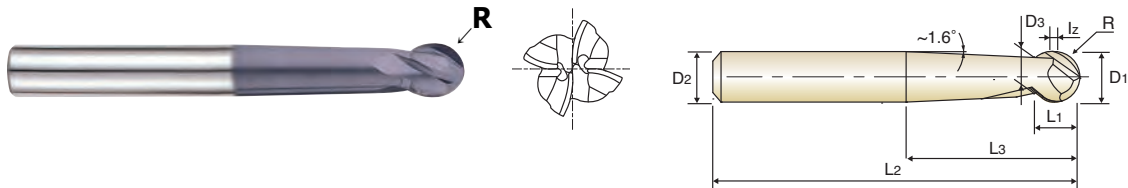




EM673 SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT

CARBIDE, 4 FLUTE LONG LENGTH BALL NOSE-MMC
VOLLHARTMETALL, 4 SCHNEIDEN LANG STIRNRADIUS-MMC

- ▶ Zaprojektowany do frezowania kłopiowego
- ▶ Praca przy zwiększonych posuwach
- ▶ Praca przy pochyleniu osi do 15°
- ▶ Łatwy do ostrzenia
- ▶ Tolerancja promienia naroża ±0.01mm



MG HM 4 30° R ±0.01 PLAIN P.898

● **4 FLUTE LONG LENGTH- ECONOMIC VERSION**
● **4 SCHNEIDEN LANG-KOSTENGÜNSTIG**

Unit : mm

EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter	lz
PLAIN	R (±0.01)	D1	D2	L1	L3	L2	D3	
EM673050	R2.5	5.0	6	6	43	80	4.1	2
EM673060	R3.0	6.0	6	7	30	100	4.7	2
EM673080	R4.0	8.0	8	9	36	100	6.5	3
EM673100	R5.0	10.0	10	11	43	100	8.2	3
EM673120	R6.0	12.0	12	13	52	100	9.8	3
EM673160	R8.0	16.0	16	15	61	150	13.4	3

※ ECONOMIC TYPE HAS MORE ADVANTAGE IN RESHARPENING THAN SPHERE TYPE.

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									
○	◎	◎	◎	○	○			○						

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

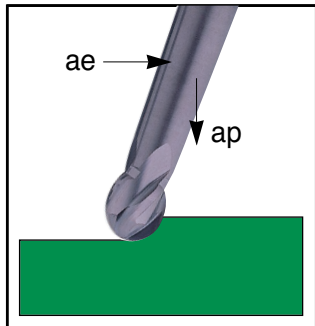
MILLING CUTTERS

TECHNICAL DATA

**YG X-POWER
END MILLS**

**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 4 FLUTE BALL NOSE MMC
VOLLHARTMETALL, 4 SCHNEIDEN STIRNRADIUS MMC**



▶ $ae = 0.05 \times D$
▶ $ap = 0.02 \times D$

EM673, EM864 SERIES

■ NORMAL SPEED

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
HARDNESS	~ HRc30				HRc30 ~ HRc40				HRc45 ~ HRc65			
STRENGTH	~ 1000N/mm ²				1000 ~ 1250N/mm ²				1500N/mm ² ~			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
R2.5 × 5.0	21000	4000	330	0.048	20000	4000	315	0.050	7000	1400	110	0.050
R3.0 × 6.0	17000	4000	320	0.059	16000	3500	300	0.055	6000	1300	115	0.054
R4.0 × 8.0	13000	3500	325	0.067	12000	3000	300	0.063	4500	1100	115	0.061
R5.0 × 10.0	10500	3000	330	0.071	10000	2500	315	0.063	3500	1000	110	0.071
R6.0 × 12.0	9000	2800	340	0.078	8000	2500	300	0.078	3000	950	115	0.079
R8.0 × 16.0	6000	2800	300	0.117	5500	2200	275	0.100	2000	800	100	0.100

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

■ HIGH SPEED

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
HARDNESS	~ HRc30				HRc30 ~ HRc40				HRc45 ~ HRc65			
STRENGTH	~ 1000N/mm ²				1000 ~ 1250N/mm ²				1500N/mm ² ~			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
R2.5 × 5.0	28000	5600	440	0.050	27000	5300	425	0.049	11000	2100	175	0.048
R3.0 × 6.0	23000	5100	435	0.055	22000	4900	415	0.056	9000	1900	170	0.053
R4.0 × 8.0	18000	4600	450	0.064	17000	4300	425	0.063	7000	1700	175	0.061
R5.0 × 10.0	14000	3900	440	0.070	13000	3700	410	0.071	5000	1400	155	0.070
R6.0 × 12.0	12000	3700	450	0.077	11000	3500	415	0.080	4500	1300	170	0.072
R8.0 × 16.0	9000	3100	450	0.086	8000	3000	400	0.094	3300	1100	165	0.083

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