



	Carbide End Mills	Carbide End Mills TiAlN	Ball Nose End Mills TiAlN	Carbide Spot Drills - 90°
Article Number	EC11030 1/2/3	EC41013 2/4	EC 422132	DC466132
Cutting Material	Carbide	Carbide	Carbide	Carbide
Number of Cutting Edges	1,2,3	2,4	2	2
Coating	-	TiAlN	TiAlN	TiAlN
Material:	$v_c = \text{m/min}$			
Aluminium, Plastics				180
Aluminium	140	280	350	210
Cast Aluminium	105	200	250	150
Steel < 500 N/mm <sup>2</sup>	70	120	160	95
Steel < 750 N/mm <sup>2</sup>	60	105	140	80
Steel < 900 N/mm <sup>2</sup>	55	100	130	75
Steel < 1100 N/mm <sup>2</sup>	35	70	80	50
Steel < 1400 N/mm <sup>2</sup>	30	60	70	
Steel < 55 HRC		35		
Steel > 45 HRC			50	35
INOX < 900 N/mm <sup>2</sup>	40	80	80	60
INOX > 900 N/mm <sup>2</sup>	30	60	70	45
Grey Cast Iron	55	90	120	70



	Carbide Square End Mills	Roughing End Mills TiAlN	Carbide Special End Mills
Article Number	EC510154	EC444034	EC410534
Cutting Material	Carbide	Carbide	Carbide
Number of Cutting Edges	4	4	4
Coating	TiSiN	TiAlN	TiAlN
Material:	$v_c = \text{m/min}$		
Aluminium, Plastics			
Aluminium		280	280
Cast Aluminium	240	200	200
Steel < 500 N/mm <sup>2</sup>	240	120	120
Steel < 750 N/mm <sup>2</sup>	215	105	105
Steel < 900 N/mm <sup>2</sup>	195	100	100
Steel < 1100 N/mm <sup>2</sup>	180	70	70
Steel < 1400 N/mm <sup>2</sup>	160	60	60
Steel < 55 HRC			35
Steel > 45 HRC		35	
INOX < 900 N/mm <sup>2</sup>	120		80
INOX > 900 N/mm <sup>2</sup>	95	60	60
Grey Cast Iron	145	90	90