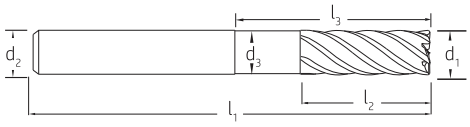

Technical Info. Page No. ***134***

Steels	Stainless Steels	Cast Irons	Hardened Steels	Titaniums	Super Alloys	Aluminiums
<30HRC	<900 N/mm²	<200 HB	-	-	-	-

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	6	EMCA 0700M 0400	EMCA 0701M 0400
5.0	-0.025	6	4.8	13.0	19	57	0.15	6	EMCA 0700M 0500	EMCA 0701M 0500
6.0	-0.025	6	5.8	13.0	21	57	0.20	6	EMCA 0700M 0600	EMCA 0701M 0600
8.0	-0.025	8	7.6	19.0	27	63	0.20	6	EMCA 0700M 0800	EMCA 0701M 0800
10.0	-0.035	10	9.5	22.0	32	72	0.30	6	EMCA 0700M 1000	EMCA 0701M 1000
12.0	-0.035	12	11.5	26.0	38	83	0.35	6	EMCA 0700M 1200	EMCA 0701M 1200
14.0	-0.035	14	13.5	26.0	38	83	0.35	6	EMCA 0700M 1400	EMCA 0701M 1400
16.0	-0.035	16	15.5	32.0	44	92	040	6	EMCA 0700M 1600	EMCA 0701M 1600
18.0	-0.035	18	17.5	32.0	44	92	040	6	EMCA 0700M 1800	EMCA 0701M 1800
20.0	-0.035	20	19.5	38.0	54	104	0.50	6	EMCA 0700M 2000	EMCA 0701M 2000
25.0	-0.035	25	24.5	45.0	65	121	0.60	6	EMCA 0700M 2500	EMCA 0701M 2500
6.0	-0.025	6		40.0		80	0.20	6	EMCA 0700X 0600	EMCA 0701X 0600
8.0	-0.025	8		50.0		100	0.20	6	EMCA 0700X 0800	EMCA 0701X 0800
10.0	-0.035	10		50.0		100	0.30	6	EMCA 0700X 1000	EMCA 0701X 1000
12.0	-0.035	12		80.0		150	0.35	6	EMCA 0700X 1200	EMCA 0701X 1200
16.0	-0.035	16		80.0		150	040	6	EMCA 0700X 1600	EMCA 0701X 1600
20.0	-0.035	20		80.0		150	0.50	6	EMCA 0700X 2000	EMCA 0701X 2000

	MATERIAL	Hardness	ap max xD	ae max xD	Vc (m/min)	fz (mm/z) Ø 6	8	10	12	14	20
	SLOTTING										
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									
	SIDE MILLING										
P	Steels, Alloy Steels and Tool Steels	<850 N/mm²	<2	<0.05	176-263	0.048	0.081	0.101	0.121	0.142	0.158
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	<2	<0.05	119-179	0.036	0.061	0.077	0.092	0.107	0.119
	Steels, Alloy Steels and Tool Steels	<1400 N/mm²									
M	Stainless Steel : Easy To Machine	<750 N/mm²	<2	<0.05	96-117	0.029	0.049	0.061	0.073	0.086	0.096
	Stainless Steel : Difficult To Machine	<950 N/mm²	<2	<0.05	89-109	0.029	0.049	0.061	0.073	0.086	0.096
K	Cast Irons, Grey, Spher., Melleable	<300 HB									
N	Aluminiums, Aluminiums Alloys	<6% Si									
S	Titanium , Titanium Alloys	<1100N/mm²	<2	<0.05	68-102	0.023	0.033	0.049	0.059	0.068	0.077
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