



EH830 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

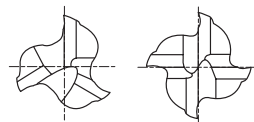
EH840 SERIES

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 3&4 FLUTE 50° HELIX LONG LENGTH VOLLHARTMETALL, 3&4 SCHNEIDEN 50° RECHTSSPIRALE LANG

- ▶ Ultra micro grain carbide
- ▶ Reduces chipping of corner edges
- ▶ Suitable for low hardness materials (under HRC45), alloy steels, tool steels, carbon steels, prehardened steels, stainless steels, etc

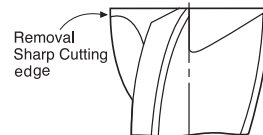
- ▶ Ultra Feinstkorn - Vollhartmetall
- ▶ Verstärkte Schneidkante.
- ▶ zur Bearbeitung von: Werkstoffen bis 45 HRC, rostfreien Stählen, Titan und Nickellegierungen.



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
PLAIN	FLAT					
EH830060	EH840060	6.0	6	13	50	3
EH830080	EH840080	8.0	8	19	60	3
EH830100	EH840100	10.0	10	22	70	3
EH830120	EH840120	12.0	12	25	75	3
EH830160	EH840160	16.0	16	32	90	3
EH830180	EH840180	18.0	18	32	90	3
EH830200	EH840200	20.0	20	38	100	4
EH830250	EH840250	25.0	25	45	120	4

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

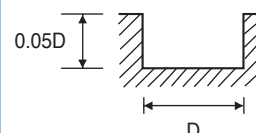
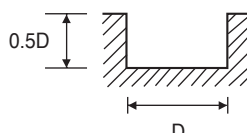


◎ : Excellent ○ : Good

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

CARBIDE, 3&4 FLUTE 50° HELIX LONG - SLOTTING
VOLLHARTMETALL, 3&4 SCHNEIDEN 50° RECHTSSPIRALE LANG - NUTENFRÄSEN
EH830, EH840 SERIES

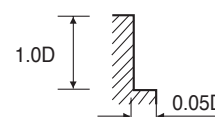
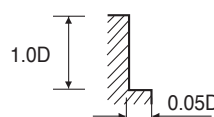
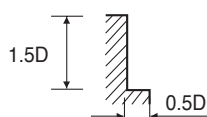
MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				STAINLESS STEELS TITANIUM ALLOY				INCONEL			
HARDNESS	~ HRC30				HRC30 ~ HRC45											
STRENGTH	1000N/mm ²				1000 ~ 1500N/mm ²											
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	5560	310	105	0.019	3360	200	65	0.020	2840	160	55	0.019	1160	40	20	0.011
8.0	4200	340	105	0.027	2520	180	65	0.024	2100	160	55	0.025	840	40	20	0.016
10.0	3260	300	100	0.031	2000	140	65	0.023	1680	140	55	0.028	670	40	20	0.020
12.0	2740	250	105	0.030	1680	120	65	0.024	1370	120	50	0.029	560	30	20	0.018
16.0	2200	200	110	0.030	1360	100	70	0.025	1050	100	55	0.032	420	25	20	0.020
18.0	1940	175	110	0.030	1210	85	70	0.023	950	85	55	0.030	370	20	20	0.018
20.0	1680	150	105	0.022	1060	70	65	0.017	840	70	55	0.021	320	20	20	0.016
25.0	1360	115	105	0.021	840	60	65	0.018	670	60	55	0.022	270	15	20	0.014



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

CARBIDE, 3&4 FLUTE 50° HELIX - SIDE CUTTING
VOLLHARTMETALL, 3&4 SCHNEIDEN 50° RECHTSSPIRALE - SEITENFRÄSEN
EH830, EH840 SERIES

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				STAINLESS STEELS TITANIUM ALLOY				INCONEL			
HARDNESS	~ HRC30				HRC30 ~ HRC45											
STRENGTH	1000N/mm ²				1000 ~ 1500N/mm ²											
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	5560	400	105	0.024	3360	250	65	0.025	2840	250	55	0.029	1050	55	20	0.017
8.0	4200	420	105	0.033	2520	230	65	0.030	2100	265	55	0.042	840	50	20	0.020
10.0	3260	370	100	0.038	2000	180	65	0.030	1680	230	55	0.046	680	50	20	0.025
12.0	2740	310	105	0.038	1680	150	65	0.030	1370	180	50	0.044	560	45	20	0.027
16.0	2200	250	110	0.038	1360	120	70	0.029	1050	150	55	0.048	420	35	20	0.028
18.0	1940	220	110	0.038	1210	110	70	0.030	950	130	55	0.046	370	30	20	0.027
20.0	1680	190	105	0.028	1060	95	65	0.022	840	115	55	0.034	340	30	20	0.022
25.0	1360	150	105	0.028	840	75	65	0.022	670	90	55	0.034	270	25	20	0.023



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