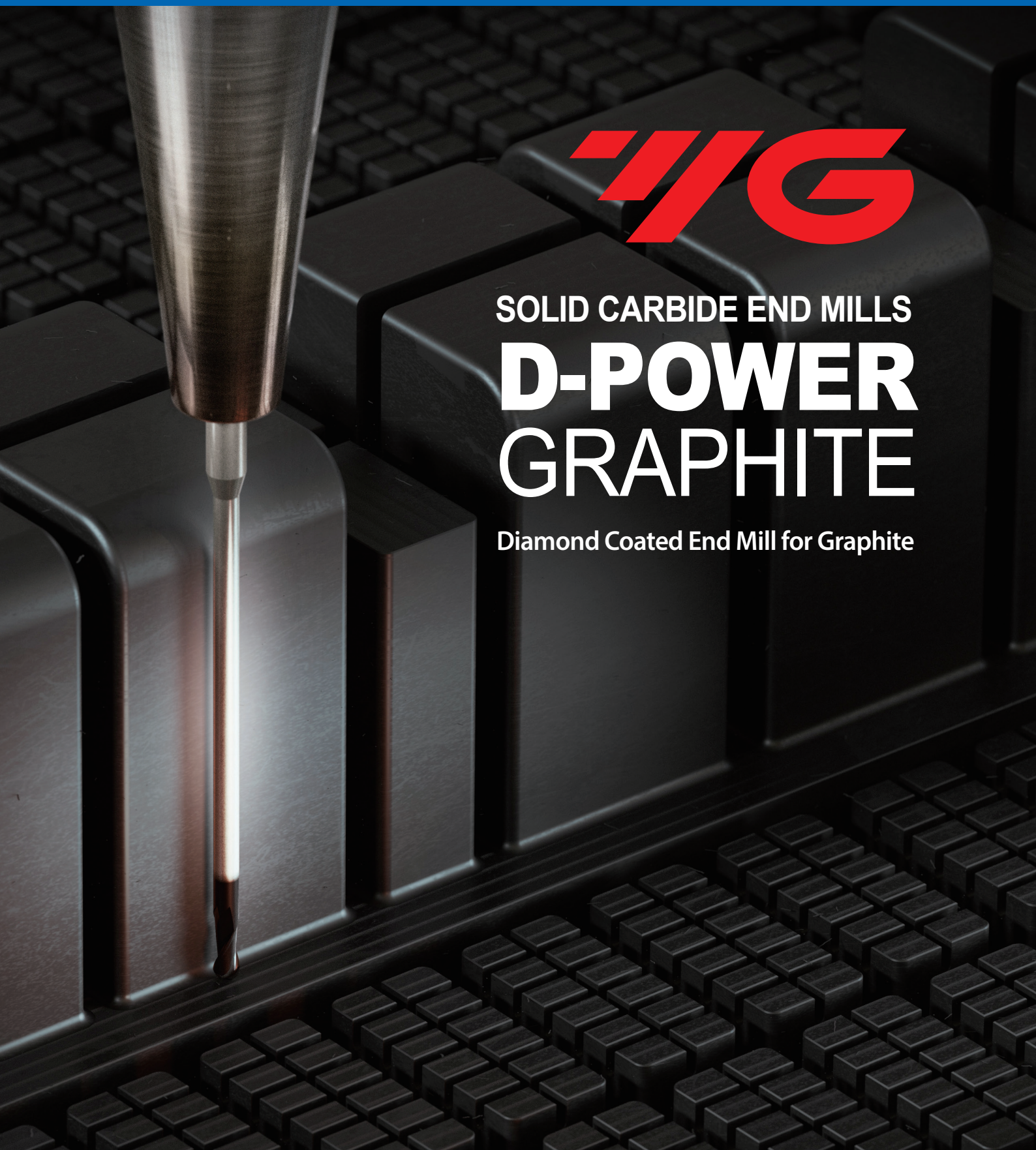
YE-DP26 EUROPE



SOLID CARBIDE END MILLS

D-POWER GRAPHITE

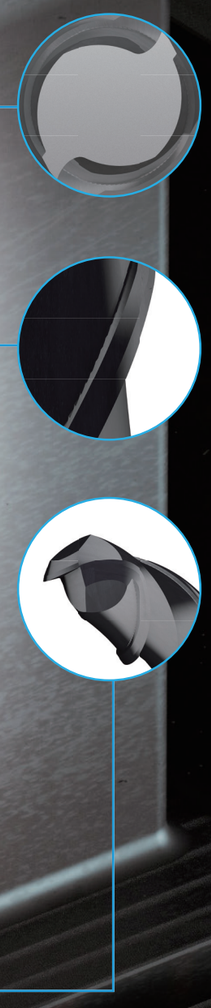
Diamond Coated End Mill for Graphite

D-POWER *for* GRAPHITE

Diamond Coated End Mill for Graphite

Complete Product Range for Every Graphite Machining Application

From micro tools for fine details to solutions for deep cavity machining, D-POWER offers a comprehensive lineup with a wide range of diameters, neck lengths, and geometries, enabling efficient machining from roughing to finishing of graphite electrodes for die and mold applications.



Core Design for Stability and Accuracy

- Optimized core design provides outstanding rigidity, stability, and machining accuracy.

