



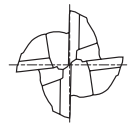
PLAIN SHANK  
GLATTER ZYLINDERSCHAFT

FLAT SHANK  
SEITLICHEN MITNAHMEFLÄCHEN

## CARBIDE, 4 FLUTE MULTIPLE HELIX SHORT LENGTH VOLLHARTMETALL, 4 SCHNEIDEN MEHRSCHEIDIG FRÄSER KURZ

- ▶ Special flute geometry and multiple helix eliminate vibrations
- ▶ Designed to machine mild steels, cast irons, tool steels, and low hardened steels up to HRc 40.
- ▶ Excellent work piece finishes.
- ▶ Higher speeds, deeper cuts, and higher metal removal rates.

- ▶ Besondere Nutenform und variable Drallsteigung verhindern Vibrationen.
- ▶ Für die Bearbeitung von Baustahl, Guss, Werkzeugstahl und niedrig legierten Stählen bis HRc40.
- ▶ Ausgezeichnete Werkstückoberfläche.
- ▶ Höhere Schnittgeschwindigkeit, tieferer Schnitt und größeres Entspannungsvolumen.



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT				
EMD42030	EMD43030	3.0	6	5	50
EMD42040	EMD43040	4.0	6	8	54
EMD42050	EMD43050	5.0	6	9	54
EMD42060	EMD43060	6.0	6	10	54
EMD42080	EMD43080	8.0	8	12	58
EMD42100	EMD43100	10.0	10	14	66
EMD42120	EMD43120	12.0	12	16	73
EMD42140	EMD43140	14.0	14	18	75
EMD42160	EMD43160	16.0	16	22	82
EMD42180	EMD43180	18.0	18	24	84
EMD42200	EMD43200	20.0	20	26	92

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									
◎	◎	◎	○					○		○				

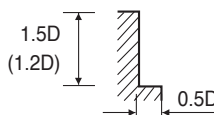
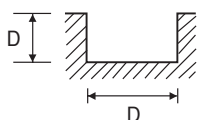


**RECOMMENDED CUTTING CONDITIONS**  
**EMFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 4 FLUTE**  
**VOLLHARTMETALL, 4 SCHNEIDEN**

**EMD42, EMD43, EMD44, EMD45, EMD38, EMD39, EMD40, EMD41, EME05, EME06, EME33, EME34** SERIES

MATERIAL	ALLOY STEELS TOOL STEELS CARBON STEELS				ALLOY STEELS TOOL STEELS CARBON STEELS			
	HARDNESS	~ HB 300				HB 300 ~ HB 380		
STRENGTH	~ 1000N/mm <sup>2</sup>				1000 ~ 1300N/mm <sup>2</sup>			
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
3.0	13475	275	125	0.005	9430	190	90	0.005
4.0	10105	330	125	0.008	7070	230	90	0.008
5.0	8085	370	125	0.011	5660	260	90	0.011
6.0	6735	435	125	0.016	4715	305	90	0.016
8.0	5050	555	125	0.027	3535	385	90	0.027
10.0	4455	690	140	0.039	3115	480	100	0.039
12.0	3710	695	140	0.047	2600	485	100	0.047
14.0	3180	620	140	0.049	2225	435	100	0.049
16.0	2785	590	140	0.053	1950	410	100	0.053
18.0	2475	585	140	0.059	1730	410	100	0.059
20.0	2225	580	140	0.065	1560	405	100	0.065
25.0	1780	450	140	0.063	1245	315	100	0.063



\* ( ) : Short length Type

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

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