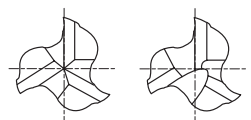


CARBIDE, 3 FLUTE 38° HELIX SHORT LENGTH VOLLHARTMETALL, 3 SCHNEIDEN 38° RECHTSSPIRALE KURZ

- ▶ Designed to machine tool steels, alloy steels, mold steels and other hardened materials.
- ▶ Possesses the advantage of 2 flute and 4 flute end mill.
- ▶ Superior workpiece finishes.

- ▶ Zur Bearbeitung: Werkzeugstählen, Legierten Stählen, Stahlguß und gehärteten Stählen.
- ▶ Besitzt die Vorteile von 2 und 4 Schneiden Fräsern
- ▶ Bessere Werkstückoberflächen



under Ø3mm from Ø3mm



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT				
EM895010	—	1.0	3	2.5	38
EM895015	—	1.5	4	5	50
EM895025	—	2.5	3	7	38
EM895030	—	3.0	3	10	38
EM895901	EM896901	3.0	6	10	50
EM895035	—	3.5	4	12	50
EM895902	EM896902	3.5	6	12	50
EM895040	—	4.0	4	12	50
EM895903	EM896040	4.0	6	12	50
EM895045	EM896045	4.5	6	14	57
EM895050	—	5.0	5	14	50
EM895904	EM896903	5.0	6	14	57
EM895060	EM896060	6.0	6	16	57
EM895080	EM896080	8.0	8	20	63
EM895100	EM896100	10.0	10	22	72
EM895120	EM896120	12.0	12	25	73
EM895140	EM896140	14.0	14	25	75
EM895160	EM896160	16.0	16	32	82
EM895180	EM896180	18.0	18	32	92
EM895200	EM896200	20.0	20	38	92

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									
○	◎	◎	◎	○				○		○				

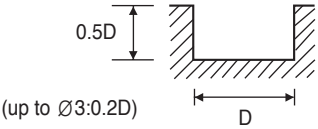


**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN**

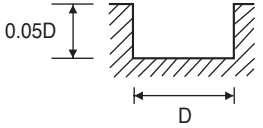
**CARBIDE, 3 FLUTE - SLOTTING
VOLLHARTMETALL, 3 SCHNEIDEN - NUTENFRÄSEN**

EM895, EM896, EM836, EM846 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				STAINLESS STEELS			
HARDNESS	~ HRC30				HRC30 ~ HRC45							
STRENGTH	~ 1000N/mm ²				1000 ~ 1500N/mm ²							
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	11560	170	75	0.005	7560	110	50	0.005	6300	80	40	0.004
3.0	8920	190	85	0.007	5560	130	50	0.008	4620	110	45	0.008
4.0	7560	270	95	0.012	4620	160	60	0.012	3880	130	50	0.011
5.0	6300	280	100	0.015	3780	170	60	0.015	3160	140	50	0.015
6.0	5560	310	105	0.019	3360	200	65	0.020	2840	160	55	0.019
8.0	4200	340	105	0.027	2520	180	65	0.024	2100	160	55	0.025
10.0	3260	300	100	0.031	2000	140	65	0.023	1680	145	55	0.029
12.0	2740	250	105	0.030	1680	120	65	0.024	1360	120	50	0.029
16.0	2200	200	110	0.030	1360	100	70	0.025	1060	100	55	0.031
18.0	1940	175	110	0.030	1210	85	70	0.023	950	85	55	0.030
20.0	1680	150	105	0.030	1060	70	65	0.022	840	70	55	0.028



MATERIAL	HARDENED STEELS				HARDENED STEELS			
HARDNESS	HRC45 ~ HRC55				HRC55 ~ HRC65			
STRENGTH	1500 ~ 2000N/mm ²				2000N/mm ² ~			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	5040	30	30	0.002				
3.0	3360	35	30	0.003	1900	40	20	0.007
4.0	2940	35	35	0.004	1480	35	20	0.008
5.0	2320	45	35	0.006	1260	35	20	0.009
6.0	2000	50	40	0.008	1100	35	20	0.011
8.0	1680	65	40	0.013	840	35	20	0.014
10.0	1360	55	45	0.013	680	30	20	0.015
12.0	1160	50	45	0.014	560	30	20	0.018
16.0	900	35	45	0.013	440	20	20	0.015
18.0	790	30	45	0.013	380	20	20	0.018
20.0	680	25	45	0.012	320	20	20	0.021



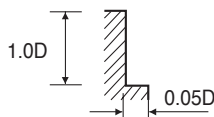
RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t

CARBIDE, 3 FLUTE - SIDE CUTTING VOLLHARTMETALL, 3 SCHNEIDEN - SEITENFRÄSEN

EM895, EM896, EM836, EM846 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				STAINLESS STEELS			
	HARDNESS	~ HRC30				HRC30 ~ HRC45						
STRENGTH	~ 1000N/mm ²				1000 ~ 1500N/mm ²							
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	11560	210	75	0.006	7560	140	50	0.006	6300	115	40	0.006
3.0	8920	240	85	0.009	5560	150	50	0.009	4620	125	45	0.009
4.0	7560	430	95	0.019	4620	260	60	0.019	3880	210	50	0.018
5.0	6300	450	100	0.024	3780	270	60	0.024	3160	230	50	0.024
6.0	5560	500	105	0.030	3360	310	65	0.031	2840	250	55	0.029
8.0	4200	530	105	0.042	2520	290	65	0.038	2100	265	55	0.042
10.0	3260	460	100	0.047	2000	230	65	0.038	1680	230	55	0.046
12.0	2740	390	105	0.047	1680	190	65	0.038	1360	180	50	0.044
16.0	2200	310	110	0.047	1360	150	70	0.037	1060	150	55	0.047
18.0	1940	280	110	0.048	1210	135	70	0.037	950	130	55	0.046
20.0	1680	240	105	0.048	1060	120	65	0.038	840	115	55	0.046

MATERIAL	HARDENED STEELS				HARDENED STEELS			
	HARDNESS	HRC45 ~ HRC55				HRC55 ~ HRC65		
STRENGTH	1500 ~ 2000N/mm ²				2000N/mm ² ~			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	5040	30	30	0.002				
3.0	3360	40	30	0.004	1900	45	20	0.008
4.0	2940	45	35	0.005	1480	45	20	0.010
5.0	2320	55	35	0.008	1260	45	20	0.012
6.0	2000	60	40	0.010	1100	45	20	0.014
8.0	1680	80	40	0.016	840	45	20	0.018
10.0	1360	70	45	0.017	680	35	20	0.017
12.0	1160	60	45	0.017	560	35	20	0.021
16.0	900	45	45	0.017	440	20	20	0.015
18.0	790	35	45	0.015	380	20	20	0.018
20.0	680	30	45	0.015	320	20	20	0.021



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