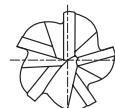


CARBIDE, 5 FLUTE LONG LENGTH VOLLHARTMETALL, 5 SCHNEIDEN LANG

- ▶ 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



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Unit : mm

EDP No.		Mill Diameter	Shank Diameter h6	Length of Cut	Overall Length
PLAIN	FLAT				
EMB72060	EMB73060	6.0	6	13	57
EMB72080	EMB73080	8.0	8	19	63
EMB72100	EMB73100	10.0	10	22	72
EMB72120	EMB73120	12.0	12	26	83
EMB72140	EMB73140	14.0	14	26	83
EMB72160	EMB73160	16.0	16	32	92
EMB72180	EMB73180	18.0	18	32	92
EMB72200	EMB73200	20.0	20	38	104
EMB72250	EMB73250	25.0	25	38	104

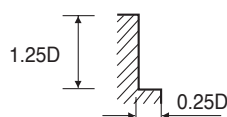
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6

◎ : Excellent ○ : Good

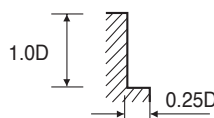
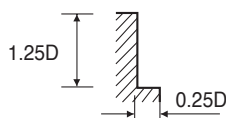
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
◎	○	○								◎	◎	○		

**CARBIDE, 5 FLUTE
VOLLHARTMETALL, 5 SCHNEIDEN**
EMB72, EMB73 SERIES

MATERIAL	ALLOY STEELS CAST IRON				STAINLESS STEELS 300SERIES				STAINLESS STEELS 400SERIES			
HARDNESS	~HB230											
STRENGTH	~1000N/mm ²											
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
6.0	7270	1240	135	0.034	6060	920	115	0.030	5660	860	105	0.030
8.0	5450	1040	135	0.038	4540	720	115	0.032	4240	670	105	0.032
10.0	4360	1100	135	0.050	3630	690	115	0.038	3390	640	105	0.038
12.0	3630	1150	135	0.063	3030	960	115	0.063	3830	820	145	0.043
14.0	3110	1080	135	0.069	2600	850	115	0.065	2420	770	105	0.064
16.0	2720	1040	135	0.076	2270	780	115	0.069	2120	720	105	0.068
20.0	2180	970	135	0.089	1810	690	115	0.076	1690	640	105	0.076



MATERIAL	TITANIUM				INCONEL			
HARDNESS								
STRENGTH								
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
6.0	4440	670	85	0.030	1450	120	25	0.017
8.0	3330	520	85	0.031	1090	110	25	0.020
10.0	2660	500	85	0.038	870	110	25	0.025
12.0	2220	560	85	0.050	720	130	25	0.036
14.0	1900	540	85	0.057	620	140	25	0.045
16.0	1660	520	85	0.063	540	130	25	0.048
20.0	1330	500	85	0.075	430	130	25	0.060



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