JET-POWER END MILLS

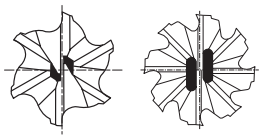
EH915 SERIES PLAIN SHANK GLATTER ZYLINDERSCHAFT

EH916 SERIES FLAT SHANK SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 6&8 FLUTE 45° HELIX LONG LENGTH (Positive Rake Angle)
VOLLHARTMETALL, 6&8 SCHNEIDEN 45° 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.

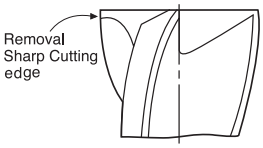


MG HM | 6&8 | 45° | PLAIN | FLAT P.926

Unit : mm

EDP No. PLAIN	EDP No. FLAT	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
EH915060	EH916060	6.0	6	13	57	6
EH915070	EH916070	7.0	8	16	63	6
EH915080	EH916080	8.0	8	19	63	6
EH915090	EH916090	9.0	10	19	72	6
EH915100	EH916100	10.0	10	22	72	6
EH915120	EH916120	12.0	12	26	83	6
EH915140	EH916140	14.0	14	26	83	6
EH915160	EH916160	16.0	16	32	92	6
EH915180	EH916180	18.0	18	32	92	8
EH915200	EH916200	20.0	20	38	104	8
EH915250	EH916250	25.0	25	44	104	8

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									
○	◎	◎	○							◎	◎	○		

JET-POWER END MILLS

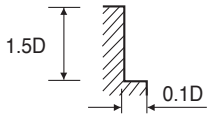
RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

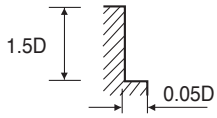
CARBIDE, 6&8 FLUTE 45° HELIX LONG - SIDE CUTTING
VOLLHARTMETALL, 6&8 SCHNEIDEN 45° RECHTSSPIRALE LANG - SEITENFRÄSEN

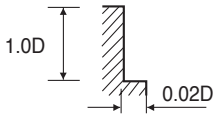
EH915, EH916 SERIES

■ NORMAL SPEED

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS				STAINLESS STEELS TITANIUM ALLOY				INCONEL			
HARDNESS	~ HRc30				HRc30 ~ HRc45											
STRENGTH	1000N/mm²				1000 ~ 1500N/mm²											
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	5560	2000	105	0.060	3880	1370	75	0.059	3370	1100	65	0.054	1350	280	25	0.035
8.0	4200	2000	105	0.079	2940	1370	75	0.078	2490	1100	65	0.074	1000	280	25	0.047
10.0	3360	2000	105	0.099	2320	1370	75	0.098	1920	1100	60	0.095	440	280	15	0.106
12.0	2840	1680	105	0.099	2000	1160	75	0.097	1610	1000	60	0.104	400	250	15	0.104
16.0	2100	1260	105	0.100	1480	880	75	0.099	1160	770	60	0.111	310	190	15	0.102
20.0	1680	1010	105	0.075	1160	690	75	0.074	900	620	55	0.086	250	155	15	0.078
25.0	1500	900	120	0.075	1100	600	85	0.068	850	540	65	0.079	220	135	15	0.077



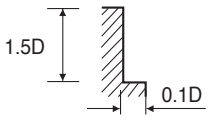


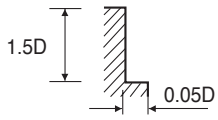


RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

■ HIGH SPEED

MATERIAL	CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS			
HARDNESS	~ HRc30				HRc30 ~ HRc45			
STRENGTH	1000N/mm²				1000 ~ 1500N/mm²			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	22200	8000	420	0.060	16800	6090	315	0.060
8.0	16800	8000	420	0.079	12600	6090	315	0.081
10.0	13400	8000	420	0.100	9980	5990	315	0.100
12.0	11350	6720	430	0.099	8400	5040	315	0.100
16.0	8400	5040	420	0.100	6300	3780	315	0.100
20.0	6700	4040	420	0.075	5040	3050	315	0.076
25.0	6000	3600	470	0.075	4500	2700	355	0.075





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