



Technical Info. Page No. **144**

Steels	Stainless Steels	Cast Irons	Hardened Steels <65HRC	Titaniums	Super Alloys	Aluminiums
-	-	-	-	-	-	-

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>	r	z	EDP No. HA	EDP No. HA
	tol.	h6	-0.1	±0.50	±0.50	±0.80	±0.015		ALD	DX
6.0	-0.025	6		8.0		50	0.50	4	EMRD 4100S 0600 050	EMRX 4100S 0600 050
6.0	-0.025	6		8.0		50	1.00	4	EMRD 4100S 0600 100	EMRX 4100S 0600 100
8.0	-0.025	8		10.0		60	0.50	4	EMRD 4100S 0800 050	EMRX 4100S 0800 050
8.0	-0.025	8		10.0		60	1.00	4	EMRD 4100S 0800 100	EMRX 4100S 0800 100
10.0	-0.035	10		12.0		75	0.50	4	EMRD 4100S 1000 050	EMRX 4100S 1000 050
10.0	-0.035	10		12.0		75	1.00	4	EMRD 4100S 1000 100	EMRX 4100S 1000 100
12.0	-0.035	12		15.0		75	0.50	4	EMRD 4100S 1200 050	EMRX 4100S 1200 050
12.0	-0.035	12		15.0		75	1.00	4	EMRD 4100S 1200 100	EMRX 4100S 1200 100
6.0	-0.025	6		8.0		100	0.50	4	EMRD 4100L 0600 050	EMRX 4100L 0600 050
6.0	-0.025	6		8.0		100	1.00	4	EMRD 4100L 0600 100	EMRX 4100L 0600 100
8.0	-0.025	8		10.0		100	0.50	4	EMRD 4100L 0800 050	EMRX 4100L 0800 050
8.0	-0.025	8		10.0		100	1.00	4	EMRD 4100L 0800 100	EMRX 4100L 0800 100
10.0	-0.035	10		12.0		100	0.50	4	EMRD 4100L 1000 050	EMRX 4100L 1000 050
10.0	-0.035	10		12.0		100	1.00	4	EMRD 4100L 1000 100	EMRX 4100L 1000 100
12.0	-0.035	12		15.0		100	0.50	4	EMRD 4100L 1200 050	EMRX 4100L 1200 050
12.0	-0.035	12		15.0		100	1.00	4	EMRD 4100L 1200 100	EMRX 4100L 1200 100

HB Weldon Shank available on request. Order Code for ALD Coated : EMRD 4101 | Order Code for DX Coated: EMRX 4101

STEELS

INOX

SUPERNOX

CHIPSPLITTERS

Aluminiums

ROCKSTARS

MICRO MILLS

UNIVERSAL

DRILLS

MATERIAL		Hardness	ap max xD	ae max xD	Vc (m/min)	fz (mm/z) Ø										
COPY MILLING [EMBD 2100]						1	2	3	4	5	6	8	10	12	16	20
<b>P</b>	High tensile strength steel	35-45 HRC	0.05	0.2	140-180	0.009	0.012	0.018	0.025	0.032	0.038	0.048	0.057	0.067	0.095	0.108
<b>H</b>	Hardened steel	45-55HRC	0.05	0.2	80-100	0.007	0.010	0.014	0.020	0.026	0.030	0.038	0.045	0.054	0.076	0.086
<b>SLOTTING [EMSD 2100]</b>																
<b>P</b>	High tensile strength steel	35-45 HRC	0.2	1	30-70	0.005	0.008	0.012	0.016	0.020	0.026	0.031	0.037	0.044	0.058	0.075
<b>H</b>	Hardened steel	45-55HRC	0.1	1	20-40	0.004	0.007	0.010	0.014	0.018	0.023	0.027	0.032	0.039	0.051	0.065
<b>SIDE MILLING [EMSD 4100]</b>																
<b>P</b>	High tensile strength steel	35-45 HRC	1	0.05	40-60	0.007	0.014	0.020	0.027	0.031	0.034	0.044	0.057	0.068	0.088	0.112
<b>H</b>	Hardened steel	45-55HRC	1	0.05	20-40	0.006	0.012	0.018	0.024	0.027	0.030	0.039	0.050	0.060	0.077	0.098
<b>SIDE MILLING</b>																
<b>P</b>	High tensile strength steel	35-45 HRC	1.5	0.05	20-60		0.012	0.017	0.023	0.026	0.029	0.038	0.048	0.058	0.075	0.095
<b>H</b>	Hardened steel	45-55HRC	1.5	0.05	20-40		0.010	0.015	0.020	0.023	0.025	0.033	0.042	0.051	0.065	0.083
<b>SIDE MILLING</b>																
<b>P</b>	High tensile strength steel	35-45 HRC	1.5	0.02	60-100			0.007	0.010	0.012	0.014	0.022	0.027	0.033	0.045	0.058
<b>H</b>	Hardened steel	45-55HRC	1.5	0.02	50-70			0.006	0.008	0.010	0.013	0.019	0.024	0.029	0.039	0.051
<b>SLOTTING</b>																
<b>P</b>	High tensile strength steel	35-45 HRC	0.3	1	30-50			0.008	0.011	0.013	0.015	0.020	0.024	0.028	0.034	0.042
<b>H</b>	Hardened steel	45-55HRC	0.2	1	20-40			0.007	0.010	0.012	0.014	0.019	0.022	0.026	0.032	0.039
<b>SIDE MILLING</b>																
<b>P</b>	High tensile strength steel	35-45 HRC	1.2	0.2	40-60			0.010	0.014	0.017	0.020	0.026	0.031	0.035	0.044	0.054
<b>H</b>	Hardened steel	45-55HRC	1	0.1	30-50			0.014	0.019	0.023	0.027	0.035	0.042	0.048	0.061	0.074
<b>HELICAL MILLING</b>																
<b>P</b>	High tensile strength steel	35-45 HRC	3°	0.4	30-50			0.006	0.008	0.011	0.012	0.016	0.019	0.022	0.028	0.034
<b>H</b>	Hardened steel	45-55HRC	2°	0.4	20-40			0.007	0.009	0.011	0.013	0.017	0.020	0.023	0.029	0.035
<b>TROCHOIDAL MILLING</b>																
<b>P</b>	High tensile strength steel	35-45 HRC	1	0.1	50-70			0.021	0.029	0.034	0.041	0.054	0.064	0.073	0.092	0.112
<b>H</b>	Hardened steel	45-55HRC	1	0.1	40-60			0.029	0.040	0.048	0.057	0.074	0.088	0.101	0.126	0.154

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