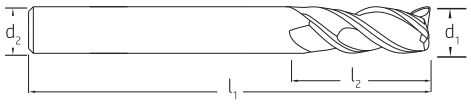

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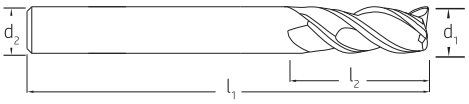
Steels	Stainless Steels	Cast Irons	Hardened Steels	Titaniums	Super Alloys	Aluminiums
<35HRC	<1100 N/mm²	<300 HB	-	<1100 N/mm²	<1100 N/mm²	-

d_1	d_1	d_2	d_3	l_2	l_3	l_1	CCx45°	z	EDP No. HA	EDP No. HB
	tol.	*h6*	*-0.2*	*±0.50*	*±0.50*	*±0.80*	*-0.05*		GX	GX
1.0	-0.010	4		2.0		45	-	3	903SCT 0100	
1.1	-0.020	4		2.2		45	-	3	903SCT 0110	
1.2	-0.020	4		24		45	-	3	903SCT 0120	
1.3	-0.020	4		2.6		45	-	3	903SCT 0130	
14	-0.020	4		2.8		45	-	3	903SCT 0140	
1.5	-0.020	4		3.0		45	-	3	903SCT 0150	
1.6	-0.020	4		3.2		45	-	3	903SCT 0160	
1.7	-0.020	4		34		45	-	3	903SCT 0170	
1.8	-0.020	4		3.6		45	-	3	903SCT 0180	
1.9	-0.020	4		3.8		45	-	3	903SCT 0190	
2.0	-0.020	6		4.0		50	0.10	3	903SCT 0200	903SWT 0200
2.1	-0.025	6		4.2		50	0.10	3	903SCT 0210	903SWT 0210
2.2	-0.025	6		44		50	0.10	3	903SCT 0220	903SWT 0220
2.3	-0.025	6		4.6		50	0.10	3	903SCT 0230	903SWT 0230
24	-0.025	6		4.8		50	0.10	3	903SCT 0240	903SWT 0240
2.5	-0.025	6		5.0		50	0.10	3	903SCT 0250	903SWT 0250
2.6	-0.025	6		5.2		50	0.10	3	903SCT 0260	903SWT 0260
2.7	-0.025	6		54		50	0.10	3	903SCT 0270	903SWT 0270
2.8	-0.025	6		5.6		50	0.10	3	903SCT 0280	903SWT 0280
2.9	-0.025	6		5.8		50	0.10	3	903SCT 0290	903SWT 0290
3.0	-0.025	6		6.0		50	0.10	3	903SCT 0300	903SWT 0300
3.1	-0.025	6		7.0		50	0.15	3	903SCT 0310	903SWT 0310
3.2	-0.025	6		7.0		50	0.15	3	903SCT 0320	903SWT 0320
3.3	-0.025	6		7.0		50	0.15	3	903SCT 0330	903SWT 0330
34	-0.025	6		7.0		50	0.15	3	903SCT 0340	903SWT 0340

SUPERNOX

3 Flute 41°/42°/43° Helix & Unequal Pitch Endmills, Corner Chamfer

903S



Technical Info. Page No. ***135***

Steels	Stainless Steels	Cast Irons	Hardened Steels	Titaniums	Super Alloys	Aluminiums
<35HRC	<1100 N/mm²	<300 HB	-	<1100 N/mm²	<1100 N/mm²	-

d_1	d_1	d_2	d_3	l_2	l_3	l_1	CCx45°	z	EDP No. HA	EDP No. HB
	tol.	*h6*	*-0.10*	*±0.50*	*±0.50*	*±0.80*	*-0.05*		GX	GX
3.5	-0.025	6		8.0		50	0.15	3	903SCT 0350	903SWT 0350
3.6	-0.025	6		8.0		50	0.15	3	903SCT 0360	903SWT 0360
3.7	-0.025	6		8.0		50	0.15	3	903SCT 0370	903SWT 0370
3.8	-0.025	6		8.0		50	0.15	3	903SCT 0380	903SWT 0380
3.9	-0.025	6		8.0		50	0.15	3	903SCT 0390	903SWT 0390
4.0	-0.025	6		8.0		50	0.15	3	903SCT 0400	903SWT 0400
4.5	-0.025	6		10.0		50	0.15	3	903SCT 0450	903SWT 0450
5.0	-0.025	6		10.0		50	0.15	3	903SCT 0500	903SWT 0500
5.5	-0.025	6		13.0		50	0.20	3	903SCT 0550	903SWT 0550
6.0	-0.025	6		13.0		60	0.20	3	903SCT 0600	903SWT 0600
6.5	-0.025	8		13.0		60	0.20	3	903SCT 0650	903SWT 0650
7.0	-0.025	8		16.0		60	0.20	3	903SCT 0700	903SWT 0700
7.5	-0.025	8		16.0		60	0.20	3	903SCT 0750	903SWT 0750
8.0	-0.025	8		19.0		60	0.20	3	903SCT 0800	903SWT 0800
8.5	-0.035	10		19.0		70	0.30	3	903SCT 0850	903SWT 0850
9.0	-0.035	10		19.0		70	0.30	3	903SCT 0900	903SWT 0900
9.5	-0.035	10		19.0		70	0.30	3	903SCT 0950	903SWT 0950
10.0	-0.035	10		22.0		80	0.30	3	903SCT 1000	903SWT 1000
11.0	-0.035	12		22.0		80	0.35	3	903SCT 1100	903SWT 1100
12.0	-0.035	12		26.0		90	0.35	3	903SCT 1200	903SWT 1200
15.0	-0.035	16		26.0		110	040	3	903SCT 1500	903SWT 1500
16.0	-0.035	16		30.0		110	040	3	903SCT 1600	903SWT 1600
20.0	-0.035	20		32.0		140	0.50	3	903SCT 2000	903SWT 2000

