

CARBIDE, 4 FLUTE REGULAR LENGTH

- ▶ Special flute geometry eliminates vibrations
- ▶ Designed for mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material
- ▶ Excellent work piece finishes
- ▶ Higher speeds, deeper cuts and metal removal rates



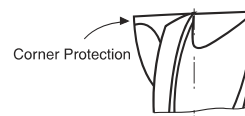
MG
4
PLAIN
FLAT
P.687

◇ Call for Availability

Unit : mm

| EDP No. | | Mill Diameter | | Shank Diameter | Length of Cut | Overall Length |
|----------|----------|---------------|-------|----------------|---------------|----------------|
| PLAIN | FLAT | Metric | Inch | | | |
| EMB14030 | - | 3.0 | .1181 | 6 | 8 | 57 |
| EMB14040 | - | 4.0 | .1575 | 6 | 11 | 57 |
| EMB14050 | - | 5.0 | .1969 | 6 | 13 | 57 |
| EMB14060 | - | 6.0 | .2362 | 6 | 13 | 57 |
| EMB14080 | - | 8.0 | .3150 | 8 | 19 | 63 |
| EMB14100 | - | 10.0 | .3937 | 10 | 22 | 72 |
| - | EMB39120 | 12.0 | .4724 | 12 | 26 | 83 |
| - | EMB39140 | 14.0 | .5512 | 14 | 26 | 83 |
| - | EMB39160 | 16.0 | .6299 | 16 | 32 | 92 |
| - | EMB39180 | 18.0 | .7087 | 18 | 32 | 92 |
| - | EMB39200 | 20.0 | .7874 | 20 | 38 | 104 |
| - | EMB39250 | 25.0 | .9800 | 25 | 38 | 104 |

| Mill Dia. Tolerance (inch) | Shank Dia. Tolerance |
|----------------------------|----------------------|
| 0~-.0012 | h6 |



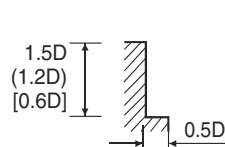
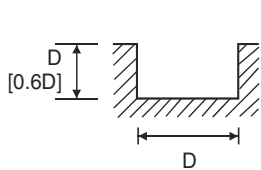
- CBN END MILL
- i-Xmill END MILL
- X5070 END MILLS
- 4G MILLS END MILLS
- X-SPEED ROUGHER END MILLS
- X-POWER END MILLS
- JET-POWER END MILLS
- V7 Mill STEEL END MILLS
- V7 Mill INOX END MILLS
- ALU-POWER END MILLS
- D-POWER END MILLS
- STANDARD CARBIDE END MILLS
- TANK-POWER END MILLS
- STANDARD COBALT & HSS END MILLS
- TECHNICAL DATA

◎ : Excellent ○ : Good

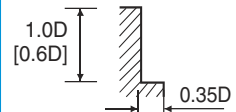
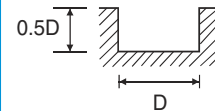
| Carbon Steels | Alloy Steels | Prehardened Steels | Hardened Steels | | High Hardened Steels | Copper | Graphite | Cast Iron | Aluminum | Stainless Steels | Titanium | Inconel |
|---------------|--------------|--------------------|-----------------|----------|----------------------|--------|----------|-----------|----------|------------------|----------|---------|
| ~HRc20 | HRc20~30 | HRc30~40 | HRc40~45 | HRc45~55 | HRc55~70 | | | | | | | |
| ◎ | ○ | ○ | | | | | | | | ◎ | ◎ | ○ |

CARBIDE, 4 FLUTE
EMC75, EMD60, EMC76, EMD61, EMB12, EMB37, EMB13, EMB38, EMB20 SERIES

| MATERIAL | ALLOY STEELS CAST IRON | | STAINLESS STEELS 300SERIES | | STAINLESS STEELS 400SERIES | | TITANIUM | | INCONEL | |
|----------|---------------------------|------|-------------------------------|------|-------------------------------|------|----------|------|---------|------|
| HARDNESS | ~HRc 20 | | | | | | | | | |
| STRENGTH | ~1000N/mm ² | | | | | | | | | |
| DIAMETER | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED | RPM | FEED |
| 1/8 | 12735 | 10.2 | 9625 | 7.3 | 13475 | 7.6 | 8320 | 7.6 | 2565 | 2.1 |
| 3/16 | 8490 | 10.9 | 6385 | 8.3 | 12000 | 8.4 | 5550 | 8.4 | 1685 | 1.8 |
| 1/4 | 6370 | 11.5 | 4810 | 9.6 | 6815 | 9.6 | 4160 | 9.6 | 1285 | 2.5 |
| 5/16 | 5100 | 13.0 | 3850 | 10.7 | 5390 | 10.7 | 3330 | 10.7 | 1025 | 2.8 |
| 3/8 | 4245 | 18.4 | 3210 | 15.4 | 4490 | 15.4 | 2770 | 15.4 | 855 | 4.1 |
| 7/16 | 4010 | 24.5 | 2750 | 20.9 | 3850 | 20.9 | 2380 | 20.7 | 735 | 5.5 |
| 1/2 | 3500 | 25.9 | 2400 | 21.0 | 3370 | 21.0 | 2080 | 21.0 | 640 | 5.6 |
| 9/16 | 3110 | 26.0 | 2140 | 21.2 | 2990 | 21.2 | 1850 | 21.2 | 570 | 5.7 |
| 5/8 | 2800 | 26.1 | 1925 | 21.2 | 2700 | 21.2 | 1660 | 21.2 | 510 | 5.6 |
| 3/4 | 2340 | 24.0 | 1600 | 19.4 | 2250 | 19.4 | 1390 | 19.4 | 425 | 5.2 |
| 1 | 1755 | 17.4 | 1200 | 14.7 | 1685 | 15.1 | 1040 | 15.1 | 315 | 4.3 |



* () : Short length Type
* [] : Stub length Type



* 1.2 x D Axial cutting depth should be applied for Short length series DIA over 5/16mm
* 0.6 x D Axial cutting depth should be applied for Stub length series.

RPM = rev./min.
FEED = inch/min.

 CBN
END MILL

 i-Xmill
END MILL

 X5070
END MILLS

 4G MILLS
END MILLS

 X-SPEED
ROUGHER
END MILLS

 X-POWER
END MILLS

 JET-POWER
END MILLS

 V7 Mill STEEL
END MILLS

**V7 Mill INOX
END MILLS**

 ALU-POWER
END MILLS

 D-POWER
END MILLS

 STANDARD
CARBIDE
END MILLS

 TANK-POWER
END MILLS

 STANDARD
COBALT
& HSS
END MILLS

 TECHNICAL
DATA