CARBIDE

Being the best through innovation

V7 Mill INOX

V7 FRÄSER

- Stainless Steels in Heavy and Silent Cutting Materials up to HRc40.Designed as Variable Leads, YG-1's Patent.
- Für rostfreie Stähle in schwerem und ruhigem Schnittbis zu HRc40. Variable Drallsteigungen. YG-1 Patent

SELECTION GUIDE

ITEM	MODEL	DESCRIPTION	SIZE MIN	SIZE MAX	PAGE
METRIC					
EMB41 EMB42		CARBIDE, 4 FLUTE SHORT LENGTH VOLLHARTMETALL, 4 SCHNEIDEN KURZ	D3.0	D20.0	700
EMB43 EMB44		CARBIDE, 4 FLUTE SHORT LENGTH CORNER RADIUS VOLLHARTMETALL, 4 SCHNEIDEN KURZ ECKENRADIUS	D3.0	D20.0	701
EMB14 EMB39		CARBIDE, 4 FLUTE LONG LENGTH VOLLHARTMETALL, 4 SCHNEIDEN LANG	D3.0	D25.0	702
EMB15 EMB40		CARBIDE, 4 FLUTE LONG LENGTH CORNER RADIUS VOLLHARTMETALL, 4 SCHNEIDEN LANG ECKENRADIUS	D3.0	D25.0	703
EMB74 EMB75		CARBIDE, 4 FLUTE LONG LENGTH BALL NOSE VOLLHARTMETALL, 4 SCHNEIDEN LANG STIRNRADIUS	R1.5	R12.5	704
EMB72 EMB73		CARBIDE, 5 FLUTE LONG LENGTH VOLLHARTMETALL, 5 SCHNEIDEN LANG	D6.0	D25.0	705
INCH					
EMB12 EMB37		CARBIDE, 4 FLUTE REGULAR LENGTH VOLLHARTMETALL, 4 SCHNEIDEN STANDARD	D1/8″	D1″	706
EMB13 EMB38		CARBIDE, 4 FLUTE REGULAR LENGTH CORNER RADIUS VOLLHARTMETALL, 4 SCHNEIDEN STANDARD ECKENRADIUS	D1/8″	D1″	707
EMB78 EMB79		CARBIDE, 4 FLUTE REGULAR LENGTH BALL NOSE VOLLHARTMETALL, 4 SCHNEIDEN STANDARD STIRNRADIUS	R1/16″	R1/2″	708
EMB76 EMB77		CARBIDE, 5 FLUTE REGULAR LENGTH VOLLHARTMETALL, 5 SCHNEIDEN STANDARD	D1/4″	D1″	709
		RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN			710

◎ : Excellent, ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	○								◎	◎	○
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V7 Mill INOX END MILLS

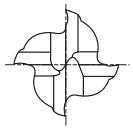
EMB41 SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT

EMB42 SERIES FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 4 FLUTE SHORT LENGTH
VOLLHARTMETALL, 4 SCHNEDEN KURZ

- ▶ Special flute geometry eliminates vibrations
- ▶ Designed to mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material under HRc 40
- ▶ Excellent work piece finishes
- ▶ Higher speeds, deeper cuts and metal removal rates

- ▶ Spezielle Schneidengeometrie verhindert Vibrationen
- ▶ Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
- ▶ Bessere Werkstückoberflächen.
- ▶ Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen



MG HM | 4 | PLAIN | FLAT

P.710

Unit : mm

EDP No. PLAIN	EDP No. FLAT	Mill Diameter	Shank Diameter h6	Length of Cut	Overall Length
EMB41030	EMB42030	3.0	6	7	54
EMB41040	EMB42040	4.0	6	8	54
EMB41050	EMB42050	5.0	6	10	54
EMB41060	EMB42060	6.0	6	10	54
EMB41080	EMB42080	8.0	8	12	58
EMB41100	EMB42100	10.0	10	14	66
EMB41120	EMB42120	12.0	12	16	73
EMB41140	EMB42140	14.0	14	18	75
EMB41160	EMB42160	16.0	16	22	82
EMB41180	EMB42180	18.0	18	24	84
EMB41200	EMB42200	20.0	20	26	92

