110	0.080	2500	450	110	0.060
16.0	2200	625	110	0.095	2200	465	110	0.070
18.0	1950	680	110	0.116	1950	510	110	0.087
20.0	1700	700	105	0.137	1700	525	105	0.103
22.0	1600	685	110	0.143	1600	515	110	0.107
25.0	1400	625	110	0.149	1400	465	110	0.111
28.0	1250	675	110	0.180	1250	505	110	0.135
32.0	1100	700	110	0.212	1100	525	110	0.159



RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t