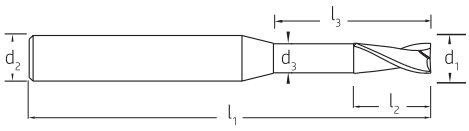

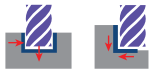

Technical Info. Page No. ***145***

Steels	Stainless Steels	Cast Irons	Hardened Steels	Titaniums	Super Alloys	Aluminiums
<50HRC	-	<390 HB	-	-	-	-

d_1	d_1	d_2	d_3	l_2	l_3	l_1	z	EDP No. HA	EDP No. HB
	tol.	*h6*	*-0.2*	*±0.50*	*±0.50*	*±0.80*		AlCrN	AlCrN
0.80	-0.020	4	0.75	1.20	06	45	2	EMSA 586 0080 04045 06	-
0.80	-0.020	4	0.75	1.50	08	45	2	EMSA 586 0080 04045 08	-
1.00	-0.020	4	0.97	1.50	06	45	2	EMSA 586 0100 04045 06	-
1.00	-0.020	4	0.95	1.50	08	45	2	EMSA 586 0100 04045 08	-
1.00	-0.020	4	0.95	1.50	10	45	2	EMSA 586 0100 04045 10	-
1.20	-0.020	4	1.15	1.80	08	45	2	EMSA 586 0120 04045 08	-
1.20	-0.020	4	0.93	1.80	12	45	2	EMSA 586 0120 04045 12	-
140	-0.020	4	1.13	2.10	12	45	2	EMSA 586 0140 04045 12	-
1.50	-0.020	4	1.33	2.30	06	45	2	EMSA 586 0150 04045 06	-
1.50	-0.020	4	145	2.30	08	45	2	EMSA 586 0150 04045 08	-
1.50	-0.020	4	145	2.30	10	45	2	EMSA 586 0150 04045 10	-
1.50	-0.020	4	143	2.30	12	45	2	EMSA 586 0150 04045 12	-
1.60	-0.020	4	141	240	16	45	2	EMSA 586 0160 04045 16	-
1.80	-0.020	4	1.53	2.70	12	45	2	EMSA 586 0180 04045 12	-
2.00	-0.020	4	1.93	3.00	12	50	2	EMSA 586 0200 04050 12	-
2.00	-0.020	4	1.93	3.00	16	50	2	EMSA 586 0200 04050 16	-
2.50	-0.020	4	240	3.70	12	45	2	EMSA 586 0250 0404512	-
2.50	-0.020	4	240	3.70	16	55	2	EMSA 586 0250 04055 16	-
3.00	-0.020	6	2.85	4.50	14	50	2	EMSA 586 0300 06055 14	EMSA 587 0300 06055 14
3.00	-0.020	6	240	4.50	16	55	2	EMSA 586 0300 06050 16	EMSA 587 0300 06050 16
3.00	-0.020	6	2.85	4.50	18	55	2	EMSA 586 0300 06055 18	EMSA 587 0300 06055 18

	MATERIAL	Hardness	ap max xD	ae max xD	Vc (m/min)	fz (mm/z) Ø 0.8	1.0	1.2	1.4	1.5	1.6	1.8	2.0	2.5	3.0
	SLOTTING EMS 586														
P	Steels, Alloy Steels and Tool Steels	<850 N/mm²	0.06	1	78-85	0.0070	0.010	0.014	0.016	0.017	0.018	0.019	0.021	0.023	0.031
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	0.06	1	55-60	0.0060	0.009	0.012	0.015	0.016	0.017	0.018	0.020	0.022	0.030
	Steels, Alloy Steels and Tool Steels	<1400 N/mm²	0.01	1	34-37	0.0030	0.004	0.005	0.006	0.007	0.007	0.008	0.008	0.010	0.012
M	Stainless Steel : Easy To Machine	<750 N/mm²													
	Stainless Steel : Difficult To Machine	<950 N/mm²	0.06	1	55-60	0.0060	0.009	0.012	0.015	0.016	0.017	0.018	0.020	0.022	0.030
K	Cast Irons, Grey, Spher., Melleable	<300 HB	0.06	1	78-85	0.0070	0.010	0.014	0.016	0.017	0.018	0.019	0.021	0.023	0.031
N	Aluminiums, Aluminiums Alloys	<6% Si													
S	Titanium , Titanium Alloys	<1100N/mm²													
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²	0.01	1	34-37	0.0030	0.004	0.005	0.006	0.007	0.007	0.008	0.008	0.010	0.012
	SIDE MILLING EMB 586														
P	Steels, Alloy Steels and Tool Steels	<850 N/mm²	0.06	1	66-122	0.0060	0.007	0.009	0.009	0.011	0.012	0.012	0.014	0.021	0.025
	Steels, Alloy Steels and Tool Steels	850-1200 N/mm²	0.06	1	55-60	0.0040	0.005	0.006	0.007	0.008	0.009	0.009	0.010	0.014	0.018
	Steels, Alloy Steels and Tool Steels	<1400 N/mm²	0.01	1	30-55	0.0050	0.006	0.007	0.009	0.009	0.010	0.010	0.011	0.012	0.018
M	Stainless Steel : Easy To Machine	<750 N/mm²													
	Stainless Steel : Difficult To Machine	<950 N/mm²	0.06	1	55-60	0.0040	0.005	0.006	0.007	0.008	0.009	0.009	0.010	0.014	0.018
K	Cast Irons, Grey, Spher., Melleable	<300 HB	0.06	1	66-122	0.0060	0.007	0.009	0.009	0.011	0.012	0.012	0.014	0.021	0.025
N	Aluminiums, Aluminiums Alloys	<6% Si													
S	Titanium , Titanium Alloys	<1100N/mm²													
S	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm²	0.01	1	30-55	0.0050	0.006	0.007	0.009	0.009	0.010	0.010	0.011	0.012	0.018

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