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
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	○								◎	◎	○

V7 Mill INOX END MILLS

EMB43 SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT

EMB44 SERIES FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 4 FLUTE SHORT LENGTH CORNER RADIUS
VOLLHARTMETALL, 4 SCHNEIDEN KURZ ECKENRADIUS

- ▶ Special flute geometry eliminates vibrations
- ▶ Designed to mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material under HRc 40
- ▶ Excellent work piece finishes
- ▶ Higher speeds, deeper cuts and metal removal rates

- ▶ Spezielle Schneidengeometrie verhindert Vibrationen
- ▶ Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
- ▶ Bessere Werkstückoberflächen.
- ▶ Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen

MG HM | 4 | PLAIN | FLAT

P.710

Unit : mm

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT	R		h6		
EMB43030	EMB44030	R0.25~R0.38	3.0	6	7	54
EMB43040	EMB44040	R0.25~R0.38	4.0	6	8	54
EMB43050	EMB44050	R0.25~R0.38	5.0	6	10	54
EMB43060	EMB44060	R0.38~R0.51	6.0	6	10	54
EMB43080	EMB44080	R0.38~R0.51	8.0	8	12	58
EMB43100	EMB44100	R0.38~R0.51	10.0	10	14	66
EMB43120	EMB44120	R0.64~R0.76	12.0	12	16	73
EMB43140	EMB44140	R0.64~R0.76	14.0	14	18	75
EMB43160	EMB44160	R0.89~R1.02	16.0	16	22	82
EMB43180	EMB44180	R0.89~R1.02	18.0	18	24	84
EMB43200	EMB44200	R0.89~R1.02	20.0	20	26	92

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
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	○								◎	◎	○

V7 Mill INOX END MILLS

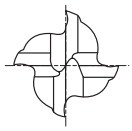
EMB14 SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT

EMB39 SERIES FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 4 FLUTE LONG LENGTH
VOLLHARTMETALL, 4 SCHNEIDEN LANG

- ▶Special flute geometry eliminates vibrations
- ▶Designed to mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material under HRc 40
- ▶Excellent work piece finishes
- ▶Higher speeds, deeper cuts and metal removal rates

- ▶Spezielle Schneidengeometrie verhindert Vibrationen
- ▶Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
- ▶Bessere Werkstückoberflächen.
- ▶Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen



MG HM | 4 | PLAIN | FLAT

P.710

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT		h6		
EMB14030	EMB39030	3.0	6	8	57
EMB14040	EMB39040	4.0	6	11	57
EMB14050	EMB39050	5.0	6	13	57
EMB14060	EMB39060	6.0	6	13	57
EMB14080	EMB39080	8.0	8	19	63
EMB14100	EMB39100	10.0	10	22	72
EMB14120	EMB39120	12.0	12	26	83
EMB14140	EMB39140	14.0	14	26	83
EMB14160	EMB39160	16.0	16	32	92
EMB14180	EMB39180	18.0	18	32	92
EMB14200	EMB39200	20.0	20	38	104
EMB14250	EMB39250	25.0	25	38	104

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
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	○								◎	◎	○

V7 Mill INOX END MILLS

EMB15 SERIES PLAIN SHANK GLATTER ZYLINDERSCHAFT

EMB40 SERIES FLAT SHANK SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 4 FLUTE LONG LENGTH CORNER RADIUS
VOLLHARTMETALL, 4 SCHNEIDEN LANG ECKENRADIUS

- ▶ Special flute geometry eliminates vibrations
- ▶ Designed to mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material under HRc 40
- ▶ Excellent work piece finishes
- ▶ Higher speeds, deeper cuts and metal removal rates

- ▶ Spezielle Schneidengeometrie verhindert Vibrationen
- ▶ Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
- ▶ Bessere Werkstückoberflächen.
- ▶ Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen

