

CARBIDE, 4 FLUTE MULTIPLE HELIX with EXTENDED NECK CORNER RADIUS **VOLLHARTMETALL, 4 SCHNEIDEN MEHRSCHEIDIG FRÄSER mit ABGESETZTEM SCHAFTTETL ECKENRADIUS**

- 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.		Corner Radius R	Mill Diameter	Shank Diameter h6	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
PLAIN	FLAT							
EME33030	EME34030	RO.3	3.0	6	7	12	54	2.7
EME33901	EME34901	RO.3	3.0	6	7	17	57	2.7
EME33040	EME34040	RO.3	4.0	6	8	15	57	3.7
EME33902	EME34902	RO.3	4.0	6	8	22	63	3.7
EME33050	EME34050	RO.3	5.0	6	10	17	57	4.7
EME33903	EME34903	RO.3	5.0	6	10	27	67	4.7
EME33060	EME34060	RO.5	6.0	6	10	15	57	5.5
EME33904	EME34904	RO.5	6.0	6	10	20	62	5.5
EME33905	EME34905	RO.5	6.0	6	10	32	74	5.5
EME33080	EME34080	RO.5	8.0	8	12	20	63	7.5
EME33906	EME34906	RO.5	8.0	8	12	30	73	7.5
EME33907	EME34907	RO.5	8.0	8	12	46	90	7.5
EME33100	EME34100	RO.5	10.0	10	14	25	72	9.2
EME33908	EME34908	RO.5	10.0	10	14	35	82	9.2
EME33909	EME34909	RO.5	10.0	10	14	55	102	9.2
EME33120	EME34120	RO.7	12.0	12	16	30	83	11
EME33910	EME34910	RO.7	12.0	12	16	40	93	11
EME33911	EME34911	RO.7	12.0	12	16	64	117	11
EME33160	EME34160	R1.0	16.0	16	22	38	92	15
EME33912	EME34912	R1.0	16.0	16	22	55	109	15
EME33913	EME34913	R1.0	16.0	16	22	87	141	15
EME33200	EME34200	R1.0	20.0	20	26	50	104	19
EME33914	EME34914	R1.0	20.0	20	26	70	124	19
EME33915	EME34915	R1.0	20.0	20	26	110	164	19

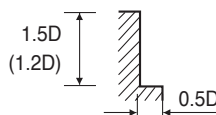
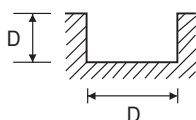
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6

◎ : 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									
◎	◎	◎	○					○		○				


**V7 Mill STEEL
END MILLS**
**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