Cutting Edge for Performance and Efficiency

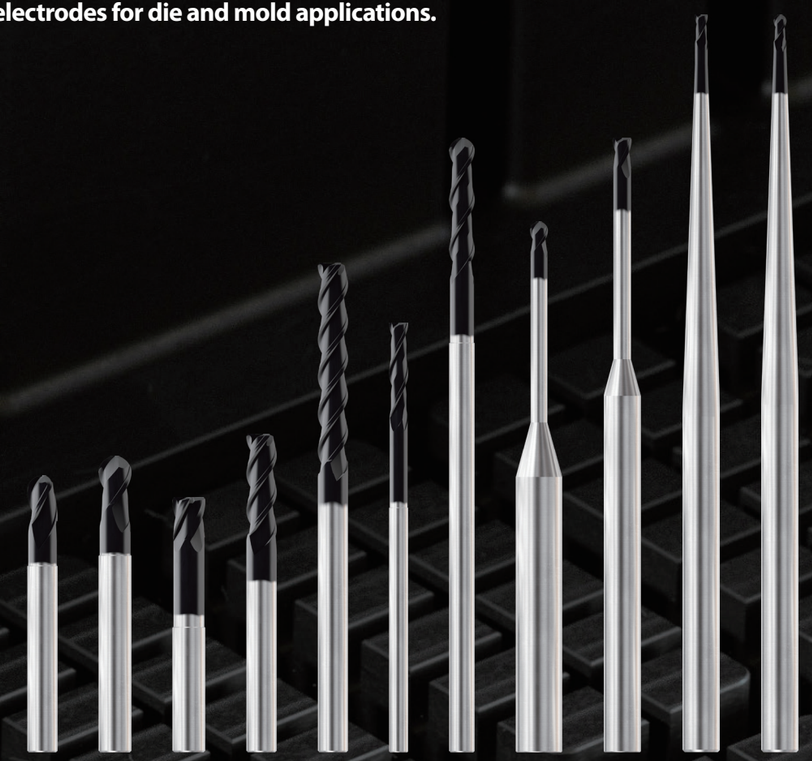
- Advanced cutting edge geometry maximizes cutting performance and machining efficiency.

Ball Nose for Precision

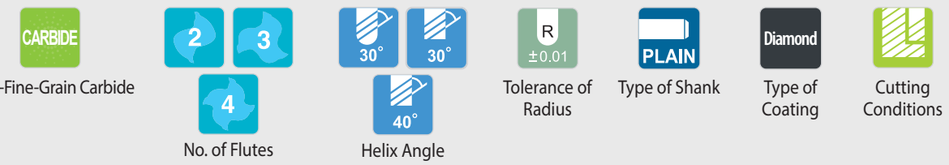
- Precision ball nose geometry delivers superior surface quality and dimensional accuracy.

Coating

- Diamond Coating provides exceptional wear resistance and extended tool life.



GUIDE TO ICONS



SELECTION GUIDE

SOLID CARBIDE END MILLS
D-POWER GRAPHITE

Diamond Coated End Mill for Graphite

Please visit globalyg1.com/mat for material search

Recommended cutting conditions : p.21-22

◎ : Excellent ○ : Good

SERIES	EI997	EIB93	EI880
FLUTE	2	2	2
HELIX ANGLE	30°	30°	30°
CUTTING EDGE SHAPE	BALL NOSE	BALL NOSE	BALL NOSE
SIZE MIN	R0.1	R0.2	R1.0
SIZE MAX	R3.0	R2.0	R6.0
PAGE	6	8	9
	MINIATURE NECK	MINIATURE NECK	SHORT LENGTH NECK
	Diamond		

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	EI997	EIB93	EI880
P	1	Non-alloy steel	About 0.15% C	Annealed	125				
	2		About 0.45% C	Annealed	190	13			
	3		About 0.45% C	Quenched & Tempered	250	25			
	4		About 0.75% C	Annealed	270	28			
	5		About 0.75% C	Quenched & Tempered	300	32			
	6	Low alloy steel		Annealed	180	10			
	7			Quenched & Tempered	275	29			
	8			Quenched & Tempered	300	32			
	9			Quenched & Tempered	350	38			
	10	High alloyed steel, and tool steel		Annealed	200	15			
	11			Quenched & Tempered	325	35			
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15			
	13		Martensitic	Quenched & Tempered	240	23			
	14			Austenitic	180	10			
K	15	Grey cast iron	Pearlitic / Ferritic		180	10			
	16		Pearlitic (Martensitic)		260	26			
	17	Nodular cast iron	Ferritic		160	3			
	18		Pearlitic		250	25			
	19	Malleable cast iron	Ferritic		130				
	20		Pearlitic		230	21			
N	21	Aluminum-wrought alloy	Not Curable		60				
	22		Curable	Hardened	100				
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75				
	24		≤ 12% Si, Curable	Hardened	90				
	25		> 12% Si, Not Curable		130		○	○	○
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110				
	27		CuZn, CuSnZn (Brass)		90				
	28		CuSn, lead-free copper and electrolytic copper		100				
	29.1	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic						
	29.2		GRAPHITE				◎	◎	◎
	29.3		CFRP, GFRP						
	30		Rubber, Wood, etc.						
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15			
	32			Cured	280	30			
	33		Ni or Co Based	Annealed	250	25			
	34			Cured	350	38			
	35			Cast	320	34			
	36	Titanium Alloys	Pure Titanium		400 Rm				
	37		Alpha + Beta Alloys	Hardened	1050 Rm				
H	38	Hardened steel		Hardened	550	55			
	39			Hardened	630	60			
	40	Chilled Cast Iron		Cast	400	42			
	41	Hardened Cast Iron		Hardened	550	55			