MG HM | 4 | PLAIN | FLAT P.710

Unit : mm

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT	R		h6		
EMB15030	EMB40030	R0.25~R0.38	3.0	6	8	57
EMB15040	EMB40040	R0.25~R0.38	4.0	6	11	57
EMB15050	EMB40050	R0.25~R0.38	5.0	6	13	57
EMB15060	EMB40060	R0.38~R0.51	6.0	6	13	57
EMB15080	EMB40080	R0.38~R0.51	8.0	8	19	63
EMB15100	EMB40100	R0.38~R0.51	10.0	10	22	72
EMB15120	EMB40120	R0.64~R0.76	12.0	12	26	83
EMB15140	EMB40140	R0.64~R0.76	14.0	14	26	83
EMB15160	EMB40160	R0.89~R1.02	16.0	16	32	92
EMB15180	EMB40180	R0.89~R1.02	18.0	18	32	92
EMB15200	EMB40200	R0.89~R1.02	20.0	20	38	104
EMB15250	EMB40250	R0.89~R1.02	25.0	25	38	104

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
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	○								◎	◎	○

V7 Mill INOX END MILLS

EMB74 SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT

EMB75 SERIES FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

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

- ▶Special flute geometry eliminates vibrations
- ▶Designed to mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material under HRc 40
- ▶Excellent work piece finishes
- ▶Higher speeds, deeper cuts and metal removal rates

- ▶Spezielle Schneidengeometrie verhindert Vibrationen
- ▶Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
- ▶Bessere Werkstückoberflächen.
- ▶Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen

MG HM | 4 | R ±0.01 | PLAIN | FLAT

P.711

Unit : mm

EDP No. PLAIN	EDP No. FLAT	Radius of Ball Nose R (±0.01)	Mill Diameter	Shank Diameter h6	Length of Cut	Overall Length
EMB74030	EMB75030	R1.5	3.0	6	8	57
EMB74040	EMB75040	R2.0	4.0	6	11	57
EMB74050	EMB75050	R2.5	5.0	6	13	57
EMB74060	EMB75060	R3.0	6.0	6	13	57
EMB74080	EMB75080	R4.0	8.0	8	19	63
EMB74100	EMB75100	R5.0	10.0	10	22	72
EMB74120	EMB75120	R6.0	12.0	12	26	83
EMB74160	EMB75160	R8.0	16.0	16	32	92
EMB74200	EMB75200	R10.0	20.0	20	38	104
EMB74250	EMB75250	R12.5	25.0	25	38	104

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
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	○								◎	◎	○

V7 Mill INOX END MILLS

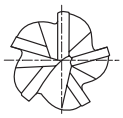
EMB72 SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT

EMB73 SERIES FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 5 FLUTE LONG LENGTH
VOLLHARTMETALL, 5 SCHNEIDEN LANG

- ▶ Special flute geometry eliminates vibrations
- ▶ Designed to mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material under HRc 40
- ▶ Excellent work piece finishes
- ▶ Higher speeds, deeper cuts and metal removal rates

- ▶ Spezielle Schneidengeometrie verhindert Vibrationen
- ▶ Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
- ▶ Bessere Werkstückoberflächen.
- ▶ Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen



MG HM | 5 | PLAIN | FLAT P.711

Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT		h6		
EMB72060	EMB73060	6.0	6	13	57
EMB72080	EMB73080	8.0	8	19	63
EMB72100	EMB73100	10.0	10	22	72
EMB72120	EMB73120	12.0	12	26	83
EMB72140	EMB73140	14.0	14	26	83
EMB72160	EMB73160	16.0	16	32	92
EMB72180	EMB73180	18.0	18	32	92
EMB72200	EMB73200	20.0	20	38	104
EMB72250	EMB73250	25.0	25	38	104

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
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	○								◎	◎	○

V7 Mill INOX END MILLS

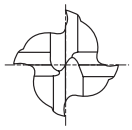
EMB12 SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT

EMB37 SERIES FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 4 FLUTE REGULAR LENGTH
VOLLHARTMETALL, 4 SCHNEIDEN STANDARD

- ▶Special flute geometry eliminates vibrations
- ▶Designed to mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material under HRc 40
- ▶Excellent work piece finishes
- ▶Higher speeds, deeper cuts and metal removal rates

