



STEELS

INOX

SUPERNOX

CHIPSPLITTERS

Aluminums

ROCKSTARS

MICRO MILLS

UNIVERSAL

DRILLS

Technical Info. Page No. **142**

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	CCx45°	z	EDP No. HA		EDP No. HA		
tol.		h6	-0.2	±0.50	±0.50	±0.80	-0.05	AlCrN		GX			
3xd													
6.0	-0.025	6	5.8	18.0	26	62	0.12	4	934CCA 0600	934CCT 0600			
8.0	-0.025	8	7.6	24.0	32	68	0.12	5	935CCA 0800	935CCT 0800			
10.0	-0.035	10	9.5	30.0	40	80	0.20	5	935CCA 1000	935CCT 1000			
10.0	-0.035	10	9.5	30.0	40	80	0.20	6	936CCA 1000	936CCT 1000			
12.0	-0.035	12	11.5	36.0	48	93	0.20	5	935CCA 1200	935CCT 1200			
12.0	-0.035	12	11.5	36.0	48	93	0.20	6	936CCA 1200	936CCT 1200			
16.0	-0.035	16	15.5	48.0	64	108	0.20	5	935CCA 1600	935CCT 1600			
16.0	-0.035	16	15.5	48.0	64	108	0.20	7	937CCA 1600	937CCT 1600			
20.0	-0.035	20	19.5	60.0	80	126	0.30	5	935CCA 2000	935CCT 2000			
20.0	-0.035	20	19.5	60.0	80	126	0.30	7	937CCA 2000	937CCT 2000			
4xd													
6.0	-0.025	6	5.8	24.0	32	68	0.12	4	944CCA 0600	944CCT 0600			
8.0	-0.025	8	7.6	32.0	44	80	0.12	5	945CCA 0800	945CCT 0800			
10.0	-0.035	10	9.5	40.0	55	95	0.20	5	945CCA 1000	945CCT 1000			
10.0	-0.035	10	9.5	40.0	55	95	0.20	6	946CCA 1000	946CCT 1000			
12.0	-0.035	12	11.5	48.0	62	107	0.20	5	945CCA 1200	945CCT 1200			
12.0	-0.035	12	11.5	48.0	62	107	0.20	6	946CCA 1201	946CCT 1201			
16.0	-0.035	16	15.5	64.0	80	128	0.20	5	945CCA 1600	945CCT 1600			
16.0	-0.035	16	15.5	64.0	80	128	0.20	7	947CCA 1600	947CCT 1600			
20.0	-0.035	20	19.5	80.0	100	150	0.30	5	945CCA 2000	945CCT 2000			
20.0	-0.035	20	19.5	80.0	100	150	0.30	7	947CCA 2000	947CCT 2000			
5xd													
10.0	-0.035	10	9.5	50.0	65	105	0.20	5	955CCA 1000	955CCT 1000			
12.0	-0.035	12	11.5	60.0	73	118	0.20	5	955CCA 1200	955CCT 1200			
16.0	-0.035	16	15.5	80.0	94	142	0.20	5	955CCA 1600	955CCT 1600			
20.0	-0.035	20	19.5	100.0	113	163	0.30	5	955CCA 2000	955CCT 2000			

HB Weldon Shank available on request. Order Code for AlCrN Coated : 935CWA | Order Code for GX Coated: 935CWT