EI451	EI450	EIB87	EI881	EI996	EIB86	EIA13	EIA14	EIB88	EIB04
2	2	2	3	2	2	3	3	4	2
30°	30°	30°	30°	30°	30°	40°	40°	30°	30°
BALL NOSE	BALL NOSE	BALL NOSE	BALL NOSE	CORNER RADIUS	CORNER RADIUS	CORNER RADIUS	CORNER RADIUS	CORNER RADIUS	SQUARE
R1.0	R1.0	R0.5	R1.0	D0.2	D1.0	D2.0	D2.0	D6.0	D0.5
R6.0	R6.0	R1.0	R6.0	D6.0	D2.0	D12.0	D12.0	D12.0	D12.0
10	11	12	13	14	16	17	18	19	20
LONG LENGTH NECK	LONG REACH NECK	TAPER NECK	SHORT LENGTH NECK	MINIATURE NECK	TAPER NECK	SHORT LENGTH	LONG LENGTH	NECK	LONG LENGTH NECK
Diamond									

EI451	EI450	EIB87	EI881	EI996	EIB86	EIA13	EIA14	EIB88	EIB04	ISO
										1 P
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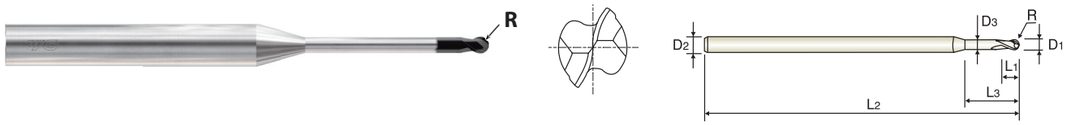
SOLID CARBIDE END MILLS

2 FLUTE MINIATURE BALL NOSE with NECK

SERIES

PLAIN SHANK **EI997**

- ▶ Perfectly suited for micro machining applications
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)



CARBIDE | 2 | 30° | R ±0.01 | PLAIN | Diamond p.21

Unit : mm

EDP No.	Radius of Ball Nose R (±0.01)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
EI997002000040	R0.1	**0.2**	3	0.2	-	40	-
EI997003000040	R0.15	**0.3**	3	0.3	-	40	-
EI997004000040	R0.2	**0.4**	3	0.4	-	40	-
EI997005025040	R0.25	**0.5**	3	0.5	2.5	40	0.45
EI997006	R0.3	**0.6**	3	0.6	3	40	0.55
EI997006050040	R0.3	**0.6**	3	0.6	5	40	0.55
EI997008	R0.4	**0.8**	3	0.8	4	40	0.75
EI997008070040	R0.4	**0.8**	3	0.8	7	40	0.75
EI997010	R0.5	**1.0**	3	1	5	40	0.95
EI997903	R0.5	**1.0**	3	1	8.5	40	0.95
EI997010120040	R0.5	**1.0**	3	1	12	40	0.95
EI997012	R0.6	**1.2**	3	1.2	6	50	1.15
EI997012100050	R0.6	**1.2**	3	1.2	10	50	1.15
EI997015	R0.75	**1.5**	3	1.5	7.5	50	1.4
EI997906	R0.75	**1.5**	3	1.5	12	50	1.4
EI997015180050	R0.75	**1.5**	3	1.5	18	50	1.4
EI997020	R1.0	**2.0**	3	2.2	10	60	1.9
EI997908	R1.0	**2.0**	3	2.2	16	60	1.9
EI997020250060	R1.0	**2.0**	3	2.2	25	60	1.9
EI997030100065	R1.5	**3.0**	4	3	10	65	2.9
EI997030150065	R1.5	**3.0**	4	3	15	65	2.9
EI997030200065	R1.5	**3.0**	4	3	20	65	2.9

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.02	h5

◎ : 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
Recommended																				

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
Recommended					○				◎												

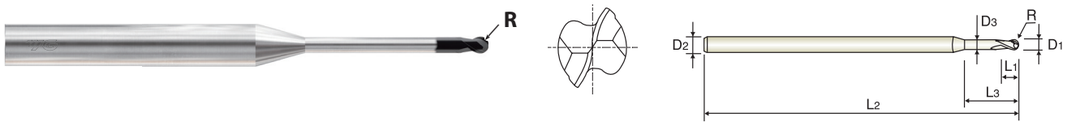
SOLID CARBIDE END MILLS

2 FLUTE MINIATURE BALL NOSE with NECK

SERIES

PLAIN SHANK **EI997**

- ▶ Perfectly suited for micro machining applications
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)



CARBIDE | 2 | 30° | R ±0.01 | PLAIN | Diamond p.21

Unit : mm

EDP No.	Radius of Ball Nose R (±0.01)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
EI997030250075	R1.5	**3.0**	4	3	25	75	2.9
EI997030300075	R1.5	**3.0**	4	3	30	75	2.9
EI997040200065	R2.0	**4.0**	6	4	20	65	3.9
EI997040300075	R2.0	**4.0**	6	4	30	75	3.9
EI997040400090	R2.0	**4.0**	6	4	40	90	3.9
EI997050200065	R2.5	**5.0**	6	5	20	65	4.9
EI997050300075	R2.5	**5.0**	6	5	30	75	4.9
EI997050400090	R2.5	**5.0**	6	5	40	90	4.9
EI997050500090	R2.5	**5.0**	6	5	50	90	4.9
EI997060300075	R3.0	**6.0**	6	6	30	75	5.9
EI997060400090	R3.0	**6.0**	6	6	40	90	5.9
EI997060500090	R3.0	**6.0**	6	6	50	90	5.9
EI997060600100	R3.0	**6.0**	6	6	60	100	5.9

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.02	h5

◎ : 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
Recommended																				

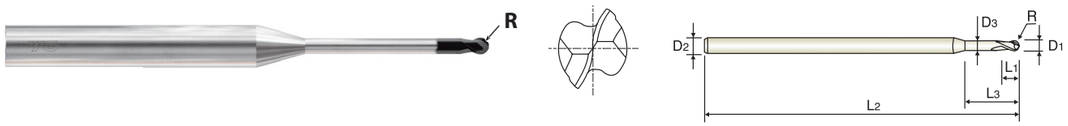
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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
Recommended					○				◎												