- ▶Spezielle Schneidengeometrie verhindert Vibrationen
- ▶Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
- ▶Bessere Werkstückoberflächen.
- ▶Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen



MG HM | 4 | PLAIN | FLAT P.710

Unit : inch

EDP No. PLAIN	EDP No. FLAT	Mill Diameter	Shank Diameter h6	Length of Cut	Overall Length
EMB12008	-	1/8	1/8	3/8	1-1/2
EMB12010	-	5/32	3/16	7/16	2
EMB12012	-	3/16	3/16	7/16	2
EMB12014	-	7/32	1/4	7/16	2-1/2
EMB12016	-	1/4	1/4	1/2	2-1/2
EMB12018	-	9/32	5/16	5/8	2-1/2
EMB12020	-	5/16	5/16	13/16	2-1/2
EMB12022	EMB37022	11/32	3/8	13/16	2-1/2
EMB12024	EMB37024	3/8	3/8	7/8	2-1/2
EMB12026	EMB37026	13/32	7/16	15/16	2-3/4
EMB12028	EMB37028	7/16	7/16	1	2-3/4
EMB12030	EMB37030	15/32	1/2	1	3
EMB12032	EMB37032	1/2	1/2	1	3
EMB12036	EMB37036	9/16	9/16	1-1/8	3-1/2
EMB12040	EMB37040	5/8	5/8	1-1/4	3-1/2
EMB12048	EMB37048	3/4	3/4	1-1/2	4
EMB12064	EMB37064	1	1	1-1/2	4

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

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	○								◎	◎	○

V7 Mill INOX END MILLS

EMB13 SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT

EMB38 SERIES FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 4 FLUTE REGULAR LENGTH CORNER RADIUS
VOLLHARTMETALL, 4 SCHNEIDEN STANDARD ECKENRADIUS

- ▶Special flute geometry eliminates vibrations
- ▶Designed to mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material under HRc 40
- ▶Excellent work piece finishes
- ▶Higher speeds, deeper cuts and metal removal rates

- ▶Spezielle Schneidengeometrie verhindert Vibrationen
- ▶Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
- ▶Bessere Werkstückoberflächen.
- ▶Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen

MG HM | 4 | PLAIN | FLAT P.710

Unit : inch

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT	R		h6		
EMB13008	-	R.010~R.015	**1/8**	1/8	3/8	1-1/2
EMB13012	-	R.010~R.015	**3/16**	3/16	7/16	2
EMB13016	-	R.015~R.020	**1/4**	1/4	1/2	2-1/2
EMB13020	-	R.015~R.020	**5/16**	5/16	13/16	2-1/2
EMB13024	**EMB38024**	R.015~R.020	**3/8**	3/8	7/8	2-1/2
EMB13028	**EMB38028**	R.015~R.020	**7/16**	7/16	1	2-3/4
EMB13032	**EMB38032**	R.025~R.030	**1/2**	1/2	1	3
EMB13036	**EMB38036**	R.025~R.030	**9/16**	9/16	1-1/8	3-1/2
EMB13040	**EMB38040**	R.035~R.040	**5/8**	5/8	1-1/4	3-1/2
EMB13048	**EMB38048**	R.035~R.040	**3/4**	3/4	1-1/2	4
EMB13064	**EMB38064**	R.035~R.040	**1**	1	1-1/2	4

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

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	○								◎	◎	○

V7 Mill INOX END MILLS

EMB78 SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT

EMB79 SERIES FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 4 FLUTE REGULAR LENGTH BALL NOSE
VOLLHARTMETALL, 4 SCHNEIDEN STANDARD STIRNRADIUS

- ▶Special flute geometry eliminates vibrations
- ▶Designed to mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material under HRc 40
- ▶Excellent work piece finishes
- ▶Higher speeds, deeper cuts and metal removal rates

- ▶ Spezielle Schneidengeometrie verhindert Vibrationen
- ▶ Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
- ▶Bessere Werkstückoberflächen.
- ▶ Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen

