# JET-POWER END MILLS

PLAIN SHANK **EH911** SERIES
FLAT SHANK **EH912** SERIES

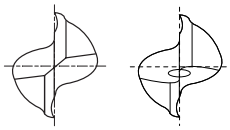
## CARBIDE, 2 FLUTE 35° HELIX SHORT LENGTH

**VOLLHARTMETALL, 2 SCHNEIDEN 35° RECHTSSPIRALE KURZ**
**Fraise carbure, 2 dents, hélice 35°, courte**
**2 TAGLIENTI, ELICA 35°, CORTA**

- Ultra micro grain carbide
- Reduces chipping of corner edges
- Suitable for low hardness materials(under HRc45), alloy steels, tool steels, carbon steels, prehardened steels, stainless steels, etc

- Ultra Feinstkorn - Vollhartmetall.
- Verstärkte Schneidkante.
- zur Bearbeitung von: Werkstoffen bis 45 HRc, rostfreien Stählen, Titan und Nickellegierungen.






CARBIDE | 2 | 35° | PLAIN | FLAT | TiAlN

p.C469

| Recommended ToolHolder | Flat Shank | Plain Shank |
|---|---|---|
| | END MILL HOLDER | POWER MILLING CHUCK |
| | - | HYDRAULIC CHUCK<br>SHRINK FIT HOLDER |
| | - | ER COLLET CHUCK |

Unit : mm

| EDP No. | | Mill Diameter | Shank Diameter | Length of Cut | Overall Length |
|---|---|---|---|---|---|
| PLAIN | FLAT | $D_1$ | $D_2$ | $L_1$ | $L_2$ |
| **EH911010** | - | **1.0** | 4 | 2.5 | 40 |
| **EH911901** | **EH912901** | **1.0** | 6 | 2.5 | 40 |
| **EH911015** | - | **1.5** | 4 | 4 | 40 |
| **EH911902** | **EH912902** | **1.5** | 6 | 4 | 40 |
| **EH911020** | - | **2.0** | 4 | 6 | 40 |
| **EH911903** | **EH912903** | **2.0** | 6 | 6 | 40 |
| **EH911025** | - | **2.5** | 4 | 8 | 40 |
| **EH911904** | **EH912904** | **2.5** | 6 | 8 | 40 |
| **EH911030** | **EH912030** | **3.0** | 6 | 8 | 45 |
| **EH911035** | **EH912035** | **3.5** | 6 | 10 | 45 |
| **EH911040** | **EH912040** | **4.0** | 6 | 11 | 45 |
| **EH911045** | **EH912045** | **4.5** | 6 | 11 | 45 |
| **EH911050** | **EH912050** | **5.0** | 6 | 13 | 50 |
| **EH911055** | **EH912055** | **5.5** | 6 | 13 | 50 |
| **EH911060** | **EH912060** | **6.0** | 6 | 13 | 50 |
| **EH911065** | **EH912065** | **6.5** | 8 | 16 | 60 |
| **EH911070** | **EH912070** | **7.0** | 8 | 16 | 60 |
| **EH911075** | **EH912075** | **7.5** | 8 | 16 | 60 |
| **EH911080** | **EH912080** | **8.0** | 8 | 19 | 60 |
| **EH911085** | **EH912085** | **8.5** | 10 | 19 | 70 |

| Mill Dia. Tolerance (mm) | Shank Dia. Tolerance |
|---|---|
| 0 ~ - 0.03 | h5 |

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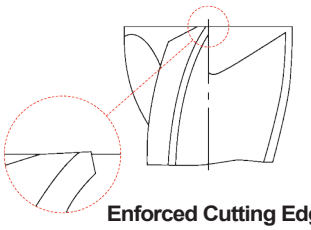

