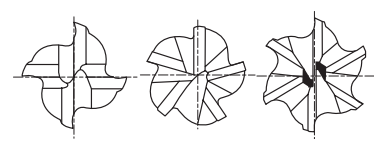


**CARBIDE, MULTI FLUTE 45° HELIX SHORT LENGTH ROUGHING - FINE**  
**VOLLHARTMETALL, MULTI SCHNEIDEN 45° RECHTSSPIRALE KURZ SCHRUPPFRÄSER - FEIN**

- ▶ Ultra micro grain carbide
- ▶ High chip removal and minimizing breakages of cutting edges.
- ▶ Suitable for low hardness materials(under HRc45), alloy steels, tool steels, carbon steels, prehardened steels, stainless steels, etc

- ▶ Ultra Feinstkorn - Vollhartmetall
- ▶ Schnelle Spanausfuhr und Minimierung von Abbrechen von Schneidkanten.
- ▶ zur Bearbeitung von: Werkstoffen bis 45 HRc, rostfreien Stählen, Titan und Nickellegierungen..









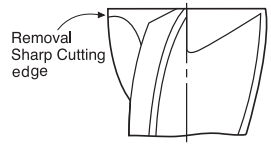
 P.929

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
PLAIN	FLAT	h10	h6			
EH917060	EH918060	6.0	6	7	54	4
EH917080	EH918080	8.0	8	9	58	4
EH917100	EH918100	10.0	10	14	66	4
EH917120	EH918120	12.0	12	16	73	4
EH917160	EH918160	16.0	16	22	82	5
EH917200	EH918200	20.0	20	26	92	6

**Tolerances according to DIN 7160 & 7161**  
**Toleranzen nach DIN 7160 & 7161**

Tolerance range in $\mu\text{m}$ / Toleranzwerte in $\mu\text{m}$					
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
<b>h10</b>	0 - 40	0 - 48	0 - 58	0 - 70	0 - 84
<b>h6</b>	0 - 6	0 - 8	0 - 9	0 - 11	0 - 13

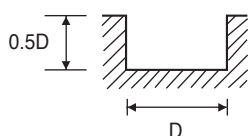


◎ : Excellent ○ : Good

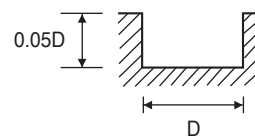
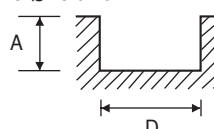
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
○	◎	◎	○							◎	◎	○		

**CARBIDE, MULTI FLUTE ROUGHING - SLOTING**  
**VOLLHARTMETALL, MULTI SCHNEIDEN SCHRUPPFRÄSER**
**EH917, EH918, EH921, EH942 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 <sup>2</sup>				1000 ~ 1500N/mm <sup>2</sup>											
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	15600	1390	294	0.022	12400	500	234	0.010	8400	340	158	0.010	2400	115	45	0.012
8.0	11600	1390	292	0.030	9200	500	231	0.014	6300	340	158	0.013	1800	110	45	0.015
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
16.0	6000	1440	302	0.048	4800	460	241	0.019	3300	310	166	0.019	800	65	40	0.016
20.0	4800	1300	302	0.045	3600	340	226	0.016	2400	220	151	0.015	660	60	41	0.015



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

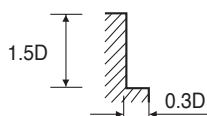


※ The FEED, in long & long reach types, should be reduced by around 50%

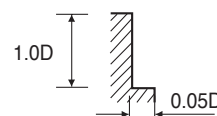
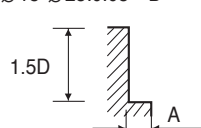
RPM = rev./min.  
 FEED = mm/min.  
 Vc = m/min.  
 fz = mm/t

**CARBIDE, MULTI FLUTE ROUGHING - SIDE CUTTING**  
**VOLLHARTMETALL, MULTI SCHNEIDEN SCHRUPPFRÄSER**
**EH917, EH918, EH921, EH942 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 <sup>2</sup>				1000 ~ 1500N/mm <sup>2</sup>											
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	15600	2320	294	0.037	12400	840	234	0.017	8400	570	158	0.017	2400	190	45	0.020
8.0	11600	2320	292	0.050	9200	840	231	0.023	6300	570	158	0.023	1800	180	45	0.025
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
16.0	6000	2400	302	0.080	4800	760	241	0.032	3300	510	166	0.031	800	110	40	0.028
20.0	4800	2160	302	0.075	3600	560	226	0.026	2400	360	151	0.025	660	100	41	0.025



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



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

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