JET-POWER END MILLS

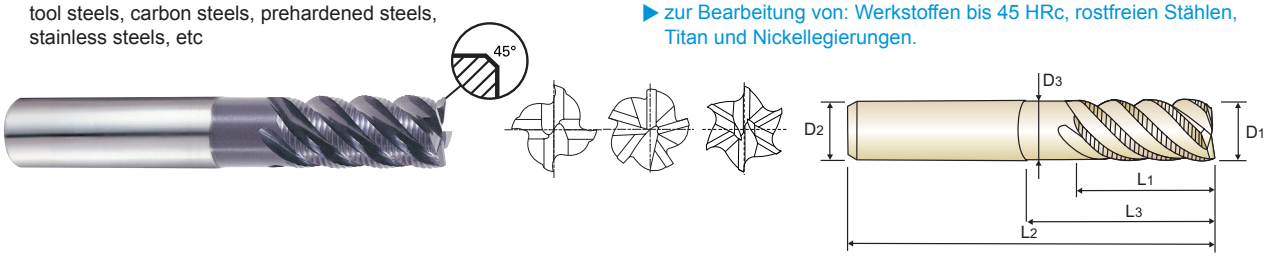
PLAIN SHANK **EH921** SERIES
FLAT SHANK **EH942** SERIES

CARBIDE, MULTI FLUTE 45° HELIX LONG REACH ROUGHING - FINE

VOLLHARTMETALL, MULTI SCHNEIDEN 45° RECHTSSPIRALE GROßE REICHWEITE SCHRUPPFRÄSER - FEIN
Fraise carbure, multi-dents ébauche longue portée, hélice 45°, pas fin
MULTITAGLIENTI, ELICA 45° SCARICATA, PER SGROSSATURA, LUNGA - Bombato fine

- Ultra micro grain carbide
- High chip removal and minimizing breakages of cutting edges.
- Suitable for low hardness materials(under HRc45), alloy steels, tool steels, carbon steels, prehardened steels, stainless steels, etc

- Ultra Feinstkorn - Vollhartmetall
- Schnelle Spanausfuhr und Minimierung von Abbrechen von Schneidkanten.
- zur Bearbeitung von: Werkstoffen bis 45 HRc, rostfreien Stählen, Titan und Nickellegierungen.



CARBIDE | HR | 4-6 | 45° | PLAIN | FLAT | C x 45° | TiAlN

p.C474~C475

Recommended ToolHolder

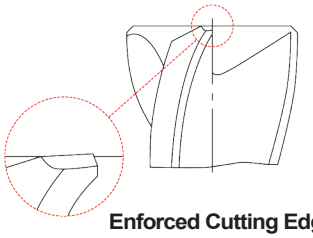
	Flat Shank	Plain Shank
◎	END MILL HOLDER	POWER MILLING CHUCK
◎	-	HYDRAULIC CHUCK SHRINK FIT HOLDER
○	-	ER COLLET CHUCK

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter	No. of Flute	Chamfer
PLAIN	FLAT	D1(h10)	D2(h5)	L1	L3	L2	D3		
EH921060	EH942060	6.0	6	16	20	57	5.5	4	0.15
EH921080	EH942080	8.0	8	16	26	63	7.5	4	0.18
EH921100	EH942100	10.0	10	22	31	72	9.5	4	0.2
EH921120	EH942120	12.0	12	26	37	83	11.5	4	0.2
EH921160	EH942160	16.0	16	32	51	100	15.5	5	0.2
EH921200	EH942200	20.0	20	38	59	110	19.2	6	0.2

Tolerances according to DIN 7160 & 7161

Tolerance range in ㎛					
Nominal-Diameter in ㎜					
	from 1 to 3	over 3 to 6	over 6 to 10	over 10 to 18	over 18 to 30
h10	0 - 40	0 - 48	0 - 58	0 - 70	0 - 84
h5	0 - 4	0 - 5	0 - 6	0 - 8	0 - 9



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											○	○	○	○	○	◎	◎			○	

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