SOLID CARBIDE END MILLS

2 FLUTE MINIATURE BALL NOSE with NECK

SERIES
PLAIN SHANK **EIB93**

- ▶ Perfectly suited for micro machining applications
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)



CARBIDE 2 30° R ±0.01 PLAIN Diamond p.21

Unit : mm

EDP No.	Radius of Ball Nose R (±0.01)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
EIB93004040	R0.2	**0.4**	4	0.6	4	45	0.36
EIB93004060	R0.2	**0.4**	4	0.6	6	45	0.36
EIB93006040	R0.3	**0.6**	4	1	4	45	0.56
EIB93006060	R0.3	**0.6**	4	1	6	45	0.56
EIB93006080	R0.3	**0.6**	4	1	8	45	0.56
EIB93010060	R0.5	**1.0**	4	1.5	6	45	0.95
EIB93010080	R0.5	**1.0**	4	1.5	8	45	0.95
EIB93010120	R0.5	**1.0**	4	1.5	12	45	0.95
EIB93015120	R0.75	**1.5**	4	1.75	12	45	1.45
EIB93020080	R1.0	**2.0**	4	3	8	60	1.95
EIB93020120	R1.0	**2.0**	4	3	12	60	1.95
EIB93020160	R1.0	**2.0**	4	3	16	60	1.95
EIB93040160	R2.0	**4.0**	4	6	16	60	3.9

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.02	h5

◎ : 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
Recommended																				

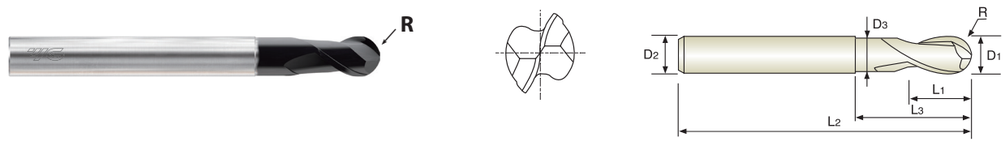
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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
Recommended					○				◎												

SOLID CARBIDE END MILLS

2 FLUTE BALL NOSE SHORT LENGTH with NECK

SERIES
PLAIN SHANK **EI880**

- ▶ Short reach length for perfectly stable roughing applications
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)



CARBIDE 2 30° R ±0.01 PLAIN Diamond p.21

Unit : mm

EDP No.	Radius of Ball Nose R (±0.01)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
EI880020	R1.0	**2.0**	6	3	5	60	1.9
EI880025	R1.25	**2.5**	6	4	6	60	2.4
EI880030	R1.5	**3.0**	6	4.5	6.5	60	2.8
EI880035	R1.75	**3.5**	6	5	7	65	3.2
EI880040	R2.0	**4.0**	6	6	8	65	3.7
EI880050	R2.5	**5.0**	6	7.5	10	65	4.6
EI880060	R3.0	**6.0**	6	9	12	75	5.6
EI880080	R4.0	**8.0**	8	12	25	75	7.4
EI880100	R5.0	**10.0**	10	15	30	80	9.4
EI880120	R6.0	**12.0**	12	18	36	90	11.4

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

◎ : 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
Recommended																				

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
Recommended					○				◎												

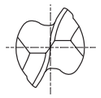
SOLID CARBIDE END MILLS

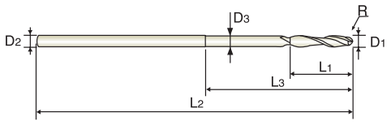
2 FLUTE BALL NOSE LONG LENGTH with NECK

SERIES

PLAIN SHANK **EI451**

- ▶ Highest stick-out length for difficult-to-reach applications with up to 10xD neck length
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)





CARBIDE | 2 | 30° | R ±0.01 | PLAIN | Diamond

p.21

Unit : mm

EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R (±0.01)	D_1	D_2	L_1	L_3	L_2	D_3
EI451020	R1.0	**2.0**	4	10	20	80	1.95
EI451030	R1.5	**3.0**	4	15	25	80	2.9
EI451040	R2.0	**4.0**	4	20	30	80	3.9
EI451050	R2.5	**5.0**	6	30	50	100	4.9
EI451060	R3.0	**6.0**	6	30	50	100	5.5
EI451070	R3.5	**7.0**	6	30	-	100	-
EI451080	R4.0	**8.0**	8	40	60	110	7.5
EI451090	R4.5	**9.0**	8	40	-	110	-
EI451100	R5.0	**10.0**	10	50	70	120	9.5
EI451120	R6.0	**12.0**	12	55	75	130	11.5

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

◎ : 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
Recommended																				

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
Recommended					○				◎												

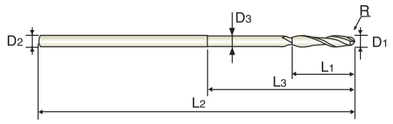
SOLID CARBIDE END MILLS

2 FLUTE BALL NOSE LONG REACH with NECK

SERIES

PLAIN SHANK **EI450**

- ▶ Highest stick-out length for difficult-to-reach applications with up to 10xD neck length
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)



CARBIDE | 2 | 30° | R ±0.01 | PLAIN | Diamond

p.21

Unit : mm

EDP No.	Radius of Ball Nose	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R (±0.01)	D_1	D_2	L_1	L_3	L_2	D_3
EI450020	R1.0	**2.0**	4	10	20	100	1.95
EI450030	R1.5	**3.0**	4	15	25	100	2.9
EI450040	R2.0	**4.0**	4	20	30	100	3.9
EI450050	R2.5	**5.0**	6	30	50	120	4.9
EI450060	R3.0	**6.0**	6	30	50	150	5.5
EI450070	R3.5	**7.0**	6	30	-	150	-
EI450080	R4.0	**8.0**	8	40	60	150	7.5
EI450090	R4.5	**9.0**	8	40	-	150	-
EI450100	R5.0	**10.0**	10	50	70	180	9.5
EI450120	R6.0	**12.0**	12	55	75	200	11.5

