



EME05 SERIES

PLAIN SHANK
GLATTER ZYLINDERSCHAFT

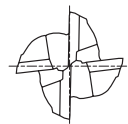
EME06 SERIES

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 4 FLUTE MULTIPLE HELIX with EXTENDED NECK VOLLHARTMETALL, 4 SCHNEIDEN MEHRSCHEIDIG FRÄSER mit ABGESETZTEM SCHAFTTETEL

- ▶ 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 h6	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
PLAIN	FLAT						
EME05030	EME06030	3.0	6	7	12	54	2.7
EME05913	EME06913	3.0	6	7	17	57	2.7
EME05040	EME06040	4.0	6	8	15	57	3.7
EME05914	EME06914	4.0	6	8	22	63	3.7
EME05050	EME06050	5.0	6	10	17	57	4.7
EME05915	EME06915	5.0	6	10	27	67	4.7
EME05060	EME06060	6.0	6	10	15	57	5.5
EME05901	EME06901	6.0	6	10	20	62	5.5
EME05902	EME06902	6.0	6	10	32	74	5.5
EME05080	EME06080	8.0	8	12	20	63	7.5
EME05903	EME06903	8.0	8	12	30	73	7.5
EME05904	EME06904	8.0	8	12	46	90	7.5
EME05100	EME06100	10.0	10	14	25	72	9.2
EME05905	EME06905	10.0	10	14	35	82	9.2
EME05906	EME06906	10.0	10	14	55	102	9.2
EME05120	EME06120	12.0	12	16	30	83	11
EME05907	EME06907	12.0	12	16	40	93	11
EME05908	EME06908	12.0	12	16	64	117	11
EME05160	EME06160	16.0	16	22	38	92	15
EME05909	EME06909	16.0	16	22	55	109	15
EME05910	EME06910	16.0	16	22	87	141	15
EME05200	EME06200	20.0	20	26	50	104	19
EME05911	EME06911	20.0	20	26	70	124	19
EME05912	EME06912	20.0	20	26	110	164	19

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									
◎	◎	◎	○					○		○				

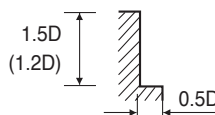
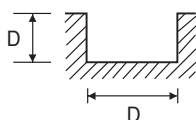


RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

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 ²				1000 ~ 1300N/mm ²			
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