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Steels <35HRC		Stainless Steels <1100 N/mm²		Cast Irons <300 HB		Hardened Steels -		Titaniums -		Super Alloys -		Aluminiums -	
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		
4.0	-0.025	6	3.8	11.0	17	57	0.15	4	EMCA 1100M 0400		EMCA 1101M 0400		
5.0	-0.025	6	4.8	13.0	19	57	0.15	4	EMCA 1100M 0500		EMCA 1101M 0500		
6.0	-0.025	6	5.8	13.0	21	57	0.20	4	EMCA 1100M 0600		EMCA 1101M 0600		
8.0	-0.025	8	7.6	19.0	27	63	0.20	4	EMCA 1100M 0800		EMCA 1101M 0800		
10.0	-0.035	10	9.5	22.0	32	72	0.30	4	EMCA 1100M 1000		EMCA 1101M 1000		
12.0	-0.035	12	11.5	26.0	38	83	0.35	4	EMCA 1100M 1200		EMCA 1101M 1200		
14.0	-0.035	14	13.5	26.0	38	83	0.35	4	EMCA 1100M 1400		EMCA 1101M 1400		
16.0	-0.035	16	15.5	32.0	44	92	0.40	4	EMCA 1100M 1600		EMCA 1101M 1600		
18.0	-0.035	18	17.5	32.0	44	92	0.40	4	EMCA 1100M 1800		EMCA 1101M 1800		
20.0	-0.035	20	19.5	38.0	54	104	0.50	4	EMCA 1100M 2000		EMCA 1101M 2000		
25.0	-0.035	25	24.5	45.0	65	121	0.60	4	EMCA 1100M 2500		EMCA 1101M 2500		

STEELS

INOX

SUPRINOX

CHIPSPLITTERS

Aluminiums

ROCKSTARS

MICRO MILLS

UNIVERSAL

DRILLS

	MATERIAL		Hardness	ap max xD	ae max xD	Vc (m/min)	fz (mm/z) Ø							
	SLOTING						4	5	6	8	10	12	16	20
	P	Steels, Alloy Steels and Tool Steels	<850 N/mm ²	1	1	130	0.014	0.018	0.026	0.034	0.041	0.047	0.058	0.071
		Steels, Alloy Steels and Tool Steels	850-1200 N/mm ²	1	1	90	0.013	0.016	0.024	0.031	0.037	0.042	0.052	0.064
		Steels, Alloy Steels and Tool Steels	<1400 N/mm ²	1	1	70	0.010	0.013	0.020	0.026	0.031	0.035	0.044	0.053
	M	Stainless Steel : Easy To Machine	<750 N/mm ²	1	1	90	0.013	0.016	0.024	0.031	0.037	0.042	0.052	0.064
		Stainless Steel : Difficult To Machine	<950 N/mm ²	0.5	1	70	0.010	0.013	0.020	0.026	0.031	0.035	0.044	0.053
	K	Cast Irons, Grey, Spher., Malleable	<300 HB	1	1	90	0.013	0.016	0.024	0.031	0.037	0.042	0.052	0.064
	N	Aluminiums, Aluminiums Alloys	<6% Si											
	S	Titanium , Titanium Alloys	<1100N/mm ²	0.5	1	50	0.012	0.015	0.018	0.024	0.029	0.033	0.041	0.050
	S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm ²											
SIDE MILLING														
	P	Steels, Alloy Steels and Tool Steels	<850 N/mm ²	1.5	0.5	150	0.020	0.025	0.031	0.041	0.049	0.056	0.070	0.085
		Steels, Alloy Steels and Tool Steels	850-1200 N/mm ²	1.5	0.5	110	0.020	0.025	0.028	0.037	0.044	0.050	0.063	0.077
		Steels, Alloy Steels and Tool Steels	<1400 N/mm ²	1.2	0.3	80	0.016	0.020	0.025	0.033	0.039	0.045	0.056	0.068
	M	Stainless Steel : Easy To Machine	<750 N/mm ²	1.5	0.5	110	0.020	0.025	0.028	0.037	0.044	0.050	0.063	0.077
		Stainless Steel : Difficult To Machine	<950 N/mm ²	1.2	0.3	80	0.016	0.020	0.025	0.033	0.039	0.045	0.056	0.068
	K	Cast Irons, Grey, Spher., Malleable	<300 HB	1.5	0.5	110	0.020	0.025	0.028	0.037	0.044	0.050	0.063	0.077
	N	Aluminiums, Aluminiums Alloys	<6% Si											
	S	Titanium , Titanium Alloys	<1100N/mm ²											
	S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm ²	1.2	0.3	40	0.024	0.030	0.035	0.045	0.054	0.062	0.077	0.094
RAMPING														
	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											
HELICAL MILLING														
	P	Steels, Alloy Steels and Tool Steels	<850 N/mm ²	7°	0.4	130	0.012	0.015	0.018	0.024	0.029	0.033	0.041	0.050
		Steels, Alloy Steels and Tool Steels	850-1200 N/mm ²	5°	0.4	90	0.011	0.014	0.017	0.022	0.027	0.031	0.038	0.046
		Steels, Alloy Steels and Tool Steels	<1400 N/mm ²	3°	0.4	70	0.010	0.013	0.016	0.020	0.025	0.028	0.035	0.043
	M	Stainless Steel : Easy To Machine	<750 N/mm ²	5°	0.4	90	0.011	0.014	0.017	0.022	0.027	0.031	0.038	0.046
		Stainless Steel : Difficult To Machine	<950 N/mm ²	3°	0.4	70	0.010	0.013	0.016	0.020	0.025	0.028	0.035	0.043
	K	Cast Irons, Grey, Spher., Malleable	<300 HB	5°	0.4	70	0.011	0.014	0.017	0.022	0.027	0.031	0.038	0.046
	N	Aluminiums, Aluminiums Alloys	<6% Si											
	S	Titanium , Titanium Alloys	<1100N/mm ²											
	S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm ²	3°	0.4	40	0.010	0.013	0.015	0.019	0.023	0.026	0.033	0.400
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	200	0.044	0.055	0.066	0.085	0.102	0.117	0.146	0.177
		Steels, Alloy Steels and Tool Steels	850-1200 N/mm ²	2	0.1	130	0.039	0.049	0.059	0.077	0.092	0.105	0.131	0.160
		Steels, Alloy Steels and Tool Steels	<1400 N/mm ²	1.5	0.05	100	0.036	0.045	0.052	0.068	0.082	0.093	0.117	0.142
	M	Stainless Steel : Easy To Machine	<750 N/mm ²	2	0.1	130	0.039	0.049	0.059	0.077	0.092	0.105	0.131	0.160
		Stainless Steel : Difficult To Machine	<950 N/mm ²	1.5	0.05	100	0.036	0.045	0.052	0.068	0.082	0.093	0.117	0.142
	K	Cast Irons, Grey, Spher., Malleable	<300 HB	2	0.1	130	0.039	0.049	0.059	0.077	0.092	0.105	0.131	0.160
	N	Aluminiums, Aluminiums Alloys	<6% Si											
	S	Titanium , Titanium Alloys	<1100N/mm ²											
	S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm ²	1.5	0.05	60	0.048	0.060	0.072	0.094	0.112	0.128	0.016	0.195

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