

# 2 FLUTE, BALL NOSE, STUB CUT LENGTH for OVER HRc55 STEELS 2 SCHNEIDEN, STIRNRADIUS, EXTRA KURZ für Stähle ÜBER HRc55

**SERIES EM868** PLAIN SHANK

GLATTEM ZYLINDERSCHAFT

 MG  
HM

 FLUTE  
2


P.60

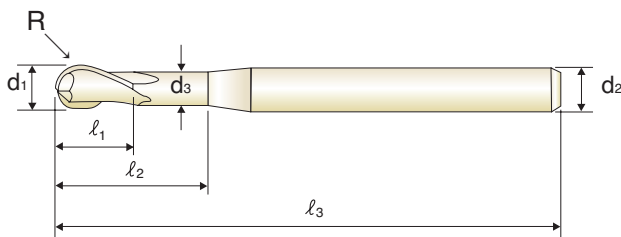
**SERIES EM869** FLAT SHANK

SEITLICHEN MITNAHMEFLÄCHEN



Unit : mm

| EDP No.  |          | R<br>±0.01 | MILL<br>DIAMETER<br>d <sub>1</sub> (e8) | SHANK<br>DIAMETER<br>d <sub>2</sub> (h6) | LENGTH<br>OF CUT<br>ℓ <sub>1</sub> | LENGTH<br>BELOW SHANK<br>ℓ <sub>2</sub> | OVERALL<br>LENGTH<br>ℓ <sub>3</sub> | NECK<br>DIAMETER<br>d <sub>3</sub> |
|----------|----------|------------|-----------------------------------------|------------------------------------------|------------------------------------|-----------------------------------------|-------------------------------------|------------------------------------|
| PLAIN    | FLAT     |            |                                         |                                          |                                    |                                         |                                     |                                    |
| EM868010 | —        | R0.5       | 1.0                                     | 4                                        | 1                                  | 2.2                                     | 50                                  | 0.95                               |
| EM868901 | —        | R0.5       | 1.0                                     | 6                                        | 1                                  | 2.2                                     | 50                                  | 0.95                               |
| EM868012 | —        | R0.6       | 1.2                                     | 4                                        | 1.2                                | 2.6                                     | 50                                  | 1.1                                |
| EM868015 | —        | R0.75      | 1.5                                     | 4                                        | 1.5                                | 3                                       | 50                                  | 1.4                                |
| EM868020 | EM869020 | R1.0       | 2.0                                     | 6                                        | 2                                  | 4                                       | 50                                  | 1.9                                |
| EM868030 | EM869030 | R1.5       | 3.0                                     | 6                                        | 3                                  | 6                                       | 60                                  | 2.9                                |
| EM868040 | EM869040 | R2.0       | 4.0                                     | 6                                        | 4                                  | 8                                       | 70                                  | 3.9                                |
| EM868050 | EM869050 | R2.5       | 5.0                                     | 6                                        | 5                                  | 10                                      | 80                                  | 4.9                                |
| EM868060 | EM869060 | R3.0       | 6.0                                     | 6                                        | 6                                  | 12                                      | 90                                  | 5.9                                |
| EM868070 | EM869070 | R3.5       | 7.0                                     | 8                                        | 7                                  | 14                                      | 90                                  | 6.9                                |
| EM868080 | EM869080 | R4.0       | 8.0                                     | 8                                        | 8                                  | 16                                      | 100                                 | 7.9                                |
| EM868090 | EM869090 | R4.5       | 9.0                                     | 10                                       | 9                                  | 18                                      | 100                                 | 8.9                                |
| EM868100 | EM869100 | R5.0       | 10.0                                    | 10                                       | 10                                 | 20                                      | 100                                 | 9.9                                |
| EM868120 | EM869120 | R6.0       | 12.0                                    | 12                                       | 12                                 | 24                                      | 110                                 | 11.9                               |
| EM868140 | EM869140 | R7.0       | 14.0                                    | 14                                       | 14                                 | 28                                      | 110                                 | 13.8                               |
| EM868160 | EM869160 | R8.0       | 16.0                                    | 16                                       | 16                                 | 32                                      | 140                                 | 15.8                               |
| EM868180 | EM869180 | R9.0       | 18.0                                    | 18                                       | 18                                 | 36                                      | 140                                 | 17.8                               |
| EM868200 | EM869200 | R10.0      | 20.0                                    | 20                                       | 20                                 | 40                                      | 160                                 | 19.8                               |
| EM868250 | EM869250 | R12.5      | 25.0                                    | 25                                       | 25                                 | 50                                      | 180                                 | 24.8                               |


 Tolerances according to DIN 7160 & 7161  
 Toleranzen nach DIN 7160 & 7161

| Toleranzwerte in $\mu\text{m}$ / Tolerance range in $\mu\text{m}$ |                            |                             |                               |                                 |                                 |
|-------------------------------------------------------------------|----------------------------|-----------------------------|-------------------------------|---------------------------------|---------------------------------|
| Nennmaßbereich in mm / Nominal-Diameter in mm                     |                            |                             |                               |                                 |                                 |
|                                                                   | von 1 bis 3<br>from 1 to 3 | über 3 bis 6<br>over 3 to 6 | über 6 bis 10<br>over 6 to 10 | über 10 bis 18<br>over 10 to 18 | über 18 bis 30<br>over 18 to 30 |
| e8                                                                | — 14<br>— 28               | — 20<br>— 38                | — 25<br>— 47                  | — 32<br>— 59                    | — 40<br>— 73                    |
| h6                                                                | — 0<br>— 6                 | — 0<br>— 8                  | — 0<br>— 9                    | — 0<br>— 11                     | — 0<br>— 13                     |

- Suitable for HRc55~HRc70 high hardened materials.  
Geeignet zum Fräsen von HRc55 ~ HRc70
- Strong cutting edges and higher tool rigidity.  
Robuste Schneidkanten und hohe Werkzeughärte.
- Radius tolerance  $\pm 0.01\text{mm}$ .  
Radius Toleranz  $\pm 0.01\text{mm}$ .