	MATERIAL		Hardness		ap max ae max		Vc	6	8	fz (mm/z) Ø	10	12	16	20
	TROCHOIDAL MILLING [3xD] 934-H, 935-H		xD	xD										
	P	Steels, Alloy Steels and Tool Steels	<850 N/mm²	3	0.03-0.14	240-400	0.038-0.081	0.050-0.108	0.070-0.150	0.083-0.177	0.101-0.216	0.126-0.270		
		Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	3	0.03-0.14	210-350	0.038-0.081	0.050-0.108	0.063-0.135	0.070-0.150	0.076-0.162	0.101-0.216		
		Steels, Alloy Steels and Tool Steels	<1400 N/mm²	3	0.03-0.14	240-400	0.032-0.069	0.045-0.146	0.063-0.135	0.076-0.162	0.088-0.189	0.113-0.243		
	M	Stainless Steel : Easy To Machine	<750 N/mm²	3	0.03-0.14	165-275	0.038-0.081	0.050-0.108	0.063-0.135	0.076-0.162	0.088-0.189	0.101-0.216		
		Stainless Steel : Difficult To Machine	<950 N/mm²	3	0.03-0.14	120-200	0.038-0.081	0.050-0.108	0.063-0.135	0.078-0.168	0.088-0.189	0.101-0.216		
	K	Cast Irons, Grey, Spher., Melleable	<300 HB	3	0.03-0.14	210-350	0.038-0.081	0.050-0.108	0.063-0.135	0.070-0.150	0.076-0.162	0.101-0.216		
	N	Aluminiums, Aluminiums Alloys	<6% Si											
	S	Titanium , Titanium Alloys	<1100N/mm²	3	0.03-0.14	90-150	0.038-0.081	0.050-0.108	0.063-0.135	0.076-0.162	0.088-0.189	0.113-0.243		
	S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²	3	0.03-0.14	98-163	0.038-0.081	0.050-0.108	0.063-0.135	0.076-0.162	0.083-0.177	0.101-0.216		
	TROCHOIDAL MILLING [3xD] 945-H													
	P	Steels, Alloy Steels and Tool Steels	<850 N/mm²	4	0.03-0.14	182-396	0.045-0.090	0.063-0.126	0.078-0.157	0.095-0.190	0.113-0.227	0.139-0.284		
		Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	4	0.03-0.14	154-336	0.038-0.076	0.050-0.101	0.063-0.126	0.070-0.140	0.076-0.151	0.101-0.205		
		Steels, Alloy Steels and Tool Steels	<1400 N/mm²	4	0.03-0.14	176-384	0.032-0.064	0.045-0.090	0.063-0.126	0.076-0.151	0.088-0.176	0.113-0.231		
	M	Stainless Steel : Easy To Machine	<750 N/mm²	4	0.03-0.14	105-228	0.038-0.076	0.050-0.101	0.063-0.126	0.076-0.151	0.088-0.176	0.101-0.205		
		Stainless Steel : Difficult To Machine	<950 N/mm²	4	0.03-0.14	88-192	0.038-0.076	0.050-0.101	0.063-0.126	0.078-0.157	0.088-0.176	0.101-0.205		
	K	Cast Irons, Grey, Spher., Melleable	<300 HB	4	0.03-0.14	154-336	0.038-0.076	0.050-0.101	0.063-0.126	0.070-0.140	0.076-0.151	0.101-0.205		
	N	Aluminiums, Aluminiums Alloys	<6% Si											
	S	Titanium , Titanium Alloys	<1100N/mm²	4	0.03-0.14	66-144	0.038-0.076	0.050-0.101	0.063-0.126	0.076-0.151	0.088-0.176	0.113-0.231		
	S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²	4	0.03-0.14	72-156	0.032-0.064	0.045-0.090	0.057-0.115	0.063-0.126	0.083-0.165	0.101-0.205		
	TROCHOIDAL MILLING [3xD] 955-H													
	P	Steels, Alloy Steels and Tool Steels	<850 N/mm²	5	0.03-0.14	182-396	0.045-0.090	0.063-0.126	0.078-0.157	0.095-0.190	0.113-0.227	0.139-0.284		
		Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	5	0.03-0.14	154-336	0.038-0.076	0.050-0.101	0.063-0.126	0.070-0.140	0.076-0.151	0.101-0.205		
		Steels, Alloy Steels and Tool Steels	<1400 N/mm²	5	0.03-0.14	176-384	0.032-0.064	0.045-0.090	0.063-0.126	0.076-0.151	0.088-0.176	0.113-0.231		
	M	Stainless Steel : Easy To Machine	<750 N/mm²	5	0.03-0.14	105-228	0.038-0.076	0.050-0.101	0.063-0.126	0.076-0.151	0.088-0.176	0.101-0.205		
		Stainless Steel : Difficult To Machine	<950 N/mm²	5	0.03-0.14	88-192	0.038-0.076	0.050-0.101	0.063-0.126	0.078-0.157	0.088-0.176	0.101-0.205		
	K	Cast Irons, Grey, Spher., Melleable	<300 HB	5	0.03-0.14	154-336	0.038-0.076	0.050-0.101	0.063-0.126	0.070-0.140	0.076-0.151	0.101-0.205		
	N	Aluminiums, Aluminiums Alloys	<6% Si											
	S	Titanium , Titanium Alloys	<1100N/mm²	5	0.03-0.14	66-144	0.038-0.076	0.050-0.101	0.063-0.126	0.076-0.151	0.088-0.176	0.113-0.231		
	S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²	5	0.03-0.14	72-156	0.032-0.064	0.045-0.090	0.057-0.115	0.063-0.126	0.083-0.165	0.101-0.205		