MG HM | 4 | R ±0.0004" | PLAIN | FLAT

P.711

Unit : inch

EDP No. PLAIN	EDP No. FLAT	Radius of Ball Nose R (±0.0004")	Mill Diameter	Shank Diameter h6	Length of Cut	Overall Length
EMB78008	-	R1/16	1/8	1/8	3/8	1-1/2
EMB78010	-	R5/64	5/32	3/16	7/16	2
EMB78012	-	R3/32	3/16	3/16	7/16	2
EMB78016	-	R1/8	1/4	1/4	1/2	2-1/2
EMB78020	-	R5/32	5/16	5/16	13/16	2-1/2
EMB78024	EMB79024	R3/16	3/8	3/8	7/8	2-1/2
EMB78032	EMB79032	R1/4	1/2	1/2	1	3
EMB78040	EMB79040	R5/16	5/8	5/8	1-1/4	3-1/2
EMB78048	EMB79048	R3/8	3/4	3/4	1-1/2	4
EMB78064	EMB79064	R1/2	1	1	1-1/2	4

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

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	○								◎	◎	○

V7 Mill INOX END MILLS

EMB76 SERIES PLAIN SHANK
GLATTER ZYLINDERSCHAFT

EMB77 SERIES FLAT SHANK
SEITLICHE MITNAHMEFLÄCHEN

CARBIDE, 5 FLUTE REGULAR LENGTH
VOLLHARTMETALL, 5 SCHNEIDEN LANG

- ▶Special flute geometry eliminates vibrations
- ▶Designed to mild steels, stainless steel, cast iron, tool steels, titanium alloys, prehardened steels and low hardness material under HRc 40
- ▶Excellent work piece finishes
- ▶Higher speeds, deeper cuts and metal removal rates

- ▶Spezielle Schneidengeometrie verhindert Vibrationen
- ▶Geeignet für Baustähle, Rostfreie Stähle, Grauguss, Werkzeugstähle, Titanlegierungen, hochfeste Stähle und Werkstoffe unter 40 HRc
- ▶Bessere Werkstückoberflächen.
- ▶Höhere Schnittgeschwindigkeiten, größere Profiltiefe und größeres Zerspanungsvolumen

MG HM | 5 | PLAIN | FLAT | P.711

Unit : inch

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length
PLAIN	FLAT		h6		
EMB76016	-	1/4	1/4	1/2	2-1/2
EMB76020	-	5/16	5/16	13/16	2-1/2
EMB76024	EMB77024	3/8	3/8	7/8	2-1/2
EMB76032	EMB77032	1/2	1/2	1	3
EMB76036	EMB77036	9/16	9/16	1-1/8	3-1/2
EMB76040	EMB77040	5/8	5/8	1-1/4	3-1/2
EMB76048	EMB77048	3/4	3/4	1-1/2	4
EMB76064	EMB77064	1	1	1-1/2	4

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

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	○								◎	◎	○

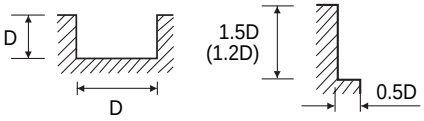
V7 Mill INOX END MILLS

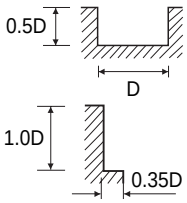
RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 4 FLUTE
VOLLHARTMETALL, 4 SCHNEIDEN

