



Technical Info. Page No. **145**

Steels <50 HRC	Stainless Steels -	Cast Irons <390 HB	Hardened Steels -	Titaniums -	Super Alloys -	Aluminiums -
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d <sub>1</sub>	d <sub>1</sub>	d <sub>2</sub>	d <sub>3</sub>	l <sub>2</sub>	l <sub>3</sub>	l <sub>1</sub>	z	EDP No.	
								HA	HB
	tol.	h6	-0.2	±0.50	±0.50	±0.80		AlCrN	AlCrN
0.60	-0.020	4	0.55	0.90	06	35	2	EMBA 586 0060 03035 06	-
0.80	-0.020	4	0.75	1.20	06	45	2	EMBA 586 0080 04045 06	-
0.80	-0.020	4	0.75	1.20	08	45	2	EMBA 586 0080 04045 08	-
1.00	-0.020	4	0.97	1.50	06	45	2	EMBA 586 0100 04045 06	-
1.00	-0.020	4	0.95	1.50	08	45	2	EMBA 586 0100 04045 08	-
1.00	-0.020	4	0.93	1.50	12	45	2	EMBA 586 0100 04045 12	-
1.20	-0.020	4	1.15	1.80	08	45	2	EMBA 586 0120 04045 08	-
1.20	-0.020	4	1.13	1.80	12	45	2	EMBA 586 0120 04045 12	-
1.40	-0.020	4	1.33	2.10	12	45	2	EMBA 586 0140 04045 12	-
1.50	-0.020	4	1.45	2.30	08	45	2	EMBA 586 0150 04045 08	-
1.50	-0.020	4	1.43	2.30	12	45	2	EMBA 586 0150 04045 12	-
1.50	-0.020	4	1.41	2.30	16	50	2	EMBA 586 0150 04050 16	-
1.60	-0.020	4	1.51	2.40	16	50	2	EMBA 586 0160 04050 16	-
1.80	-0.020	4	1.71	2.70	16	50	2	EMBA 586 0180 04050 16	-
2.00	-0.020	4	1.95	3.00	08	45	2	EMBA 586 0200 04045 08	-
2.00	-0.020	4	1.95	3.00	10	45	2	EMBA 586 0200 04045 10	-
2.00	-0.020	4	1.91	3.00	16	50	2	EMBA 586 0200 04050 16	-
2.00	-0.020	4	1.89	3.00	20	55	2	EMBA 586 0200 04055 20	-
3.00	-0.020	6	2.85	4.50	16	55	2	EMBA 586 0300 06055 16	EMBA 587 0300 06055 16
3.00	-0.020	6	2.85	4.50	20	60	2	EMBA 586 0300 06060 20	EMBA 587 0300 06060 20
4.00	-0.025	6	3.85	6.00	16	60	2	EMBA 586 0400 06060 16	EMBA 587 0400 06060 16
4.00	-0.025	6	3.85	6.00	20	65	2	EMBA 586 0400 06065 20	EMBA 587 0400 06065 20

STEELS

INOX

SUPERNOX

CHIPSPLITTERS

Aluminiums

ROCKSTARS

MICRO MILLS

UNIVERSAL

DRILLS

MATERIAL		Hardness	ap max	ae max	Vc	fz (mm/z) Ø									
SLOTTING EMS 586			xD	xD	(m/min)	0.8	1.0	1.2	1.4	1.5	1.6	1.8	2.0	2.5	3.0
<b>P</b>	Steels, Alloy Steels and Tool Steels	<850 N/mm <sup>2</sup>	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/mm <sup>2</sup>	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/mm <sup>2</sup>	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
<b>M</b>	Stainless Steel : Easy To Machine	<750 N/mm <sup>2</sup>													
	Stainless Steel : Difficult To Machine	<950 N/mm <sup>2</sup>	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
<b>K</b>	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
<b>N</b>	Aluminiums, Aluminiums Alloys	<6% Si													
<b>S</b>	Titanium , Titanium Alloys	<1100N/mm <sup>2</sup>													
<b>S</b>	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm <sup>2</sup>	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															
<b>P</b>	Steels, Alloy Steels and Tool Steels	<850 N/mm <sup>2</sup>	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/mm <sup>2</sup>	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/mm <sup>2</sup>	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
<b>M</b>	Stainless Steel : Easy To Machine	<750 N/mm <sup>2</sup>													
	Stainless Steel : Difficult To Machine	<950 N/mm <sup>2</sup>	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
<b>K</b>	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
<b>N</b>	Aluminiums, Aluminiums Alloys	<6% Si													
<b>S</b>	Titanium , Titanium Alloys	<1100N/mm <sup>2</sup>													
<b>S</b>	HRSA (Nickel Alloys, Co. Alloys)	<1300N/mm <sup>2</sup>	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