



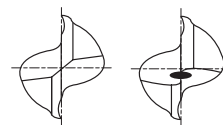
PLAIN SHANK
GLATTER ZYLINDERSCHAFT

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 2 FLUTE 35° HELIX SHORT LENGTH
VOLLHARTMETALL, 2 SCHNEIDEN 35° RECHTSSPIRALE KURZ

- ▶ 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.



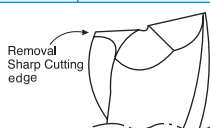
up to Ø3mm over Ø3mm



Unit : mm

	EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
	PLAIN	FLAT				
	EH911010	-	1.0	4	2.5	40
	EH911901	EH912901	1.0	6	2.5	40
	EH911015	-	1.5	4	4	40
	EH911902	EH912902	1.5	6	4	40
	EH911020	-	2.0	4	6	40
	EH911903	EH912903	2.0	6	6	40
	EH911025	-	2.5	4	8	40
	EH911904	EH912904	2.5	6	8	40
	EH911030	EH912030	3.0	6	8	45
	EH911035	EH912035	3.5	6	10	45
	EH911040	EH912040	4.0	6	11	45
	EH911045	EH912045	4.5	6	11	45
	EH911050	EH912050	5.0	6	13	50
	EH911055	EH912055	5.5	6	13	50
	EH911060	EH912060	6.0	6	13	50
	EH911065	EH912065	6.5	8	16	60
	EH911070	EH912070	7.0	8	16	60
	EH911075	EH912075	7.5	8	16	60
	EH911080	EH912080	8.0	8	19	60
	EH911085	EH912085	8.5	10	19	70
	EH911090	EH912090	9.0	10	19	70
	EH911095	EH912095	9.5	10	19	70
	EH911100	EH912100	10.0	10	22	70
	EH911110	EH912110	11.0	12	22	75
	EH911120	EH912120	12.0	12	26	75
	EH911140	EH912140	14.0	16	26	85
	EH911160	EH912160	16.0	16	32	100
	EH911180	EH912180	18.0	16	32	100
	EH911200	EH912200	20.0	20	38	105
	EH911220	EH912220	22.0	20	38	105
	EH911250	EH912250	25.0	25	45	120

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									
○	◎	◎	○						◎	◎			

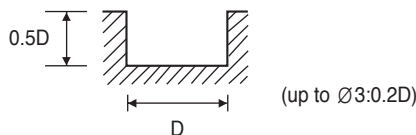


RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 2 FLUTE SHORT - SLOTTING
VOLLHARTMETALL, 2 SCHNEIDEN KURZ - NUTENFRÄSEN

EH911, EH912 SERIES

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				STAINLESS STEELS TITANIUM ALLOY			
	~ 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
2.0	11560	190	75	0.008	7560	120	50	0.008	6300	90	40	0.007
3.0	8920	210	85	0.012	5560	140	50	0.013	4620	120	45	0.013
4.0	7560	300	95	0.020	4620	180	60	0.019	3880	150	50	0.019
5.0	6300	320	100	0.025	3780	190	60	0.025	3160	160	50	0.025
6.0	5560	350	105	0.031	3360	220	65	0.033	2840	180	55	0.032
8.0	4200	380	105	0.045	2520	200	65	0.040	2100	180	55	0.043
10.0	3260	330	100	0.051	2000	160	65	0.040	1680	160	55	0.048
12.0	2740	280	105	0.051	1680	130	65	0.039	1360	130	50	0.048
16.0	2200	220	110	0.050	1360	110	70	0.040	1060	110	55	0.052
20.0	1680	170	105	0.051	1060	80	65	0.038	840	80	55	0.048
25.0	1360	130	105	0.048	840	70	65	0.042	680	60	55	0.044

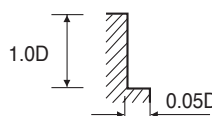


RPM = rev./min. Vc = m/min.
FEED = mm/min. fz = mm/t

CARBIDE, 4 FLUTE SHORT - SIDE CUTTING
VOLLHARTMETALL, 4 SCHNEIDEN KURZ - SEITENFRÄSEN

EH913, EH914 SERIES

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				STAINLESS STEELS TITANIUM ALLOY			
	~ 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
2.0	11560	280	75	0.006	7560	170	50	0.006	6300	140	40	0.006
3.0	8920	320	85	0.009	5560	200	50	0.009	4620	170	45	0.009
4.0	7560	570	95	0.019	4620	350	60	0.019	3880	280	50	0.018
5.0	6300	600	100	0.024	3780	360	60	0.024	3160	300	50	0.024
6.0	5560	660	105	0.030	3360	410	65	0.031	2840	330	55	0.029
8.0	4200	710	105	0.042	2520	380	65	0.038	2100	350	55	0.042
10.0	3260	610	100	0.047	2000	300	65	0.038	1680	300	55	0.045
12.0	2740	520	105	0.047	1680	250	65	0.037	1360	240	50	0.044
16.0	2200	410	110	0.047	1360	200	70	0.037	1060	200	55	0.047
20.0	1680	320	105	0.048	1060	160	65	0.038	840	150	55	0.045
25.0	1360	250	105	0.046	840	130	65	0.039	680	120	55	0.044



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