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

◎ : 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
Recommended																				

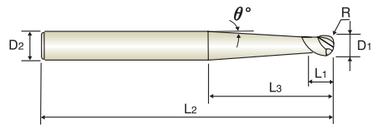
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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
Recommended					○				◎												

SOLID CARBIDE END MILLS

2 FLUTE BALL NOSE with TAPER NECK

SERIES
PLAIN SHANK **EIB87**

- ▶ Tapered and high stick-out length for difficult-to-reach micro machining applications
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)



CARBIDE | 2 | 30° | R ±0.01 | PLAIN | Diamond | p.21

Unit : mm

EDP No.	Radius of Ball Nose R (±0.01)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Taper Angle(°) θ°
EIB87010	R0.5	**1.0**	3	2	-	40	**8° 30´**
EIB87901	R0.5	**1.0**	3	2	30	60	**2°**
EIB87902	R0.5	**1.0**	3	2	70	100	**1°**
EIB87015	R0.75	**1.5**	3	3	-	40	**6° 15´**
EIB87903	R0.75	**1.5**	3	3	30	60	**1° 30´**
EIB87904	R0.75	**1.5**	3	3	58	100	**45´**
EIB87020	R1.0	**2.0**	3	4	-	40	**4° 15´**
EIB87905	R1.0	**2.0**	3	4	30	60	**1°**
EIB87906	R1.0	**2.0**	4	4	70	100	**1°**

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.02	h5

◎ : 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
Recommended																				

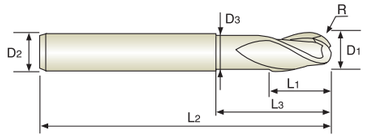
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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
Recommended					○				◎												

SOLID CARBIDE END MILLS

3 FLUTE BALL NOSE SHORT LENGTH with NECK

SERIES
PLAIN SHANK **EI881**

- ▶ Short reach length for perfectly stable roughing applications
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)



CARBIDE | 3 | 30° | R ±0.01 | PLAIN | Diamond | p.21

Unit : mm

EDP No.	Radius of Ball Nose R (±0.01)	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
EI881020	R1.0	**2.0**	6	3	5	60	1.9
EI881025	R1.25	**2.5**	6	4	6	60	2.4
EI881030	R1.5	**3.0**	6	4.5	6.5	60	2.8
EI881035	R1.75	**3.5**	6	5	7	65	3.2
EI881040	R2.0	**4.0**	6	6	8	65	3.7
EI881050	R2.5	**5.0**	6	7.5	10	65	4.6
EI881060	R3.0	**6.0**	6	9	12	75	5.6
EI881080	R4.0	**8.0**	8	12	25	75	7.4
EI881100	R5.0	**10.0**	10	15	30	80	9.4
EI881120	R6.0	**12.0**	12	18	36	90	11.4

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

◎ : 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
Recommended																				

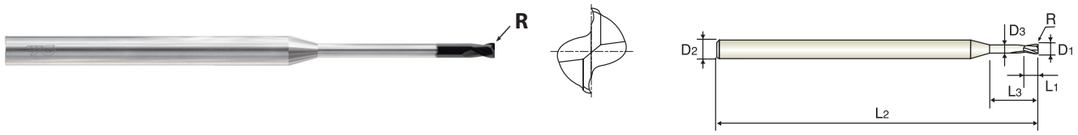
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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
Recommended					○				◎												

SOLID CARBIDE END MILLS

2 FLUTE MINIATURE CORNER RADIUS with NECK

SERIES
PLAIN SHANK **EI996**

- ▶ Perfectly suited for micro machining applications
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)



CARBIDE 2 30° PLAIN Diamond p.21

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
EI99600200000	-	**0.2**	3	0.3	-	40	-
EI99600300000	-	**0.3**	3	0.5	-	40	-
EI99600400000	-	**0.4**	3	0.6	-	40	-
EI99600505025	R0.05	**0.5**	3	0.7	2.5	40	0.45
EI99600505040	R0.05	**0.5**	3	0.7	4	40	0.45
EI996006	R0.05	**0.6**	3	0.9	3	40	0.55
EI99600605050	R0.05	**0.6**	3	0.9	5	40	0.55
EI996008	R0.05	**0.8**	3	1.2	4	40	0.75
EI99600805070	R0.05	**0.8**	3	1.2	7	40	0.75
EI996010	R0.1	**1.0**	3	1.5	5	40	0.95
EI996904	R0.1	**1.0**	3	1.5	8.5	40	0.95
EI99601010120	R0.1	**1.0**	3	1.5	12	40	0.95
EI996012	R0.1	**1.2**	3	1.8	6	50	1.15
EI99601210100	R0.1	**1.2**	3	1.8	10	50	1.15
EI996015	R0.15	**1.5**	3	2.2	7.5	50	1.4
EI996907	R0.15	**1.5**	3	2.2	12	50	1.4
EI99601515180	R0.15	**1.5**	3	2.2	18	50	1.4
EI996020	R0.15	**2.0**	3	2.2	10	60	1.9
EI996909	R0.15	**2.0**	3	2.2	16	60	1.9
EI99602015250	R0.15	**2.0**	3	2.2	25	60	1.9
EI99603020100	R0.2	**3.0**	4	3	10	65	2.9
EI99603020150	R0.2	**3.0**	4	3	15	65	2.9

