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Steels <35HRC		Stainless Steels <1100 N/mm²		Cast Irons <300 HB		Hardened Steels -		Titaniums <1100 N/mm²		Super Alloys <1100 N/mm²		Aluminums -	
d ₁	d ₁	d ₂	d ₃	l ₂	l ₃	l ₁	r	z	EDP No. HA		EDP No. HA		
tol.		h6	-0.2	±0.50	±0.50	±0.80	±0.015		AlCrN		GX		
6.0	-0.025	6	5.8	13.0	21	57	0.30	5	905SCA 0600 030		905SCT 0600 030		
6.0	-0.025	6	5.8	13.0	21	57	0.50	5	905SCA 0600 050		905SCT 0600 050		
6.0	-0.025	6	5.8	13.0	21	57	1.00	5	905SCA 0600 100		905SCT 0600 100		
6.0	-0.025	6	5.8	13.0	21	57	1.50	5	905SCA 0600 150		905SCT 0600 150		
8.0	-0.025	8	7.6	19.0	26	63	0.50	5	905SCA 0800 050		905SCT 0800 050		
8.0	-0.025	8	7.6	19.0	26	63	1.00	5	905SCA 0800 100		905SCT 0800 100		
8.0	-0.025	8	7.6	19.0	26	63	1.50	5	905SCA 0800 150		905SCT 0800 150		
8.0	-0.025	8	7.6	19.0	26	63	2.00	5	905SCA 0800 200		905SCT 0800 200		
10.0	-0.035	10	9.5	22.0	31	72	0.50	5	905SCA 1000 050		905SCT 1000 050		
10.0	-0.035	10	9.5	22.0	31	72	1.00	5	905SCA 1000 100		905SCT 1000 100		
10.0	-0.035	10	9.5	22.0	31	72	1.50	5	905SCA 1000 150		905SCT 1000 150		
10.0	-0.035	10	9.5	22.0	31	72	2.00	5	905SCA 1000 200		905SCT 1000 200		
10.0	-0.035	10	9.5	22.0	31	72	2.50	5	905SCA 1000 250		905SCT 1000 250		
12.0	-0.035	12	11.5	26.0	37	83	0.50	5	905SCA 1200 050		905SCT 1200 050		
12.0	-0.035	12	11.5	26.0	37	83	0.80	5	905SCA 1200 076		905SCT 1200 076		
12.0	-0.035	12	11.5	26.0	37	83	1.00	5	905SCA 1200 100		905SCT 1200 100		
12.0	-0.035	12	11.5	26.0	37	83	1.50	5	905SCA 1200 150		905SCT 1200 150		
12.0	-0.035	12	11.5	26.0	37	83	2.00	5	905SCA 1200 200		905SCT 1200 200		
12.0	-0.035	12	11.5	26.0	37	83	2.50	5	905SCA 1200 250		905SCT 1200 250		
12.0	-0.035	12	11.5	26.0	37	83	3.00	5	905SCA 1200 300		905SCT 1200 300		
16.0	-0.035	16	15.5	35.0	43	92	1.00	5	905SCA 1600 100		905SCT 1600 100		
16.0	-0.035	16	15.5	35.0	43	92	1.50	5	905SCA 1600 150		905SCT 1600 150		
16.0	-0.035	16	15.5	35.0	43	92	2.00	5	905SCA 1600 200		905SCT 1600 200		

HB Weldon Shank available on request. Order Code for AlCrN Coated : 905SWA | Order Code for GX Coated: 905SWT

