

CARBIDE, 6&8 FLUTE 45° HELIX LONG LENGTH

VOLLHARTMETALL, 6&8 SCHNEIDEN 45° RECHTSSPIRALE LANG

- Designed to machine hardened materials.
- High speed cutting and finish milling with high feed rates.
- Superior workpiece finishes.
- Superior wear resistant.
- Suitable for dry milling.

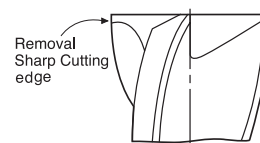
- Geeignet zum Fräsen von hochgehärteten Stählen.
- Hochgeschwindigkeitsfräsen und Finishing mit erhöhtem Vorschub.
- Bessere Werkstückoberflächen
- Höhere Verschleißfestigkeit.
- Geeignet zum Trocken-Fräsen.



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
PLAIN	FLAT					
EM812060	EM822060	6.0	6	13	57	6
EM812070	EM822070	7.0	8	16	63	6
EM812080	EM822080	8.0	8	19	63	6
EM812090	EM822090	9.0	10	19	72	6
EM812100	EM822100	10.0	10	22	72	6
EM812120	EM822120	12.0	12	26	83	6
EM812140	EM822140	14.0	14	26	83	6
EM812901	EM822901	14.0	16	26	83	6
EM812160	EM822160	16.0	16	32	92	6
EM812180	EM822180	18.0	18	32	92	8
EM812200	EM822200	20.0	20	38	104	8
EM812250	EM822250	25.0	25	44	104	8

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

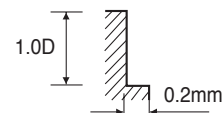
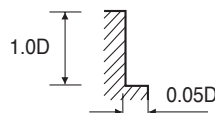
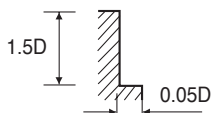
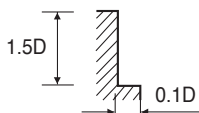


◎ : Excellent ○ : Good

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, 6&8 FLUTE 45° HELIX LONG - SIDE CUTTING
VOLLHARTMETALL, 6&8 SCHNEIDEN 45° RECHTSSPIRALE LANG - SEITENFRÄSEN**
EM812, EM822 SERIES
■ NORMAL SPEED

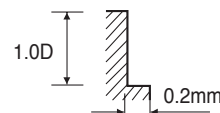
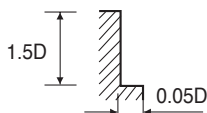
MATERIAL	NON-ALLOYED STEELS ALLOY STEELS				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS				HARDENED STEELS			
HARDNESS	~ HRc30				HRc30 ~ HRc50				HRc50 ~ HRc60				HRc60 ~ HRc65			
STRENGTH	~ 1000N/mm ²				1000 ~ 1750N/mm ²				1750 ~ 2080N/mm ²				2080N/mm ² ~			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	5560	2000	105	0.060	3880	1370	75	0.059	1580	210	30	0.022	1100	130	20	0.020
8.0	4200	2000	105	0.079	2940	1370	75	0.078	1160	210	30	0.030	840	130	20	0.026
10.0	3360	2000	105	0.099	2320	1370	75	0.098	1000	210	30	0.035	680	130	20	0.032
12.0	2840	1680	105	0.099	2000	1160	75	0.097	840	180	30	0.036	560	110	20	0.033
16.0	2100	1260	105	0.100	1480	880	75	0.099	640	130	30	0.034	420	70	20	0.028
20.0	1680	1010	105	0.075	1160	690	75	0.074	500	110	30	0.028	320	60	20	0.023
25.0	1500	900	120	0.075	1100	600	85	0.068	430	90	35	0.026	260	50	20	0.024



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

■ HIGH SPEED

MATERIAL	HEAT RESISTANT STEELS HARDENED STEELS				HARDENED STEELS				HARDENED STEELS			
HARDNESS	~ HRc50				HRc50 ~ HRc60				HRc60 ~ HRc65			
STRENGTH	~ 1750N/mm ²				1750 ~ 2080N/mm ²				2080N/mm ² ~			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	16800	6090	315	0.060	8400	3050	160	0.061	4200	1470	80	0.058
8.0	12600	6090	315	0.081	6300	3050	160	0.081	3160	1470	80	0.078
10.0	9980	5990	315	0.100	5040	3050	160	0.101	2520	1470	80	0.097
12.0	8400	5040	315	0.100	4200	2520	160	0.100	2100	1260	80	0.100
16.0	6300	3780	315	0.100	3160	1890	160	0.100	1580	950	80	0.100
20.0	5040	3050	315	0.076	2520	1470	160	0.073	1260	760	80	0.075
25.0	4500	2700	355	0.075	2200	1300	175	0.074	1120	670	90	0.075



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