X-POWER END MILLS

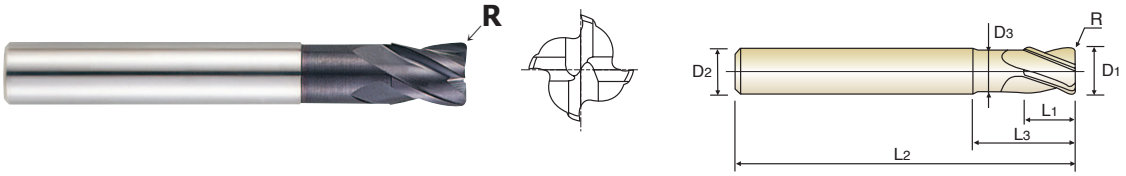
EM839 SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT

EM849 SERIES FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 4 FLUTE STUB LENGTH CORNER RADIUS
VOLLHARTMETALL, 4 SCHNEIDEN EXTRA KURZ ECKENRADIUS

- 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.
- Gesteigerte Vorschubrate.



MG HM | 4 | 30° | PLAIN | FLAT

P.903

Unit : mm

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
PLAIN	FLAT	R	D_1	D_2	L_1	L_3	L_2	D_3
EM839020	**EM849020**	R0.2	**2.0**	6	2.5	5	50	1.9
EM839025	**EM849025**	R0.25	**2.5**	6	3	6	50	2.4
EM839030	**EM849030**	R0.3	**3.0**	6	4	7	50	2.8
EM839035	**EM849035**	R0.35	**3.5**	6	4.5	8	50	3.2
EM839040	**EM849040**	R0.4	**4.0**	6	5	9	50	3.7
EM839050	**EM849050**	R0.5	**5.0**	6	6	12	50	4.6
EM839060	**EM849060**	R0.6	**6.0**	6	7	14	55	5.6
EM839080	**EM849080**	R0.8	**8.0**	8	10	18	60	7.4
EM839100	**EM849100**	R1.0	**10.0**	10	12	25	70	9.4
EM839120	**EM849120**	R1.2	**12.0**	12	15	30	80	11.4
EM839160	**EM849160**	R1.6	**16.0**	16	18	35	90	15.4

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									
○	◎	◎	◎	○				○						

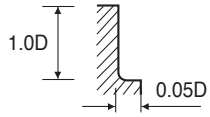
X-POWER END MILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 4 FLUTE STUB CORNER RADIUS - SIDE CUTTING
VOLLHARTMETALL, 4 SCHNEIDEN EXTRA KURZ ECKENRADIUS - SEITENFRÄSEN

EM839, EM849 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS				HARDENED STEELS			
HARDNESS	~ HRc30				HRc30 ~ HRc45				HRc45 ~ HRc55				HRc55 ~ HRc65			
STRENGTH	~ 1000N/mm²				1000 ~ 1500N/mm²				1500 ~ 2000N/mm²				2000N/mm² ~			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	13870	340	85	0.006	9070	205	55	0.006	6050	60	40	0.002				
2.5	12290	360	95	0.007	7870	220	60	0.007	5040	65	40	0.003				
3.0	10700	385	100	0.009	6670	240	65	0.009	4030	70	40	0.004	2280	70	20	0.008
3.5	9890	535	110	0.014	6100	330	65	0.014	3780	70	40	0.005	2030	70	20	0.009
4.0	9070	685	115	0.019	5540	420	70	0.019	3530	70	45	0.005	1780	70	20	0.010
5.0	7560	720	120	0.024	4540	430	70	0.024	2780	85	45	0.008	1510	70	25	0.012
6.0	6670	790	125	0.030	4030	490	75	0.030	2400	95	45	0.010	1320	70	25	0.013
8.0	5040	850	125	0.042	3020	455	75	0.038	2020	130	50	0.016	1010	70	25	0.017
10.0	3910	730	125	0.047	2400	360	75	0.038	1630	110	50	0.017	820	60	25	0.018
12.0	3290	625	125	0.047	2020	300	75	0.037	1390	95	50	0.017	670	60	25	0.022
16.0	2640	490	135	0.046	1630	240	80	0.037	1080	70	55	0.016	530	35	25	0.017

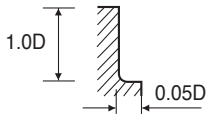


RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

CARBIDE, 6 FLUTE STUB CORNER RADIUS - SIDE CUTTING
VOLLHARTMETALL, 6 SCHNEIDEN EXTRA KURZ ECKENRADIUS - SEITENFRÄSEN

EM897, EM898 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS				HARDENED STEELS			
HARDNESS	~ HRc30				HRc30 ~ HRc45				HRc45 ~ HRc55				HRc55 ~ HRc65			
STRENGTH	~ 1000N/mm²				1000 ~ 1500N/mm²				1500 ~ 2000N/mm²				2000N/mm² ~			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
6.0	6670	790	125	0.020	4030	490	75	0.020	2400	95	45	0.007	1320	70	25	0.009
8.0	5040	850	125	0.028	3020	455	75	0.025	2020	130	50	0.011	1010	70	25	0.012
10.0	3910	730	125	0.031	2400	360	75	0.025	1630	110	50	0.011	820	60	25	0.012
12.0	3290	625	125	0.032	2020	300	75	0.025	1390	95	50	0.011	670	60	25	0.015



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