STEELS

INOX

SUPERNOX

CHIPSPLITTERS

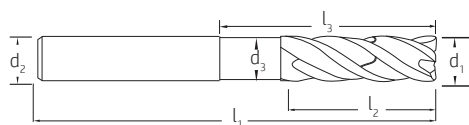
Aluminiums

ROCKSTARS

MICRO MILLS

UNIVERSAL

DRILLS



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Steels <35HRC		Stainless Steels <1100 N/mm²		Cast Irons <300 HB		Hardened Steels -		Titaniums <1100 N/mm²		Super Alloys <1100 N/mm²		Aluminiums -	
d ₁	d ₁	d ₂	d ₃	l ₂	l ₃	l ₁	r	z	EDP No. HA		EDP No. HB		
tol.		h6	-0.2	±0.50	±0.50	±0.80	±0.015		AlCrN		GX		
16.0	-0.035	16	15.5	35.0	43	92	2.50	5	905SCA 1600 250		905SCT 1600 250		
16.0	-0.035	16	15.5	35.0	43	92	3.00	5	905SCA 1600 300		905SCT 1600 300		
16.0	-0.035	16	15.5	35.0	43	92	4.00	5	905SCA 1600 400		905SCT 1600 400		
20.0	-0.035	20	19.5	45.0	53	104	1.00	5	905SCA 2000 100		905SCT 2000 100		
20.0	-0.035	20	19.5	45.0	53	104	1.50	5	905SCA 2000 150		905SCT 2000 150		
20.0	-0.035	20	19.5	45.0	53	104	2.00	5	905SCA 2000 200		905SCT 2000 200		
20.0	-0.035	20	19.5	45.0	53	104	2.50	5	905SCA 2000 250		905SCT 2000 250		
20.0	-0.035	20	19.5	45.0	53	104	3.00	5	905SCA 2000 300		905SCT 2000 300		
20.0	-0.035	20	19.5	45.0	53	104	4.00	5	905SCA 2000 400		905SCT 2000 400		
20.0	-0.035	20	19.5	45.0	53	104	5.00	5	905SCA 2000 500		905SCT 2000 500		

HB Weldon Shank available on request. Order Code for AlCrN Coated : 905SWA | Order Code for GX Coated: 905SWT

