



CARBIDE

Being the best through innovation



X-POWER END MILLS

- Medium Steels to High Hardened Steels up to HRc70

CARBIDE, 6&8 FLUTE 45° HELIX LONG & EXTRA LONG LENGTH

- ▶ Designed to machine high hardened materials.
- ▶ High speed cutting and finish milling with high feed rate.
- ▶ Superior workpiece finishes.
- ▶ Superior wear resistant.
- ▶ Suitable for dry milling.
- ▶ Corner Protection against chipping.



MG 6&8 45° PLAIN P.918, 919

◆ U.S.A Stock

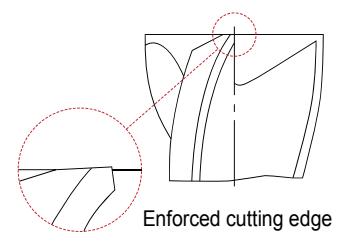
EM208 Series LONG LENGTH Unit : Inch

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
93119	1/4	1/4	1/2	2-1/4	6
93120	5/16	5/16	3/4	2-1/2	6
93121	3/8	3/8	7/8	2-7/8	6
93122	1/2	1/2	1	3-1/4	6
93123	5/8	5/8	1-1/4	3-5/8	6
93124	3/4	3/4	1-1/2	4-1/8	8
93171	1	1	1-3/4	4-1/4	8

EM218 Series EXTRALONG LENGTH Unit : Inch

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
99666	1/4	1/4	1	2-3/4	6
99667	5/16	5/16	1-1/2	3-5/8	6
99668	3/8	3/8	1-3/4	4	6
99669	1/2	1/2	2-3/16	4-3/8	6
99670	5/8	5/8	2-5/8	5-1/8	6
99588	3/4	3/4	2-1/4	5	8
99589	3/4	3/4	3-1/4	6	8
99590	3/4	3/4	4-1/8	7	8
99591	1	1	4-1/8	7	8

Mill Dia. Tolerance(inch)	Shank Dia. Tolerance
0~-0.0012	0~-0.0003



◎ : 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
~HRc20	HRc20~30	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
○	◎	◎	◎	○			○							

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR TYPE END MILLS

X5070 END MILLS

4G MILL END MILLS

X-POWER END MILLS

JET-POWER END MILLS

TitaNox -POWER END MILLS

V7 PLUS A END MILLS

V7 MILL INOX END MILLS

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

D-POWER CFRP END MILLS

ROUTERS CFRP

STANDARD CARBIDE END MILLS

ONLY ONE COATED PM60 END MILLS

SINE -POWER END MILLS

TANK-POWER END MILLS

STANDARD COBALT & HSS END MILLS

TECHNICAL DATA

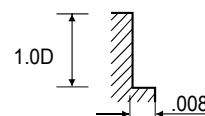
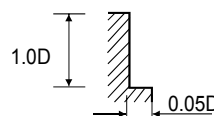
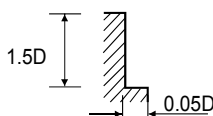
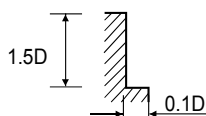


CARBIDE, 6&8 FLUTE 45° HELIX LONG LENGTH - SIDE CUTTING

EM208, EM812 SERIES

■ NORMAL SPEED

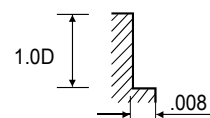
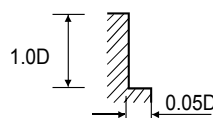
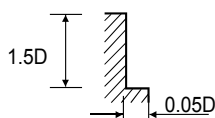
MATERIAL	P							
	CARBON STEELS ALLOY STEELS CAST IRON		ALLOY STEELS TOOL STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	~HRc30		HRc30 ~ HRc50		HRc50 ~ HRc55		HRc60 ~ HRc65	
STRENGTH	~1000N/mm ²		1000 ~ 1750N/mm ²		1750 ~ 2080N/mm ²		2080N/mm ² ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/4	5560	79.0	3880	54.0	1580	8.3	1100	5.1
5/16	4200	79.0	2940	54.0	1160	8.3	840	5.1
3/8	3360	79.0	2320	54.0	1000	8.3	680	5.1
1/2	2840	66.0	2000	46.0	840	7.1	560	4.4
5/8	2100	50.0	1480	35.0	640	5.1	420	2.8
3/4	1680	40.0	1160	27.0	500	4.4	320	2.4
1	1260	25.0	870	17.5	375	3.0	240	1.5



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

■ HIGH SPEED

MATERIAL	P					
	CARBON STEELS TOOL STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	~HRc50		HRc50 ~ HRc60		HRc60 ~	
STRENGTH	~1750N/mm ²		1750N/mm ²		1750N/mm ² ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED
1/4	16800	240.0	8400	120.0	4200	58.0
5/16	12600	240.0	6300	120.0	3160	58.0
3/8	9980	235.0	5040	120.0	2520	58.0
1/2	8400	199.0	4200	100.0	2100	50.0
5/8	6300	149.0	3160	75.0	1580	37.0
3/4	5040	120.0	2520	58.0	1260	30.0
1	3790	75.0	1890	38.0	950	19.0



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