EMB41, EMB42, EMB43, EMB44, EMB14, EMB39, EMB15, EMB40, EMB12, EMB37, EMB13, EMB38 SERIES

MATERIAL	ALLOY STEELS CAST IRON		ALLOY STEELS CAST IRON		STAINLESS STEELS 300SERIES		STAINLESS STEELS 400SERIES		TITANIUM		INCONEL	
HARDNESS	~HB 300		HB 300~HB 380									
STRENGTH	~1000N/mm²		1000~1300N/mm²									
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3.0	13475	275	9430	190	10185	195	14260	205	10185	205	2715	55
4.0	10105	330	7070	230	7600	250	14260	255	7600	255	2005	55
5.0	8085	370	5660	260	6110	310	8655	310	6110	310	1630	80
6.0	6735	435	4715	385	5095	360	7130	360	5095	360	1355	95
8.0	5050	555	3535	385	3820	435	5345	465	3280	465	1015	125
10.0	4455	690	3115	480	3055	590	4275	585	3055	585	815	155
12.0	3710	695	2600	485	2545	565	3565	565	2545	565	675	150
14.0	3180	620	2225	435	2180	520	3055	520	2180	520	580	140
16.0	2785	590	1950	410	1910	480	2670	480	1910	480	505	130
18.0	2475	585	1730	410	1695	475	2375	475	1695	475	450	125
20.0	2225	580	1560	405	1525	470	2140	470	1525	470	405	125
25.0	1780	450	1245	315	1215	380	1710	380	1215	380	320	110





1.2 x D Axial cutting depth should be applied for Short length series DIA over 8mm

RPM = rev./min.
FEED = mm/min.

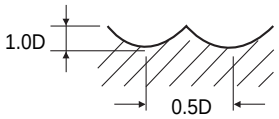
V7 Mill INOX END MILLS

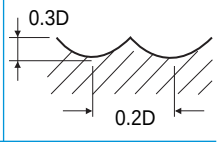
RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 4 FLUTE BALL NOSE
VOLLHARTMETALL, 4 SCHNEIDEN STIRNRADIUS

EMB74, EMB75, EMB78, EMB79 SERIES

MATERIAL	ALLOY STEELS CAST IRON		STAINLESS STEELS 300SERIES		STAINLESS STEELS 400SERIES		TITANIUM		INCONEL	
HARDNESS	~HB 230									
STRENGTH	~1000N/mm²									
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
R1.5 × 3.0	14324	1430	8220	650	7420	440	5830	280	3180	140
R2.0 × 4.0	10740	1070	6160	490	5570	330	4370	210	2380	100
R2.5 × 5.0	8590	1030	4930	490	4450	440	3500	210	1910	80
R3.0 × 6.0	7460	1140	4110	670	3710	440	2910	230	1590	100
R4.0 × 8.0	5370	1280	3080	550	2780	440	2180	260	1190	120
R5.0 × 10.0	4290	1030	2460	490	2220	400	1750	210	950	100
R6.0 × 12.0	3580	1000	2050	450	1850	370	1450	230	790	120
R8.0 × 16.0	2680	800	1540	370	1390	300	1090	190	590	110
R9.0 × 18.0	2380	760	1370	350	1230	290	970	190	530	110
R10.0 × 20.0	2140	770	1230	320	1110	260	870	210	470	100
R12.5 × 25.0	1710	680	980	270	890	210	700	190	380	80



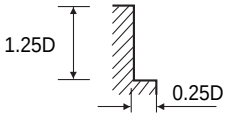


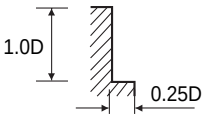
RPM = rev./min.
FEED = mm/min.

CARBIDE, 5 FLUTE
VOLLHARTMETALL, 5 SCHNEIDEN

EMB72, EMB73, EMB76, EMB77 SERIES

MATERIAL	ALLOY STEELS CAST IRON		STAINLESS STEELS 300SERIES		STAINLESS STEELS 400SERIES		TITANIUM		INCONEL	
HARDNESS	~HB 230									
STRENGTH	~1000N/mm²									
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	7270	1240	6060	920	5660	860	4440	670	1450	120
8.0	5450	1040	4540	720	4240	670	3330	520	1090	110
10.0	4360	1100	3630	690	3390	640	2660	500	870	110
12.0	3630	1150	3030	960	3830	820	2220	560	720	130
14.0	3110	1080	2600	850	2420	770	1900	540	620	140
16.0	2720	1040	2270	780	2120	720	1660	520	540	130
18.0	2420	1000	2020	710	1880	670	1480	510	480	130
20.0	2180	970	1810	690	1690	640	1330	500	430	130
25.0	1740	880	1450	640	1350	600	1060	470	340	130





RPM = rev./min.
FEED = mm/min.