▶ NEXT PAGE

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.02	h5

◎ : 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
Recommended																				

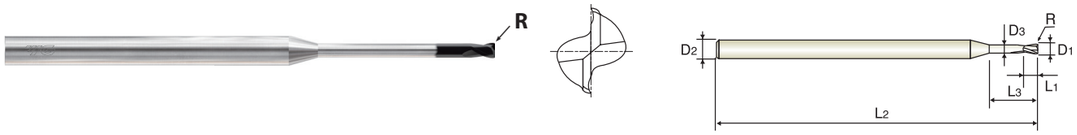
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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
Recommended					○				◎												

SOLID CARBIDE END MILLS

2 FLUTE MINIATURE CORNER RADIUS with NECK

SERIES
PLAIN SHANK **EI996**

- ▶ Perfectly suited for micro machining applications
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)



CARBIDE 2 30° PLAIN Diamond p.21

Unit : mm

EDP No.	Corner Radius R	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
EI99603020200	R0.2	**3.0**	4	3	20	65	2.9
EI99603020250	R0.2	**3.0**	4	3	25	75	2.9
EI99603020300	R0.2	**3.0**	4	3	30	75	2.9
EI99604020200	R0.2	**4.0**	6	4	20	65	3.9
EI99604020300	R0.2	**4.0**	6	4	30	75	3.9
EI99604020400	R0.2	**4.0**	6	4	40	90	3.9
EI99605030200	R0.3	**5.0**	6	5	20	75	4.9
EI99605030300	R0.3	**5.0**	6	5	30	75	4.9
EI99605030400	R0.3	**5.0**	6	5	40	90	4.9
EI99605030500	R0.3	**5.0**	6	5	50	90	4.9
EI99606030300	R0.3	**6.0**	6	6	30	75	5.9
EI99606030400	R0.3	**6.0**	6	6	40	90	5.9
EI99606030500	R0.3	**6.0**	6	6	50	90	5.9
EI99606030600	R0.3	**6.0**	6	6	60	100	5.9

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.02	h5

◎ : 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
Recommended																				

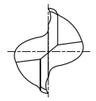
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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
Recommended					○				◎												

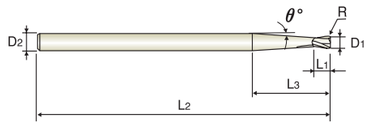
SOLID CARBIDE END MILLS

2 FLUTE CORNER RADIUS with TAPER NECK

SERIES
PLAIN SHANK **EIB86**

- ▶ Tapered and high stick-out length for difficult-to-reach micro machining applications
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)





CARBIDE 2 30° PLAIN Diamond p.21

Unit : mm

EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Taper Angle(°)
	R	D1	D2	L1	L3	L2	θ°
EIB86010	R0.1	**1.0**	3	2	30	60	**2°**
EIB86901	R0.1	**1.0**	3	2	70	100	**1°**
EIB86015	R0.15	**1.5**	3	3	30	60	**1° 30´**
EIB86902	R0.15	**1.5**	3	3	50	100	**1°**
EIB86020	R0.15	**2.0**	3	4	30	60	**1°**
EIB86903	R0.15	**2.0**	4	4	70	100	**1°**

Mill Dia. Tolerance (mm)	Shank Dia. Tolerance
0 ~ - 0.02	h5

◎ : 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
Recommended																				

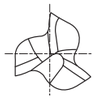
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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
Recommended					○				◎												

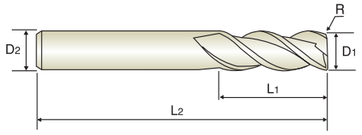
SOLID CARBIDE END MILLS

3 FLUTE 40° HELIX CORNER RADIUS SHORT LENGTH

SERIES
PLAIN SHANK **EIA13**

- ▶ Short reach length for perfectly stable roughing applications
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)





CARBIDE 3 40° PLAIN Diamond p.22

Unit : mm

EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
	R	D1	D2	L1	L2
EIA13020	R0.15	**2.0**	3	6	40
EIA13030	R0.15	**3.0**	3	12	40
EIA13040	R0.2	**4.0**	4	14	50
EIA13050	R0.3	**5.0**	5	16	50
EIA13060	R0.3	**6.0**	6	20	65
EIA13080	R0.5	**8.0**	8	20	65
EIA13100	R0.5	**10.0**	10	25	75
EIA13120	R0.5	**12.0**	12	25	75

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

◎ : 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
Recommended																				

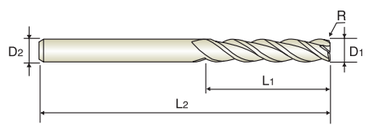
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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
Recommended					○				◎												

SOLID CARBIDE END MILLS

3 FLUTE 40° HELIX CORNER RADIUS LONG LENGTH

SERIES
PLAIN SHANK **EIA14**

- ▶ Long wall finishing up to 10xD length of cut at certain diameters
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)



CARBIDE 3 40° PLAIN Diamond p.22

Unit : mm

EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Overall Length
	R	D1	D2	L1	L2
EIA14020	R0.15	**2.0**	3	9	60
EIA14030	R0.15	**3.0**	3	30	60
EIA14040	R0.2	**4.0**	4	30	60
EIA14050	R0.3	**5.0**	5	35	70
EIA14060	R0.3	**6.0**	6	40	100
EIA14080	R0.5	**8.0**	8	40	100
EIA14100	R0.5	**10.0**	10	40	100
EIA14120	R0.5	**12.0**	12	45	100

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

◎ : 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
Recommended																				

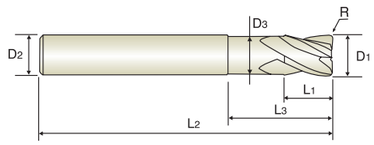
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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
Recommended					○				◎												

