



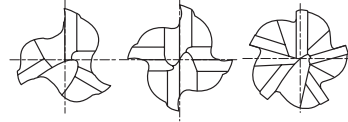
PLAIN SHANK
GLATTER ZYLINDERSCHAFT

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, MULTI FLUTE LONG LENGTH ROUGHING - FINE VOLLHARTMETALL, MULTI SCHNEIDEN LANG SCHRUPPFRÄSER - FEIN

- ▶ Longer flute length than EH852, EH862.
- ▶ Suitable for low hardness materials (under HRC45), alloy steels, tool steels, carbon steels, prehardened steels, stainless steels, etc.
- ▶ High velocity milling operation.
- ▶ Fast chip ejection.

- ▶ Längere Schneiden als bei EH852 und EH862.
- ▶ zur Bearbeitung von: Werkstoffen bis 45 HRC, rostfreien Stählen, Titan und Nickellegierungen..
- ▶ Hochgeschwindigkeitsfräsen.
- ▶ Schnelle Spanausfuhr.



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
PLAIN	FLAT	h10	h6			
EH831060	EH841060	6.0	6	16	57	3
EH831070	EH841070	7.0	8	16	63	3
EH831080	EH841080	8.0	8	16	63	3
EH831090	EH841090	9.0	10	19	72	4
EH831100	EH841100	10.0	10	22	72	4
EH831120	EH841120	12.0	12	26	83	4
EH831140	EH841140	14.0	14	26	83	4
EH831160	EH841160	16.0	16	32	92	4
EH831180	EH841180	18.0	18	32	92	4
EH831200	EH841200	20.0	20	38	104	4
EH831250	EH841250	25.0	25	45	121	5

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
h10	0 - 40	0 - 48	0 - 58	0 - 70	0 - 84
h6	0 - 6	0 - 8	0 - 9	0 - 11	0 - 13

◎ : 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									
○	◎	◎	○							◎	◎	○		

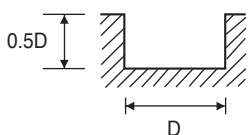


RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

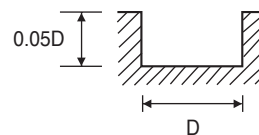
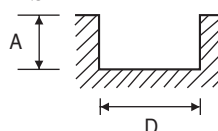
CARBIDE, MULTI FLUTE ROUGHING - SLOTING
VOLLHARTMETALL, MULTI SCHNEIDEN SCHRUPPFÄSER

EH852, EH862, EH831, EH841 SERIES

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				STAINLESS STEELS TITANIUM ALLOY				INCONEL			
	~ HRC30				HRC30 ~ HRC45											
HARDNESS	1000N/mm ²				1000 ~ 1500N/mm ²											
STRENGTH																
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	15600	1390	294	0.030	12400	500	234	0.013	8400	340	158	0.013	2400	115	45	0.016
8.0	11600	1390	292	0.040	9200	500	231	0.018	6300	340	158	0.018	1800	110	45	0.020
10.0	9200	1390	289	0.038	7600	500	239	0.016	5100	340	160	0.017	1300	115	41	0.022
12.0	8000	1440	302	0.045	6000	480	226	0.020	4200	340	158	0.020	1200	115	45	0.024
14.0	6800	1440	299	0.053	5200	500	229	0.024	3600	340	158	0.024	900	80	40	0.022
16.0	6000	1440	302	0.060	4800	460	241	0.024	3300	310	166	0.023	800	65	40	0.020
18.0	5200	1390	294	0.067	4400	430	249	0.024	2700	250	153	0.023	700	60	40	0.021
20.0	4800	1300	302	0.068	3600	340	226	0.024	2400	220	151	0.023	660	60	41	0.023
25.0	4300	1290	338	0.060	3200	370	251	0.023	2160	250	170	0.023	600	65	47	0.022



A: $\varnothing 4$ - $\varnothing 10$: $0.25 \times D$
 $\varnothing 12$ - $\varnothing 16$: $0.15 \times D$
 $\varnothing 18$ - $\varnothing 25$: $0.10 \times D$



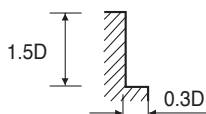
※ The FEED, in long & long reach types, should be reduced by around 50%

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

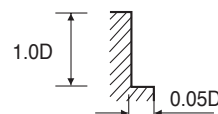
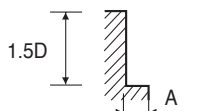
CARBIDE, MULTI FLUTE ROUGHING - SIDE CUTTING
VOLLHARTMETALL, MULTI SCHNEIDEN SCHRUPPFÄSER

EH852, EH862, EH831, EH841 SERIES

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				STAINLESS STEELS TITANIUM ALLOY				INCONEL			
	~ HRC30				HRC30 ~ HRC45											
HARDNESS	1000N/mm ²				1000 ~ 1500N/mm ²											
STRENGTH																
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	15600	2320	294	0.050	12400	840	234	0.023	8400	570	158	0.023	2400	190	45	0.026
8.0	11600	2320	292	0.067	9200	840	231	0.030	6300	570	158	0.030	1800	180	45	0.033
10.0	9200	2320	289	0.063	7600	840	239	0.028	5100	570	160	0.028	1300	190	41	0.037
12.0	8000	2400	302	0.075	6000	800	226	0.033	4200	570	158	0.034	1200	190	45	0.040
14.0	6800	2400	299	0.088	5200	840	229	0.040	3600	570	158	0.040	900	130	40	0.036
16.0	6000	2400	302	0.100	4800	760	241	0.040	3300	510	166	0.039	800	110	40	0.034
18.0	5200	2320	294	0.112	4400	720	249	0.041	2700	420	153	0.039	700	100	40	0.036
20.0	4800	2160	302	0.113	3600	560	226	0.039	2400	360	151	0.038	660	100	41	0.038
25.0	4300	2150	338	0.100	3200	620	251	0.039	2160	410	170	0.038	600	110	47	0.037



A: $\varnothing 4$ - $\varnothing 10$: $0.15 \times D$
 $\varnothing 12$ - $\varnothing 16$: $0.10 \times D$
 $\varnothing 18$ - $\varnothing 25$: $0.05 \times D$



※ The FEED, in long & long reach types, should be reduced by around 50%

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