

PLAIN SHANK
GLÄTTER ZYLINDERSCHAFT

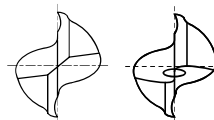
FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 2 FLUTE TAPER

VOLLHARTMETALL, 2 SCHNEIDEN KONISCH
Fraise carbure, 2 dents, conique
2 TAGLIENTI, CONICA

- ▶ Designed for milling die cavity.
- ▶ Suitable for machining tool steels, alloy steels, mold steels and other hardened materials.

- ▶ Entworfen zur Gußformbearbeitung.
- ▶ Zur Bearbeitung: Werkzeugstählen, Legierten Stählen, Stahlguß und gehärteten Stählen.



up to Ø3mm over Ø3mm



Unit : mm

EDP No.	Mill Diameter		Shank Diameter	Length of Cut	Overall Length	Taper Angle
	PLAIN	FLAT				
EM837913	-	2.0	4	6	45	30'
EM837020	-	2.0	4	6	45	1°
EM837901	-	2.0	4	6	45	2°
EM837902	-	2.0	4	6	45	3°
EM837914	EM847914	3.0	6	10	55	30'
EM837030	EM847030	3.0	6	10	55	1°
EM837903	EM847903	3.0	6	10	55	2°
EM837904	EM847904	3.0	6	10	55	3°
EM837915	EM847915	4.0	6	15	55	30'
EM837040	EM847040	4.0	6	15	55	1°
EM837905	EM847905	4.0	6	15	55	2°
EM837906	EM847906	4.0	6	15	55	3°
EM837916	EM847916	5.0	6	15	60	30'
EM837050	EM847050	5.0	6	15	60	1°
EM837907	EM847907	5.0	6	15	60	2°
EM837908	EM847908	5.0	6	15	60	3°
EM837917	EM847917	6.0	6	20	60	30'
EM837060	EM847060	6.0	6	20	60	1°
EM837909	EM847909	6.0	6	20	60	2°
EM837910	EM847910	6.0	8	20	65	3°
EM837918	EM847918	8.0	8	25	70	30'
EM837080	EM847080	8.0	8	25	70	1°
EM837911	EM847911	8.0	8	25	70	2°
EM837912	EM847912	8.0	10	25	75	3°

▶ We can supply various sizes and taper angles.

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance	Taper Angle Tolerance
0~-0.03	h6	±5'

◎ : Excellent ○ : Good

P				H	M	K	N				S		
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Stainless Steels	Cast Iron	Copper	Graphite	Aluminum	Acrylic	CFRP	Titanium	High Temperature Alloy
~HB225	HB225~325	HRC30~40	HRc40~45 HRc45~55	HRc55~70									
○	◎	◎	◎	○		○							

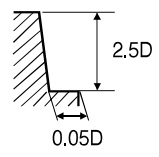


RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 2 FLUTE TAPER - SIDE CUTTING
VOLLHARTMETALL, 2 SCHNEIDEN KONISCH - SEITENFRÄSEN

EM837, EM847 SERIES

MATERIAL	P							
	NON-ALLOYED STEELS ALLOY STEELS				ALLOY STEELS HEAT RESISTANT STEELS			
HARDNESS	~ HRC30				HRC30 ~ HRC45			
STRENGTH	~ 1000N/mm ²				1000 ~ 1500N/mm ²			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	8400	170	55	0.010	6300	125	40	0.010
3.0	4410	120	40	0.014	3570	100	35	0.014
4.0	3570	140	45	0.020	2840	115	35	0.020
5.0	3050	180	50	0.030	2410	145	40	0.030
6.0	2630	210	50	0.040	2100	170	40	0.040
8.0	2000	250	50	0.063	1580	180	40	0.057



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