SOLID CARBIDE END MILLS

4 FLUTE CORNER RADIUS with NECK

SERIES
PLAIN SHANK **EIB88**

- ▶ Short reach length for perfectly stable roughing applications
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)



CARBIDE 4 30° PLAIN Diamond p.22

Unit : mm

EDP No.	Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
	R	D1	D2	L1	L3	L2	D3
EIB88060	R0.5	**6.0**	6	10	40	80	5.9
EIB88080	R0.5	**8.0**	8	10	40	80	7.8
EIB88901	R1.0	**8.0**	8	10	60	100	7.8
EIB88100	R0.5	**10.0**	10	25	-	75	-
EIB88902	R0.5	**10.0**	10	12	40	80	9.8
EIB88903	R1.0	**10.0**	10	12	40	80	9.8
EIB88904	R0.5	**10.0**	10	12	80	125	9.8
EIB88120	R0.5	**12.0**	12	25	-	80	-
EIB88905	R0.5	**12.0**	12	15	40	80	11.8
EIB88906	R1.0	**12.0**	12	15	40	80	11.8
EIB88907	R1.0	**12.0**	12	15	80	125	11.8

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

◎ : 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
Recommended																				

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
Recommended					○				◎												

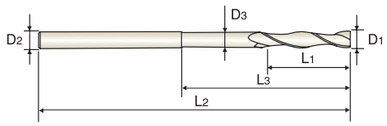
SOLID CARBIDE END MILLS

2 FLUTE LONG LENGTH with NECK

SERIES

PLAIN SHANK **EIB04**

- ▶ Long wall finishing up to 10xD length of cut at certain diameters
- ▶ High helix design to minimize end mill displacement
- ▶ Diamond Coating for excellent wear resistance
- ▶ Outstanding results on all types of graphite as well as other abrasive or prone to built-up edge materials (bakelite, green ceramic, brass etc.)



CARBIDE 2 30° PLAIN Diamond p.22

Unit : mm

EDP No.	Mill Diameter D1	Shank Diameter D2	Length of Cut L1	Length Below Shank L3	Overall Length L2	Neck Diameter D3
EIB0400502040	0.5	3	1	2	40	0.45
EIB0400603040	0.6	3	2	3	40	0.55
EIB0400704040	0.7	3	2	4	40	0.65
EIB0400805040	0.8	3	2	5	40	0.75
EIB0400906040	0.9	3	2	6	40	0.85
EIB0401008075	1.0	4	3	8	75	0.95
EIB0401510075	1.5	4	4	10	75	1.45
EIB0402016100	2.0	4	6	16	100	1.9
EIB0402520100	2.5	4	8	20	100	2.4
EIB0403030100	3.0	6	8	30	100	2.8
EIB0403535100	3.5	6	10	35	100	3.2
EIB0404040100	4.0	6	20	40	100	3.7
EIB0405050125	5.0	6	25	50	125	4.6
EIB0406060140	6.0	6	30	60	140	5.6
EIB0407000140	7.0	6	35	-	140	-
EIB0408080150	8.0	8	40	80	150	7.4
EIB0409000150	9.0	8	45	-	150	-
EIB0410080150	10.0	10	50	80	150	9.4
EIB0411000150	11.0	10	50	-	150	-
EIB0412080150	12.0	12	55	80	150	11.4

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

◎ : Excellent ○ : Good

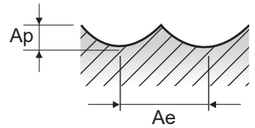
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	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
Recommended																				

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
Recommended					○				◎												

EI997, EIB93, EIB87 SERIES 2 FLUTE BALL NOSE

Vc = m/min. RPM = rev./min. fz = mm/tooth FEED = mm/min.

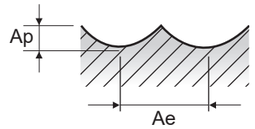
ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 0.4	0.6	0.8	1.0	1.2	1.5	2.0	3.0	4.0	5.0	6.0
N	29.2	Graphite	0.2D	0.2D	Vc	50	75	100	125	150	190	250	255	250	250	265
					fz	0.008	0.010	0.012	0.015	0.018	0.020	0.025	0.041	0.073	0.091	0.104
					RPM	39789	39789	39789	39789	39789	40319	39789	27056	19894	15915	14059
					FEED	637	796	955	1194	1432	1613	1989	2219	2905	2897	2924



EI880, EI451, EI450 SERIES 2 FLUTE BALL NOSE

Vc = m/min. RPM = rev./min. fz = mm/tooth FEED = mm/min.

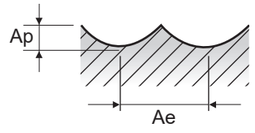
ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 2.0	2.5	3.0	3.5	4.0	5.0	6.0	8.0	10.0	12.0
N	29.2	Graphite	0.2D	0.2D	Vc	100	125	150	175	200	245	285	325	360	395
					fz	0.025	0.035	0.045	0.055	0.066	0.082	0.098	0.115	0.133	0.150
					RPM	15915	15915	15915	15915	15915	15597	15120	12931	11459	10478
					FEED	796	1114	1432	1751	2101	2558	2963	2974	3048	3143



EI881 SERIES 3 FLUTE BALL NOSE

Vc = m/min. RPM = rev./min. fz = mm/tooth FEED = mm/min.