	MATERIAL	Hardness	ap max xD	ae max xD	Vc (m/min)	fz (mm/z) Ø 3	6	8	10	12	16	20
	SLOTTING											
P	Steels, Alloy Steels and Tool Steels	<850 N/mm²	1	1	100-160	0.012	0.029	0.049	0.061	0.074	0.100	0.108
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	1	1	60-90	0.010	0.022	0.036	0.045	0.055	0.074	0.080
	Steels, Alloy Steels and Tool Steels	<1400 N/mm²										
M	Stainless Steel : Easy To Machine	<750 N/mm²	1	1	90-120	0.009	0.024	0.041	0.051	0.060	0.076	0.085
	Stainless Steel : Difficult To Machine	<950 N/mm²	0.3	1	60-90	0.007	0.019	0.032	0.040	0.048	0.064	0.069
K	Cast Irons, Grey, Spher., Melleable	<300 HB	1	1	60-90	0.010	0.022	0.036	0.045	0.055	0.074	0.080
N	Aluminiums, Aluminiums Alloys	<6% Si										
S	Titanium , Titanium Alloys	<1100N/mm²	0.3	1	40-60	0.007	0.019	0.032	0.040	0.048	0.064	0.069
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²	0.3	1	12-20	0.008	0.026	0.045	0.056	0.067	0.090	0.096
	SIDE MILLING											
P	Steels, Alloy Steels and Tool Steels	<850 N/mm²	1	0.3	130-200	0.012	0.029	0.049	0.061	0.074	0.100	0.107
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	1	0.3	70-120	0.010	0.022	0.036	0.045	0.055	0.074	0.080
	Steels, Alloy Steels and Tool Steels	<1400 N/mm²										
M	Stainless Steel : Easy To Machine	<750 N/mm²	1	0.3	120-180	0.009	0.024	0.041	0.051	0.060	0.079	0.085
	Stainless Steel : Difficult To Machine	<950 N/mm²	1	0.3	70-110	0.007	0.019	0.032	0.040	0.048	0.064	0.069
K	Cast Irons, Grey, Spher., Melleable	<300 HB	1	0.3	80-120	0.007	0.019	0.034	0.043	0.050	0.067	0.072
N	Aluminiums, Aluminiums Alloys	<6% Si										
S	Titanium , Titanium Alloys	<1100N/mm²	1	<0.3	50-70	0.007	0.019	0.032	0.040	0.048	0.064	0.069
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²	1	<0.3	15-23	0.005	0.012	0.019	0.024	0.029	0.038	0.043
	RAMPING											
P	Steels, Alloy Steels and Tool Steels	<850 N/mm²										
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm²										
	Steels, Alloy Steels and Tool Steels	<1400 N/mm²										
M	Stainless Steel : Easy To Machine	<750 N/mm²										
	Stainless Steel : Difficult To Machine	<950 N/mm²										
K	Cast Irons, Grey, Spher., Melleable	<300 HB										
N	Aluminiums, Aluminiums Alloys	<6% Si										
S	Titanium , Titanium Alloys	<1100N/mm²										
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²										
	HELICAL MILLING											
P	Steels, Alloy Steels and Tool Steels	<850 N/mm²										
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm²										
	Steels, Alloy Steels and Tool Steels	<1400 N/mm²										
M	Stainless Steel : Easy To Machine	<750 N/mm²										
	Stainless Steel : Difficult To Machine	<950 N/mm²										
K	Cast Irons, Grey, Spher., Melleable	<300 HB										
N	Aluminiums, Aluminiums Alloys	<6% Si										
S	Titanium , Titanium Alloys	<1100N/mm²										
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²										
	DRILLING											
P	Steels, Alloy Steels and Tool Steels	<850 N/mm²										
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm²										
	Steels, Alloy Steels and Tool Steels	<1400 N/mm²										
M	Stainless Steel : Easy To Machine	<750 N/mm²										
	Stainless Steel : Difficult To Machine	<950 N/mm²										
K	Cast Irons, Grey, Spher., Melleable	<300 HB										
N	Aluminiums, Aluminiums Alloys	<6% Si										
S	Titanium , Titanium Alloys	<1100N/mm²										
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²										
	TROCHOIDAL MILLING											
P	Steels, Alloy Steels and Tool Steels	<850 N/mm²										
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm²										
	Steels, Alloy Steels and Tool Steels	<1400 N/mm²										
M	Stainless Steel : Easy To Machine	<750 N/mm²										
	Stainless Steel : Difficult To Machine	<950 N/mm²										
K	Cast Irons, Grey, Spher., Melleable	<300 HB										
N	Aluminiums, Aluminiums Alloys	<6% Si										
S	Titanium , Titanium Alloys	<1100N/mm²										
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²										

Technical Data provided should be considered advisory only as variations may be necessary depending on the particular application