

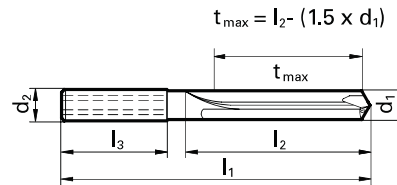


Tool material **Solid Carbide**

Surface

P	Steel	web thinning ≥ Ø 5.000 • relieved cone • negative helix • for holes with high alignment accuracy • very good surface quality of hole • observe coolant pressure
M	Stainless steel	
K	Cast iron	• aluminum and Al-alloys • Al materials with high Si-content • grey cast iron, malleable and spheroidal iron
N	Aluminum	•
S	Titanium alloys	
H	Hardened steel	

●=Optimal
○=Limited



Speeds and feeds information on pg. 526

Diameter (d1)			d2	l1	t _{max}	l2	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.1969		5.00	6.00	145.00	97.50	105.00	9007730050000
0.2362		6.00	6.00	145.00	96.00	105.00	9007730060000
0.3150		8.00	8.00	180.00	125.00	137.00	9007730080000
0.3543		9.00	10.00	217.00	156.50	170.00	9007730090000

Diameter (d1)			d2	l1	t _{max}	l2	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.3937		10.00	10.00	217.00	155.00	170.00	9007730100000
0.4331		11.00	12.00	258.00	188.50	205.00	9007730110000
0.4724		12.00	12.00	258.00	187.00	205.00	9007730120000
0.5512		14.00	14.00	290.00	215.00	236.00	9007730140000

Material group	Hardness		SFM	Feed Rate - IPR									
	HRc	Bhn		1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm	1 in. 25.400 mm	1 1/4 in. 31.750 mm	1 1/2 in. 38.100 mm
Common structural steels	- ≤ 32	≤ 150 ≤ 301											
Free-cutting steels	≤ 25 ≤ 32	≤ 255 ≤ 301											
Unalloyed heat-treatable steels	≤ 20 ≤ 25 ≤ 32	≤ 220 ≤ 255 ≤ 301											
Alloyed heat-treatable steels	≤ 32 ≤ 43	≤ 301 ≤ 402											
Unalloyed case hardened steels	≤ 25	≤ 255											
Alloyed case hardened steels	≤ 32 ≤ 43	≤ 301 ≤ 402											
Nitriding steels	≤ 32 ≤ 43	≤ 301 ≤ 402											
Tool steels	≤ 25 ≤ 43	≤ 255 ≤ 402											
High speed steels	≤ 43	≤ 402											
Spring steels	≤ 38	≤ 354											
Hardened steels	≤ 48 ≤ 66	≤ 460 -											
Stainless steels, sulphured austenitic martensitic	≤ 28 ≤ 36 ≤ 46	≤ 273 ≤ 337 ≤ 435											
Cast iron	≤ 23 ≤ 38	≤ 242 ≤ 354	395 330		0.0050 0.0050	0.0080 0.0080	0.0100 0.0100	0.0125 0.0125	0.0125 0.0125	0.0140 0.0140			
Spheroidal graphite iron and malleable cast iron	≤ 23 ≤ 38	≤ 242 ≤ 354	295 260		0.0050 0.0050	0.0080 0.0080	0.0100 0.0100	0.0125 0.0125	0.0125 0.0125	0.0140 0.0140			
Chilled cast iron	≤ 38	≤ 354	130		0.0020	0.0030	0.0040	0.0050	0.0055	0.0065			
New cast materials GGV	≤ 20 ≤ 32	≤ 220 ≤ 301											
New cast materials ADI	≤ 32 ≤ 43	≤ 301 ≤ 402											
Special alloys	≤ 54	≤ 549											
Ti and Ti-alloys	≤ 25 ≤ 43	≤ 255 ≤ 402											
Aluminium and Al-alloys	-	≤ 120	1345		0.0080	0.0125	0.0160	0.0200	0.0220	0.0245			
Al wrought alloys	-	≤ 200	1345		0.0080	0.0125	0.0160	0.0200	0.0220	0.0245			
Al cast alloys ≤ 10 % Si	-	≤ 180	1245		0.0080	0.0125	0.0160	0.0200	0.0220	0.0245			
≤ 24 % Si	-	≤ 180	1080		0.0080	0.0125	0.0160	0.0200	0.0220	0.0245			
Magnesium alloys	-	≤ 120											
Copper, low-alloyed	-	≤ 150											
Brass, short-chipping long-chipping	- -	≤ 180 ≤ 180	920		0.0050	0.0080	0.0100	0.0125	0.0125	0.0140			
Bronze, short-chipping	-	≤ 180	360		0.0040	0.0065	0.0080	0.0100	0.0100	0.0110			
Bronze, long-chipping	≤ 25 ≤ 32	≤ 255 ≤ 301	260		0.0030	0.0050	0.0065	0.0080	0.0080	0.0090			
Duroplastics Thermoplastics Reinforced plastics - Kevlar Reinforced plastics - GFK / CFK													

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