**Enforced Cutting Edge**

◎ : Excellent ○ : Good

| ISO | P | | | | | | | | | | | M | | | K | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Material Description | Non-alloy steel | | | | | Low alloy steel | | | | High alloyed steel, and tool steel | | Stainless steel | | | Grey cast iron | | Nodular cast iron | | Malleable cast iron | |
| VDI 3323 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 |
| HRc | | 13 | 25 | 28 | 32 | 10 | 29 | 32 | 38 | 15 | 35 | 15 | 23 | 10 | 10 | 26 | 3 | 25 | | 21 |
| HB | 125 | 190 | 250 | 270 | 300 | 180 | 275 | 300 | 350 | 200 | 325 | 200 | 240 | 180 | 180 | 260 | 160 | 250 | 130 | 230 |
| Recommend | ○ | ○ | ◎ | ◎ | ◎ | ○ | ◎ | ◎ | ◎ | ○ | ◎ | ○ | ○ | ◎ | | | | | | |

| ISO | N | | | | | | | | | | S | | | | | | | H | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Material Description | Aluminum-wrought alloy | | Aluminum-cast, alloyed | | | Copper and Copper Alloys (Bronze / Brass) | | | Non Metallic Materials | | Heat Resistant Super Alloys | | | | | Titanium Alloys | | Hardened steel | | Chilled Cast Iron | Hardened Cast Iron |
| VDI 3323 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 | 41 |
| HRc | | | | | | | | | | | 15 | 30 | 25 | 38 | 34 | | | 55 | 60 | 42 | 55 |
| HB | 60 | 100 | 75 | 90 | 130 | 110 | 90 | 100 | | | 200 | 280 | 250 | 350 | 320 | 400 Rm | 1050 Rm | 550 | 630 | 400 | 550 |
| Recommend | | | | | | | | | | | | | | | | ◎ | ◎ | | | ○ | |

# JET-POWER END MILLS

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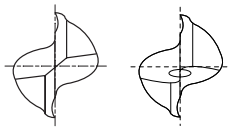


CARBIDE | 2 | 35° | PLAIN | FLAT | TiAlN

p.C469

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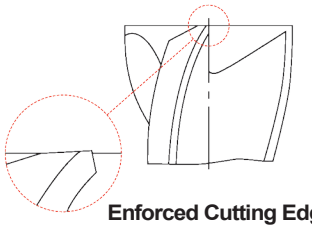
| | - | HYDRAULIC CHUCK<br>SHRINK FIT HOLDER |
| | - | ER COLLET CHUCK |

Unit : mm

| EDP No. | | Mill Diameter | Shank Diameter | Length of Cut | Overall Length |
|---|---|---|---|---|---|
| PLAIN | FLAT | $D_1$ | $D_2$ | $L_1$ | $L_2$ |
| **EH911090** | **EH912090** | **9.0** | 10 | 19 | 70 |
| **EH911095** | **EH912095** | **9.5** | 10 | 19 | 70 |
| **EH911100** | **EH912100** | **10.0** | 10 | 22 | 70 |
| **EH911110** | **EH912110** | **11.0** | 12 | 22 | 75 |
| **EH911120** | **EH912120** | **12.0** | 12 | 26 | 75 |
| **EH911140** | **EH912140** | **14.0** | 16 | 26 | 85 |
| **EH911160** | **EH912160** | **16.0** | 16 | 32 | 100 |
| **EH911180** | **EH912180** | **18.0** | 16 | 32 | 100 |
| **EH911200** | **EH912200** | **20.0** | 20 | 38 | 105 |
| **EH911220** | **EH912220** | **22.0** | 20 | 38 | 105 |
| **EH911250** | **EH912250** | **25.0** | 25 | 45 | 120 |

| Mill Dia. Tolerance (mm) | Shank Dia. Tolerance |
|---|---|
| 0 ~ - 0.03 | h5 |



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|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
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| HB | 125 | 190 | 250 | 270 | 300 | 180 | 275 | 300 | 350 | 200 | 325 | 200 | 240 | 180 | 180 | 260 | 160 | 250 | 130 | 230 |
| Recommend | ○ | ○ | ◎ | ◎ | ◎ | ○ | ◎ | ◎ | ◎ | ○ | ◎ | ○ | ○ | ◎ | | | | | | |

| ISO | N | | | | | | | | | | S | | | | | H | | | | |
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| VDI 3323 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 | 41 |
| HRc | | | | | | | | | | | 15 | 30 | 25 | 38 | 34 | | | 55 | 60 | 42 | 55 |
| HB | 60 | 100 | 75 | 90 | 130 | 110 | 90 | 100 | | | 200 | 280 | 250 | 350 | 320 | 400 Rm | 1050 Rm | 550 | 630 | 400 | 550 |
| Recommend | | | | | | | | | | | | | | | | ◎ | ◎ | | | ○ | |