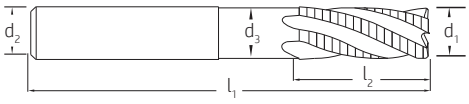

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Steels	Stainless Steels	Cast Irons	Hardened Steels	Titaniums	Super Alloys	Aluminiums
<45 HRC	<900 N/mm²	<300 HB	-	<900 N/mm²	<900 N/mm²	-

d_1	d_1	d_2	d_3	l_2	l_3	l_1	CCx45°	z	EDP No. HA	EDP No. HB
	tol.	*h6*	*-0.1*	*±0.50*	*±0.50*	*±0.80*	*-0.05*		AlCrN	AlCrN
3.0	-0.025	6	2.8	8.0	15	57	0.10	3	EMCA 7800M 0300	EMCA 7801M 0300
4.0	-0.025	6	3.8	11.0	17	57	0.15	4	EMCA 7800M 0400	EMCA 7801M 0400
5.0	-0.025	6	4.8	13.0	19	57	0.15	4	EMCA 7800M 0500	EMCA 7801M 0500
6.0	-0.025	6	5.8	13.0	21	57	0.20	4	EMCA 7800M 0600	EMCA 7801M 0600
8.0	-0.025	8	7.6	19.0	27	63	0.20	4	EMCA 7800M 0800	EMCA 7801M 0800
10.0	-0.035	10	9.5	22.0	32	72	0.30	4	EMCA 7800M 1000	EMCA 7801M 1000
12.0	-0.035	12	11.5	26.0	38	83	0.35	4	EMCA 7800M 1200	EMCA 7801M 1200
16.0	-0.035	16	15.5	32.0	44	92	040	5	EMCA 7800M 1600	EMCA 7801M 1600
20.0	-0.035	20	19.5	38.0	54	104	0.50	6	EMCA 7800M 2000	EMCA 7801M 2000
25.0	-0.035	25	24.5	45.0	65	121	0.60	8	EMCA 7800M 2500	EMCA 7801M 2500

	MATERIAL	Hardness	ap max xD	ae max xD	Vc (m/min)	fz (mm/z) Ø 3	4	5	6	8	10	12	16	20
	SLOTTING													
P	Steels, Alloy Steels and Tool Steels	<850 N/mm²	0.5	1	80-100	0.015	0.020	0.025	0.030	0.045	0.055	0.065	0.082	0.100
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	0.5	1	50-70	0.012	0.016	0.020	0.026	0.038	0.047	0.055	0.072	0.085
	Steels, Alloy Steels and Tool Steels	<1400 N/mm²	0.5	1	30-50	0.011	0.015	0.019	0.023	0.034	0.041	0.049	0.064	0.075
M	Stainless Steel : Easy To Machine	<750 N/mm²	0.5	1	50-70	0.012	0.016	0.020	0.026	0.038	0.047	0.055	0.072	0.085
	Stainless Steel : Difficult To Machine	<950 N/mm²	0.5	1	30-50	0.011	0.015	0.019	0.023	0.034	0.041	0.049	0.064	0.075
K	Cast Irons, Grey, Spher., Melleable	<300 HB	0.5	1	50-70	0.012	0.016	0.020	0.026	0.038	0.047	0.055	0.072	0.085
N	Aluminiums, Aluminiums Alloys	<6% Si												
S	Titanium , Titanium Alloys	<1100N/mm²												
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²												
	SIDE MILLING													
P	Steels, Alloy Steels and Tool Steels	<850 N/mm²	1.5	0.3	80-100	0.021	0.028	0.035	0.040	0.055	0.065	0.080	0.100	0.120
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	1.5	0.3	50-70	0.018	0.024	0.030	0.034	0.047	0.055	0.068	0.085	0.102
	Steels, Alloy Steels and Tool Steels	<1400 N/mm²	1.2	0.3	30-50	0.015	0.020	0.025	0.030	0.041	0.049	0.065	0.075	0.090
M	Stainless Steel : Easy To Machine	<750 N/mm²	1.5	0.3	50-70	0.018	0.024	0.030	0.034	0.047	0.055	0.068	0.085	0.102
	Stainless Steel : Difficult To Machine	<950 N/mm²	1.2	0.3	30-50	0.015	0.020	0.025	0.030	0.041	0.049	0.065	0.075	0.090
K	Cast Irons, Grey, Spher., Melleable	<300 HB	1.5	0.3	50-70	0.018	0.024	0.030	0.034	0.047	0.055	0.068	0.085	0.102
N	Aluminiums, Aluminiums Alloys	<6% Si												
S	Titanium , Titanium Alloys	<1100N/mm²												
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												
	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