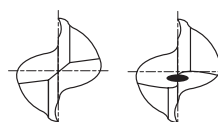


CARBIDE, 2 FLUTE LONG LENGTH VOLLHARTMETALL, 2 SCHNEIDEN LANG

- ▶ Designed to machine tool steels, alloy steels, mold steels and other hardened materials.
- ▶ Superior workpiece finishes.
- ▶ Increased feed rates.

- ▶ Zur Bearbeitung: Werkzeugstählen, Legierten Stählen, Stahlguß und gehärteten Stählen.
- ▶ Bessere Werkstückoberflächen
- ▶ Höhere Vorschübe.



up to Ø3mm over Ø3mm



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT				
EM816020	—	2.0	4	8	40
EM816030	EM826030	3.0	6	12	50
EM816040	EM826040	4.0	6	15	50
EM816050	EM826050	5.0	6	20	60
EM816060	EM826060	6.0	6	20	60
EM816080	EM826080	8.0	8	25	70
EM816100	EM826100	10.0	10	30	90
EM816120	EM826120	12.0	12	30	90
EM816140	EM826140	14.0	16	40	110
EM816160	EM826160	16.0	16	50	110
EM816180	EM826180	18.0	20	50	110
EM816200	EM826200	20.0	20	55	110
EM816250	EM826250	25.0	25	75	140

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, 2 FLUTE MINIATURE - SLOTTING VOLLHARTMETALL, 2 SCHNEIDEN MINI - NUTENFRÄSEN

EM810 SERIES

MATERIAL	ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
HARDNESS	HRC30 ~ HRC45				HRC45 ~ HRC55			
STRENGTH	1000 ~ 1500N/mm ²				1500 ~ 2000N/mm ²			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
0.4	30000	90	40	0.002	23000	50	30	0.001
0.8	24000	150	60	0.003	18000	65	45	0.002
1.0	20000	160	65	0.004	15000	75	45	0.003
1.2	16000	160	60	0.005	12000	75	45	0.003
1.5	12000	150	55	0.006	9000	70	40	0.004

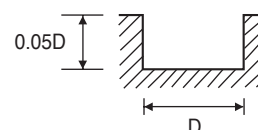
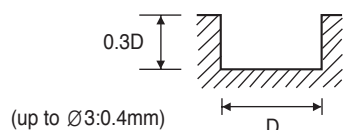
<p>D < 1 Depth=0.15 × D D ≥ 1 Depth=0.25 × D</p>		<p>D < 1 Depth=0.02 × D D ≥ 1 Depth=0.05 × D</p>	
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RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

CARBIDE, 2 FLUTE LONG - SLOTTING VOLLHARTMETALL, 2 SCHNEIDEN LANG - NUTENFRÄSEN

EM816, EM826 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
HARDNESS	~ HRC30				HRC30 ~ HRC45				HRC45 ~ HRC55			
STRENGTH	~ 1000N/mm ²				1000 ~ 1500N/mm ²				1500 ~ 2000N/mm ²			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	7560	70	50	0.005	6050	60	40	0.005	3780	30	25	0.004
3.0	5290	85	50	0.008	4280	70	40	0.008	2640	35	25	0.007
4.0	4280	100	55	0.012	3410	85	45	0.012	2150	40	25	0.009
5.0	3660	125	55	0.017	2900	100	45	0.017	1900	45	30	0.012
6.0	3160	150	60	0.024	2520	125	50	0.025	1640	60	30	0.018
8.0	2400	160	60	0.033	1900	125	50	0.033	1260	60	30	0.024
10.0	2020	160	65	0.040	1640	125	50	0.038	1010	60	30	0.030
12.0	1640	125	60	0.038	1390	115	50	0.041	840	45	30	0.027
16.0	1390	115	70	0.041	1070	90	55	0.042	670	40	35	0.030
20.0	1010	85	65	0.042	820	60	50	0.037	500	30	30	0.030



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