



Technical Info. Page No. 132

Steels <35HRC	Stainless Steels <1100 N/mm ²	Cast Irons <300 HB	Hardened Steels -	Titaniums -	Super Alloys -	Aluminiums -
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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		AlCrN	AlCrN
1.0	-0.010	6	0.8	2.5	5	57	0.07	4	EMCA 0900M 0100	EMCA 0901M 0100
2.0	-0.020	6	1.8	5.0	10	57	0.10	4	EMCA 0900M 0200	EMCA 0901M 0200
3.0	-0.025	6	2.8	8.0	15	57	0.10	4	EMCA 0900M 0300	EMCA 0901M 0300
4.0	-0.025	6	3.8	11.0	17	57	0.15	4	EMCA 0900M 0400	EMCA 0901M 0400
5.0	-0.025	6	4.8	13.0	19	57	0.15	4	EMCA 0900M 0500	EMCA 0901M 0500
6.0	-0.025	6	5.8	13.0	21	57	0.20	4	EMCA 0900M 0600	EMCA 0901M 0600
8.0	-0.025	8	7.6	19.0	27	63	0.20	4	EMCA 0900M 0800	EMCA 0901M 0800
10.0	-0.035	10	9.5	22.0	32	72	0.30	4	EMCA 0900M 1000	EMCA 0901M 1000
12.0	-0.035	12	11.5	26.0	38	83	0.35	4	EMCA 0900M 1200	EMCA 0901M 1200
14.0	-0.035	14	13.5	26.0	38	83	0.35	4	EMCA 0900M 1400	EMCA 0901M 1400
16.0	-0.035	16	15.5	32.0	44	92	0.40	4	EMCA 0900M 1600	EMCA 0901M 1600
18.0	-0.035	18	17.5	32.0	44	92	0.40	4	EMCA 0900M 1800	EMCA 0901M 1800
20.0	-0.035	20	19.5	38.0	54	104	0.50	4	EMCA 0900M 2000	EMCA 0901M 2000
25.0	-0.035	25	24.5	45.0	65	121	0.60	4	EMCA 0900M 2500	EMCA 0901M 2500

STEELS

INOX

SUPERNOX

CHIPSPLITTERS

Aluminiums

ROCKSTARS

MICRO MILLS

UNIVERSAL

DRILLS

MATERIAL			ap max xD	ae max xD	Vc (m/min)	fz (mm/z) Ø										
SLOTTING		3				4	5	6	8	10	12	16	18	20		
	P	Steels, Alloy Steels and Tool Steels	<850 N/mm²	1	1	130-150	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.100
		Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	1	1	90-110	0.110	0.015	0.019	0.022	0.028	0.034	0.039	0.044	0.049	0.059
		Steels, Alloy Steels and Tool Steels	<1400 N/mm²	≤ 1	1	90-110	0.011	0.014	0.018	0.021	0.028	0.035	0.042	0.049	0.056	0.070
	M	Stainless Steel : Easy To Machine	<750 N/mm²	1	1	70-90	0.110	0.015	0.019	0.022	0.028	0.034	0.039	0.044	0.049	0.059
		Stainless Steel : Difficult To Machine	<950 N/mm²	0.5	1	50-70	0.009	0.012	0.012	0.017	0.022	0.026	0.030	0.034	0.038	0.046
	K	Cast Irons, Grey, Spher., Melleable	<300 HB	1	1	90-130	0.110	0.015	0.019	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/mm²	0.5	1	30-50	0.009	0.012	0.012	0.017	0.022	0.026	0.030	0.034	0.038	0.046
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²														
SIDE MILLING																
	P	Steels, Alloy Steels and Tool Steels	<850 N/mm²	1	0.3	150-180	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.100
		Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	1	0.3	120-150	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.056	0.064	0.080
		Steels, Alloy Steels and Tool Steels	<1400 N/mm²													
	M	Stainless Steel : Easy To Machine	<750 N/mm²	1.5	0.5	90-110	0.014	0.018	0.022	0.026	0.034	0.041	0.047	0.052	0.058	0.071
		Stainless Steel : Difficult To Machine	<950 N/mm²	1.2	0.3	60-80	0.012	0.016	0.020	0.023	0.030	0.036	0.041	0.047	0.052	0.063
	K	Cast Irons, Grey, Spher., Melleable	<300 HB	1	0.3	120-150	0.014	0.018	0.022	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/mm²	1	0.3	40-50	0.017	0.022	0.027	0.032	0.042	0.050	0.057	0.064	0.064	0.078
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²														
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	5°	0.3	130	0.010	0.012	0.015	0.018	0.024	0.030	0.032	0.035	0.040	0.048
		Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	4°	0.3	90	0.009	0.011	0.014	0.016	0.021	0.026	0.029	0.033	0.037	0.045
		Steels, Alloy Steels and Tool Steels	<1400 N/mm²													
	M	Stainless Steel : Easy To Machine	<750 N/mm²	4°	0.4	90	0.009	0.011	0.014	0.016	0.021	0.026	0.029	0.033	0.037	0.045
		Stainless Steel : Difficult To Machine	<950 N/mm²	3°	0.4	70	0.008	0.010	0.012	0.015	0.019	0.023	0.026	0.029	0.036	0.039
	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	2	0.1	220				0.061	0.079	0.095	0.108	0.122	0.135	0.164
		Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	2	0.1	150				0.055	0.071	0.085	0.097	0.109	0.122	0.148
		Steels, Alloy Steels and Tool Steels	<1400 N/mm²	2	0.1	100				0.049	0.063	0.076	0.086	0.097	0.108	0.131
	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	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/mm²	1.5	0.1	70				0.067	0.087	0.104	0.119	0.134	0.149	0.181
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