



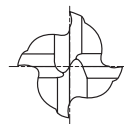
PLAIN SHANK
GLATTER ZYLINDERSCHAFT

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 4 FLUTE LONG LENGTH VOLLHARTMETALL, 4 SCHNEIDEN LANG

- ▶ Special flute geometry eliminates vibrations
- ▶ Designed to mild steels, stainless steels, cast iron, tool steels, titanium alloys, prehardened steels and low hardness materials under HRc 40
- ▶ Excellent work piece finishes
- ▶ Higher speeds, deeper cuts and metal removal rates

- ▶ Spezielle Schneidengeometrie verhindert Vibrationen
- ▶ Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
- ▶ Bessere Werkstückoberflächen.
- ▶ Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen



Unit : mm

EDP No.		Mill Diameter	Shank Diameter h6	Length of Cut	Overall Length
PLAIN	FLAT				
EMB14030	EMB39030	3.0	6	8	57
EMB14040	EMB39040	4.0	6	11	57
EMB14050	EMB39050	5.0	6	13	57
EMB14060	EMB39060	6.0	6	13	57
EMB14080	EMB39080	8.0	8	19	63
EMB14100	EMB39100	10.0	10	22	72
EMB14120	EMB39120	12.0	12	26	83
EMB14140	EMB39140	14.0	14	26	83
EMB14160	EMB39160	16.0	16	32	92
EMB14180	EMB39180	18.0	18	32	92
EMB14200	EMB39200	20.0	20	38	104
EMB14250	EMB39250	25.0	25	38	104

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

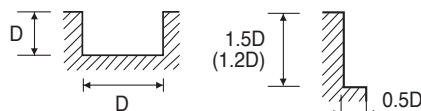
◎ : Excellent ○ : Good

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, 4 FLUTE
VOLLHARTMETALL, 4 SCHNEIDEN

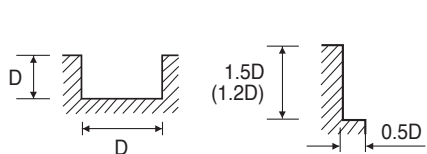
EMB41, EMB42, EMB43, EMB44, EMB14, EMB39, EMB15, EMB40, EMC84, EMC85, EME31, EME32 SERIES

MATERIAL	ALLOY STEELS CAST IRON				STAINLESS STEELS 300SERIES				STAINLESS STEELS 400SERIES			
HARDNESS	~HB230				HRC30 ~ HRC45							
STRENGTH	~1000N/mm ²				1000 ~ 1500N/mm ²							
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
3.0	13475	275	125	0.005	10185	195	95	0.005	14260	205	135	0.004
4.0	10105	330	125	0.008	7600	250	95	0.008	14260	255	180	0.004
5.0	8085	370	125	0.011	6110	310	95	0.013	8655	310	135	0.009
6.0	6735	435	125	0.016	5095	360	95	0.018	7130	360	135	0.013
8.0	5050	555	125	0.027	3820	435	95	0.028	5345	465	135	0.022
10.0	4455	690	140	0.039	3055	590	95	0.048	4275	585	135	0.034
12.0	3710	695	140	0.047	2545	565	95	0.056	3565	565	135	0.040
14.0	3180	620	140	0.049	2180	520	95	0.060	3055	520	135	0.043
16.0	2785	590	140	0.053	1910	480	95	0.063	2670	480	135	0.045
18.0	2475	585	140	0.059	1695	475	95	0.070	2375	475	135	0.050
20.0	2225	580	140	0.065	1525	470	95	0.077	2140	470	135	0.055
25.0	1780	450	140	0.063	1215	380	95	0.078	1710	380	135	0.056

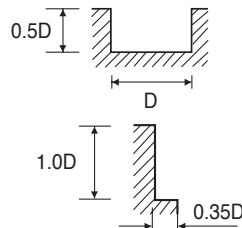


*() : short length type
1.2 x D Axial cutting depth should be applied for Short length series diameter over 8mm

MATERIAL	TITANIUM				INCONEL			
HARDNESS								
STRENGTH								
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
3.0	10185	205	95	0.005	2715	55	25	0.005
4.0	7600	255	95	0.008	2005	55	25	0.007
5.0	6110	310	95	0.013	1630	80	25	0.012
6.0	5095	360	95	0.018	1355	95	25	0.018
8.0	3280	465	80	0.035	1015	125	25	0.031
10.0	3055	585	95	0.048	815	155	25	0.048
12.0	2545	565	95	0.056	675	150	25	0.056
14.0	2180	520	95	0.060	580	140	25	0.060
16.0	1910	480	95	0.063	505	130	25	0.064
18.0	1695	475	95	0.070	450	125	25	0.069
20.0	1525	470	95	0.077	405	125	25	0.077
25.0	1215	380	95	0.078	320	110	25	0.086



1.2 x D Axial cutting depth should be applied for Short length series diameter over 8mm



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