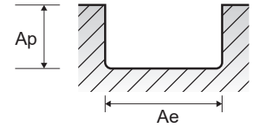
ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 2.0	2.5	3.0	3.5	4.0	5.0	6.0	8.0	10.0	12.0
N	29.2	Graphite	0.2D	0.2D	Vc	100	125	150	175	200	245	285	325	360	395
					fz	0.025	0.035	0.045	0.055	0.065	0.082	0.099	0.115	0.133	0.151
					RPM	15915	15915	15915	15915	15915	15597	15120	12931	11459	10478
					FEED	1194	1671	2149	2626	3104	3837	4491	4461	4572	4746



EI996, EIB86 SERIES 2 FLUTE CORNER RADIUS - SLOTTING

Vc = m/min. RPM = rev./min. fz = mm/tooth FEED = mm/min.

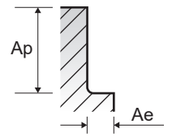
ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 0.4	0.6	0.8	1.0	1.2	1.5	2.0	3.0	4.0	5.0	6.0
N	29.2	Graphite	1.0D	0.5D	Vc	50	75	100	125	150	190	250	255	250	250	265
					fz	0.008	0.008	0.010	0.012	0.015	0.018	0.020	0.035	0.058	0.072	0.082
					RPM	39789	39789	39789	39789	39789	40319	39789	27056	19894	15915	14059
					FEED	637	637	796	955	1194	1451	1592	1894	2308	2292	2306



EIA13, EIA14 SERIES 3 FLUTE CORNER RADIUS - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.

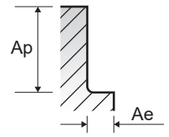
ISO	VDI 3323	Material Description	Ae	Ap	Para-meter	Diameter (Ø)							
						2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0
N	29.2	Graphite	0.3D	0.3D	Vc	250	375	505	630	755	805	815	790
					fz	0.025	0.035	0.050	0.060	0.070	0.088	0.110	0.130
					RPM	39789	39789	40187	40107	40054	32030	25942	20955
					FEED	2984	4178	6028	7219	8411	8456	8561	8173



EIB88 SERIES 4 FLUTE CORNER RADIUS - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.

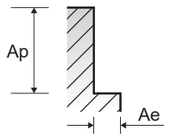
ISO	VDI 3323	Material Description	Ae	Ap	Para-meter	Diameter (Ø)			
						6.0	8.0	10.0	12.0
N	29.2	Graphite	0.3D	0.3D	Vc	755	805	815	790
					fz	0.035	0.044	0.055	0.065
					RPM	40054	32030	25942	20955
					FEED	5608	5637	5707	5448



EIB04 SERIES 2 FLUTE - SIDE CUTTING

Vc = m/min. fz = mm/tooth
RPM = rev./min. FEED = mm/min.

ISO	VDI 3323	Material Description	Ae	Ap	Para-meter	Diameter (Ø)												
						0.4	0.6	0.8	1.0	1.5	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0
N	29.2	Graphite	0.1D	1.5D	Vc	50	75	100	125	190	155	190	225	220	205	200	205	205
					fz	0.003	0.004	0.007	0.009	0.010	0.016	0.020	0.026	0.043	0.064	0.081	0.092	0.109
					RPM	39789	39789	39789	39789	40319	24669	20160	17905	14006	10876	7958	6525	5438
					FEED	239	318	557	716	806	789	806	931	1204	1392	1289	1201	1185



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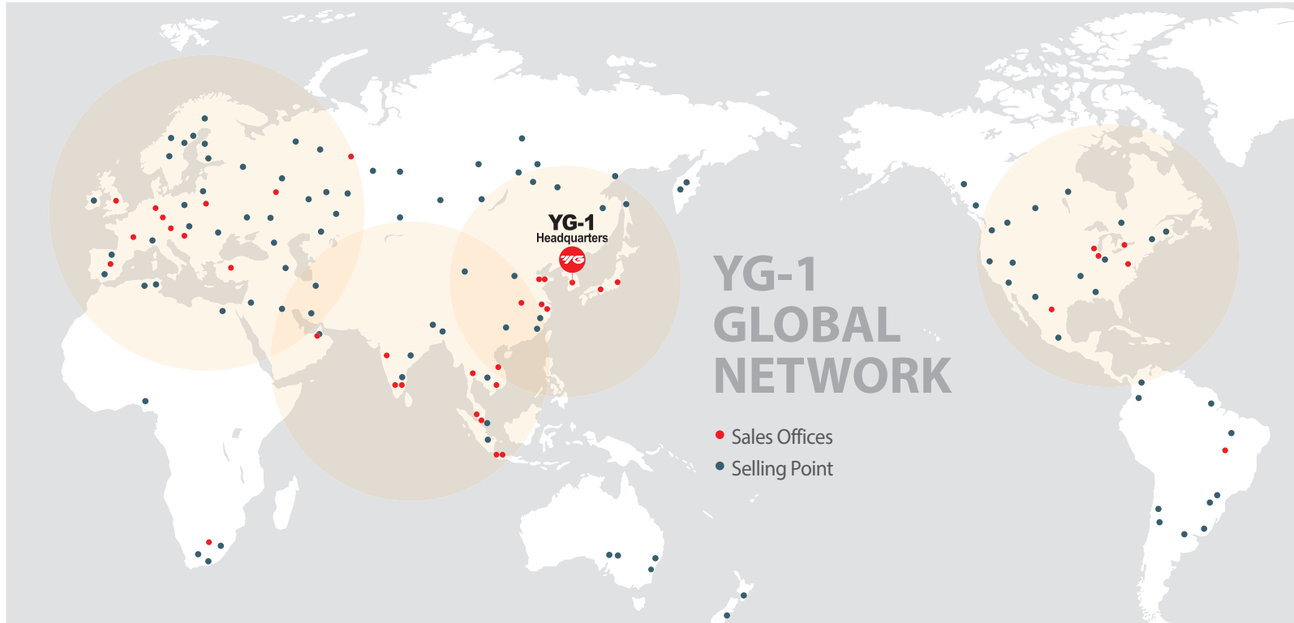

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