



PLAIN SHANK
GLATTER ZYLINDERSCHAFT

FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 6 FLUTE 45° HELIX EXTRA LONG LENGTH
VOLLHARTMETALL, 6 SCHNEIDEN 45° RECHTSSPIRALE EXTRA 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.

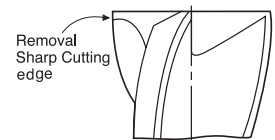


MG HM 6 45° PLAIN FLAT P.891

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT				
EM834060	EM844060	6.0	6	26	70
EM834080	EM844080	8.0	8	36	90
EM834100	EM844100	10.0	10	46	100
EM834120	EM844120	12.0	12	56	110
EM834160	EM844160	16.0	16	66	130
EM834200	EM844200	20.0	20	76	140
EM834250	EM844250	25.0	25	92	180

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



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									
○	◎	◎	◎	○				○						

◎ : Excellent ○ : Good

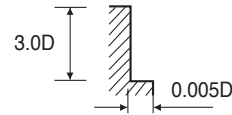
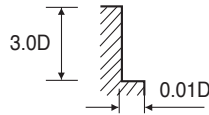


RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 6 FLUTE 45° HELIX EXTRA LONG - SIDE CUTTING
VOLLHARTMETALL, 6 SCHNEIDEN 45° RECHTSSPIRALE EXTRA LANG - SEITENFRÄSEN

EM834, EM844 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS				HARDENED STEELS			
HARDNESS	~ HRc40				HRc40 ~ HRc50				HRc50 ~ HRc60				HRc60 ~ HRc65			
STRENGTH	~ 1250N/mm ²				1250 ~ 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	2230	470	40	0.035	1670	350	30	0.035	1390	250	25	0.030	1110	200	20	0.030
8.0	1670	450	40	0.045	1250	330	30	0.044	1050	240	25	0.038	840	180	20	0.036
10.0	1330	440	40	0.055	1000	300	30	0.050	840	230	25	0.046	680	160	20	0.039
12.0	1110	400	40	0.060	840	270	30	0.054	690	210	25	0.051	560	150	20	0.045
16.0	840	330	40	0.065	630	230	30	0.061	530	170	25	0.053	420	130	20	0.052
20.0	670	280	40	0.070	500	200	30	0.067	420	150	25	0.060	320	120	20	0.063
25.0	540	240	40	0.074	400	170	30	0.071	340	130	25	0.064	270	95	20	0.059



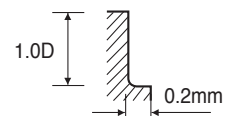
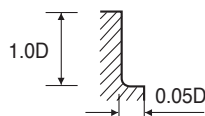
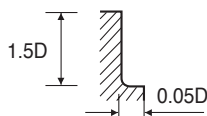
RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

CARBIDE, 6 FLUTE 45° HELIX CORNER RADIUS - SIDE CUTTING
VOLLHARTMETALL, 6 SCHNEIDEN 45° RECHTSSPIRALE ECKENRADIUS - SEITENFRÄSEN

EM835, EM845 SERIES

HIGH SPEED

MATERIAL	ALLOY STEELS HEAT RESISTANT 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	3150	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	3150	1890	160	0.100	1580	950	80	0.100
20.0	5040	3050	315	0.101	2520	1470	160	0.097	1260	760	80	0.101



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

HSS

CBN
END MILLS

i-Xmill
END MILLS

i-HS mill
END MILLS

X5070
END MILLS

4G MILL
END MILLS

X-SPEED
ROUGHER
END MILLS

X-POWER
END MILLS

JET-POWER
END MILLS

TN MILL
END MILLS

V7 Mill
END MILLS

ALU-POWER
END MILLS

CRX S
END MILLS

D-POWER
GRAPHITE
END MILLS

D-POWER
CFRP
END MILLS

ROUTERS

K-2 CARBIDE
END MILLS

GENERAL
CARBIDE
END MILLS

TANK-POWER
END MILLS

GENERAL
HSS
END MILLS

MILLING
CUTTERS

TECHNICAL
DATA