	MATERIAL	Hardness	ap max xD	ae max xD	Vc (m/min)	6	8	10	12	16	18	20
	SLOTTING											
	P Steels, Alloy Steels and Tool Steels	<850 N/mm ²	1	1	130-150	0.030	0.040	0.050	0.060	0.070	0.080	0.100
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm ²	1	1	90-110	0.022	0.028	0.034	0.039	0.044	0.049	0.059
	Steels, Alloy Steels and Tool Steels	<1400 N/mm ²	≤ 1	1	50-70	0.018	0.024	0.029	0.032	0.036	0.041	0.049
M	Stainless Steel : Easy To Machine	<750 N/mm ²	1	1	70-90	0.022	0.028	0.034	0.039	0.044	0.049	0.059
	Stainless Steel : Difficult To Machine	<950 N/mm ²	0.5	1	50-70	0.017	0.022	0.026	0.030	0.034	0.038	0.046
K	Cast Irons, Grey, Spher., Malleable	<300 HB	1	1	90-130	0.022	0.028	0.034	0.039	0.044	0.049	0.059
N	Aluminiums, Aluminiums Alloys	<6% Si										
S	Titanium , Titanium Alloys	<1100N/mm ²	0.5	1	30-50	0.017	0.022	0.026	0.030	0.034	0.038	0.046
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm ²	0.5	1	30-50	0.017	0.022	0.026	0.030	0.034	0.038	0.046
	SIDE MILLING											
	P Steels, Alloy Steels and Tool Steels	<850 N/mm ²	1	0.3	150-180	0.030	0.040	0.050	0.060	0.070	0.080	0.100
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm ²	1	0.3	120-150	0.024	0.032	0.040	0.048	0.056	0.064	0.080
	Steels, Alloy Steels and Tool Steels	<1400 N/mm ²	1	0.3	60-80	0.023	0.030	0.036	0.041	0.047	0.052	0.063
M	Stainless Steel : Easy To Machine	<750 N/mm ²	1.5	0.5	90-110	0.026	0.034	0.041	0.047	0.052	0.058	0.071
	Stainless Steel : Difficult To Machine	<950 N/mm ²	1.2	0.3	60-80	0.023	0.030	0.036	0.041	0.047	0.052	0.063
K	Cast Irons, Grey, Spher., Malleable	<300 HB	1	0.3	120-150	0.026	0.034	0.041	0.047	0.052	0.058	0.071
N	Aluminiums, Aluminiums Alloys	<6% Si										
S	Titanium , Titanium Alloys	<1100N/mm ²	1	0.3	40-50	0.032	0.042	0.050	0.057	0.064	0.064	0.078
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm ²	1	0.3	40-50	0.032	0.042	0.050	0.057	0.064	0.064	0.078
	RAMPING											
	P Steels, Alloy Steels and Tool Steels	<850 N/mm ²	10°	1	100-120	0.019	0.021	0.024	0.028	0.032	0.035	0.043
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm ²	10°	1	55-75	0.017	0.023	0.023	0.026	0.029	0.032	0.039
	Steels, Alloy Steels and Tool Steels	<1400 N/mm ²										
M	Stainless Steel : Easy To Machine	<750 N/mm ²	10°	1	60-80	0.018	0.023	0.028	0.032	0.036	0.040	0.048
	Stainless Steel : Difficult To Machine	<950 N/mm ²	5°	1	45-65	0.017	0.022	0.026	0.030	0.034	0.038	0.046
K	Cast Irons, Grey, Spher., Malleable	<300 HB	10°	1	60-80	0.018	0.023	0.028	0.032	0.036	0.040	0.048
N	Aluminiums, Aluminiums Alloys	<6% Si										
S	Titanium , Titanium Alloys	<1100N/mm ²	5°	1	30-40	0.023	0.030	0.036	0.042	0.047	0.052	0.063
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm ²	5°	1	30-40	0.023	0.030	0.036	0.042	0.047	0.052	0.063
	HELICAL MILLING											
	P Steels, Alloy Steels and Tool Steels	<850 N/mm ²	5°	0.3	110-130	0.018	0.024	0.030	0.032	0.035	0.040	0.048
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm ²	4°	0.3	70-90	0.016	0.021	0.026	0.029	0.033	0.037	0.045
	Steels, Alloy Steels and Tool Steels	<1400 N/mm ²	3°	0.3	50-70	0.015	0.019	0.023	0.026	0.029	0.032	0.039
M	Stainless Steel : Easy To Machine	<750 N/mm ²	4°	0.4	70-90	0.016	0.021	0.026	0.029	0.033	0.037	0.045
	Stainless Steel : Difficult To Machine	<950 N/mm ²	3°	0.4	70-90	0.015	0.019	0.023	0.026	0.029	0.036	0.039
K	Cast Irons, Grey, Spher., Malleable	<300 HB	4°	0.4	70-90	0.016	0.021	0.026	0.029	0.033	0.037	0.045
N	Aluminiums, Aluminiums Alloys	<6% Si										
S	Titanium , Titanium Alloys	<1100N/mm ²	3°	0.4	30-50	0.014	0.019	0.021	0.024	0.027	0.030	0.037
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm ²	3°	0.4	30-50	0.014	0.019	0.021	0.024	0.027	0.030	0.037
	DRILLING											
	P Steels, Alloy Steels and Tool Steels	<850 N/mm ²										
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm ²										
	Steels, Alloy Steels and Tool Steels	<1400 N/mm ²										
M	Stainless Steel : Easy To Machine	<750 N/mm ²										
	Stainless Steel : Difficult To Machine	<950 N/mm ²										
K	Cast Irons, Grey, Spher., Malleable	<300 HB										
N	Aluminiums, Aluminiums Alloys	<6% Si										
S	Titanium , Titanium Alloys	<1100N/mm ²										
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm ²										
	TROCHOIDAL MILLING											
	P Steels, Alloy Steels and Tool Steels	<850 N/mm ²	2	0.1	160-200	0.061	0.079	0.095	0.108	0.122	0.135	0.164
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm ²	2	0.1	110-130	0.055	0.071	0.085	0.097	0.109	0.122	0.148
	Steels, Alloy Steels and Tool Steels	<1400 N/mm ²	2	0.1	80-100	0.049	0.063	0.076	0.086	0.097	0.108	0.131
M	Stainless Steel : Easy To Machine	<750 N/mm ²	2	0.1	110-130	0.055	0.071	0.085	0.097	0.109	0.122	0.148
	Stainless Steel : Difficult To Machine	<950 N/mm ²	1.5	0.1	80-100	0.049	0.063	0.076	0.086	0.097	0.108	0.131
K	Cast Irons, Grey, Spher., Malleable	<300 HB	2	0.1	150	0.055	0.071	0.085	0.097	0.109	0.122	0.148
N	Aluminiums, Aluminiums Alloys	<6% Si										
S	Titanium , Titanium Alloys	<1100N/mm ²	1.5	0.05	50-70	0.067	0.087	0.104	0.119	0.134	0.149	0.181
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm ²	1.5	0.05	50-70	0.067	0.087	0.104	0.119	0.134	0.149	0.181

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