

## EFFICIENCY MILLS

EM

► Micro Diameter / Square / for **P** **K**

unit: mm

Order No.	Diameter D1	Flute Length L1	O.A.L. L2	Shank Dia D2
EM 0044	0.4	0.8	50	4
EM 0054	0.5	1.0	50	4
EM 0064	0.6	1.2	50	4
EM 0074	0.7	1.4	50	4
EM 0084	0.8	1.6	50	4
EM 0094	0.9	1.8	50	4
EM 0124	1.2	3.0	50	4
EM 0144	1.4	3.0	50	4
EM 0164	1.6	4.0	50	4
EM 0184	1.8	5.0	50	4

MG

2 Flutes



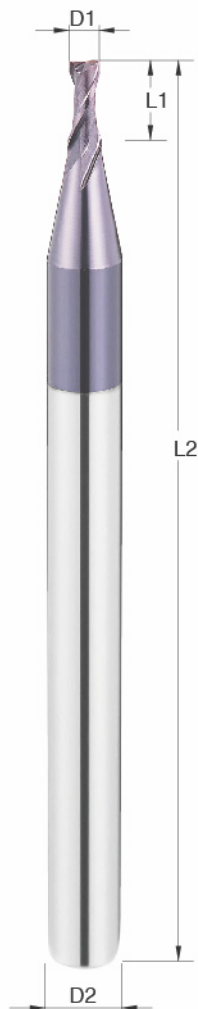
35°

HRC  
55

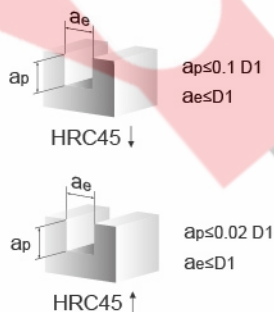
TiAlN

Finishing  
Semi-  
Finishing

Slotting



## ▼ Depth of cut



## ▼ Recommended cutting condition for EM

MATERIAL	Carbon Steels . Alloy Steels S45C, FC, FCD, SCM, S50C, SKS...		Alloy Steels . Tool Steels SCr, SNCM, SKD11, SKD61, NAK80...		Hardened Steels SKD11	
HARDNESS	~HRC30		~HRC50		~HRC60	
Dia. (D1)	SPEED (min <sup>-1</sup> )	FEED mm / min	SPEED (min <sup>-1</sup> )	FEED mm / min	SPEED (min <sup>-1</sup> )	FEED mm / min
0.4	40000	100 - 400	25000	80 - 350	10000	50 - 250
0.5	40000	100 - 500	25000	80 - 400	10000	50 - 250
0.6	38000	100 - 600	25000	80 - 500	8000	50 - 250
0.7	36000	100 - 700	20000	80 - 600	8000	50 - 250
0.8	34000	100 - 800	20000	80 - 700	8000	50 - 250
0.9	32000	100 - 1000	20000	80 - 800	8000	50 - 250