

Application



Material

Steel
850 - 1100 N/mm²

M	D1 [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	L _K [mm]	n [mm ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
M 3	2.30	0.50	3	80	0.0060	5.7	11070	47	200
M 4	3.00	0.70	3	80	0.0075	8.0	8490	48	190
M 5	4.00	0.80	3	80	0.0100	9.8	6365	38	190
M 6	4.80	1.00	3	80	0.0120	11.3	5305	38	190
M 8	6.40	1.25	3	80	0.0160	14.1	3980	38	190
M 10	7.95	1.50	4	80	0.0200	18.6	3205	52	255
M 12	9.95	1.75	4	80	0.0250	21.4	2560	44	255
M 16	12.80	2.00	4	80	0.0320	29.0	1990	51	255

Steel
1300 - 1500 N/mm²

M 3	2.30	0.50	3	50	0.0050	5.7	6920	25	105
M 4	3.00	0.70	3	50	0.0065	8.0	5305	26	105
M 5	4.00	0.80	3	50	0.0090	9.8	3980	21	105
M 6	4.80	1.00	3	50	0.0105	11.3	3315	21	105
M 8	6.40	1.25	3	50	0.0140	14.1	2485	21	105
M 10	7.95	1.50	4	50	0.0175	18.6	2000	29	140
M 12	9.95	1.75	4	50	0.0220	21.4	1600	24	140
M 16	12.80	2.00	4	50	0.0285	29.0	1245	28	140

Hardened tool steel
48 - 52 HRC

M 3	2.30	0.50	3	30	0.0040	5.7	4150	12	50
M 4	3.00	0.70	3	30	0.0050	8.0	3185	13	50
M 5	4.00	0.80	3	30	0.0065	9.8	2385	9	45
M 6	4.80	1.00	3	30	0.0080	11.3	1990	10	50
M 8	6.40	1.25	3	30	0.0105	14.1	1490	9	45
M 10	7.95	1.50	4	30	0.0135	18.6	1200	13	65
M 12	9.95	1.75	4	30	0.0165	21.4	960	11	65
M 16	12.80	2.00	4	30	0.0215	29.0	745	13	65

Stainless steel
[Cr-Ni/1.4301]

M 3	2.30	0.50	3	50	0.0040	5.7	6920	20	85
M 4	3.00	0.70	3	50	0.0050	8.0	5305	20	80
M 5	4.00	0.80	3	50	0.0065	9.8	3980	16	80
M 6	4.80	1.00	3	50	0.0080	11.3	3315	16	80
M 8	6.40	1.25	3	50	0.0105	14.1	2485	16	80
M 10	7.95	1.50	4	50	0.0135	18.6	2000	23	110
M 12	9.95	1.75	4	50	0.0165	21.4	1600	18	105
M 16	12.80	2.00	4	50	0.0215	29.0	1245	21	105

Material

Cast iron
GG(G)

M	D1 [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	L _K [mm]	n [mm ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
M 3	2.30	0.50	3	120	0.0060	5.7	16610	70	300
M 4	3.00	0.70	3	120	0.0075	8.0	12735	71	285
M 5	4.00	0.80	3	120	0.0100	9.8	9550	57	285
M 6	4.80	1.00	3	120	0.0120	11.3	7960	57	285
M 8	6.40	1.25	3	120	0.0160	14.1	5970	57	285
M 10	7.95	1.50	4	120	0.0200	18.6	4805	79	385
M 12	9.95	1.75	4	120	0.0250	21.4	3840	66	385
M 16	12.80	2.00	4	120	0.0320	29.0	2985	76	380

Wrought aluminium
alloys Si < 6%

M 3	2.30	0.50	3	150	0.0080	5.7	20760	117	500
M 4	3.00	0.70	3	150	0.0105	8.0	15915	125	500
M 5	4.00	0.80	3	150	0.0140	9.8	11935	100	500
M 6	4.80	1.00	3	150	0.0170	11.3	9945	101	505
M 8	6.40	1.25	3	150	0.0225	14.1	7460	101	505
M 10	7.95	1.50	4	150	0.0280	18.6	6005	138	675
M 12	9.95	1.75	4	150	0.0350	21.4	4800	114	670
M 16	12.80	2.00	4	150	0.0450	29.0	3730	134	670

Cast aluminium

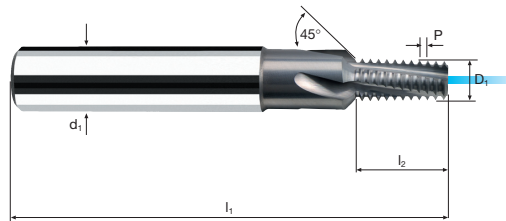
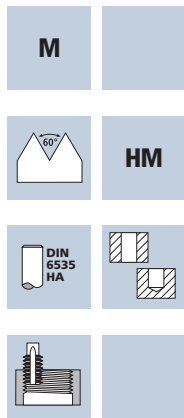
M 3	2.30	0.50	3	200	0.0080	5.7	27680	155	665
M 4	3.00	0.70	3	200	0.0105	8.0	21220	168	670
M 5	4.00	0.80	3	200	0.0140	9.8	15915	134	670
M 6	4.80	1.00	3	200	0.0170	11.3	13265	135	675
M 8	6.40	1.25	3	200	0.0225	14.1	9945	134	670
M 10	7.95	1.50	4	200	0.0280	18.6	8010	183	895
M 12	9.95	1.75	4	200	0.0350	21.4	6400	153	895
M 16	12.80	2.00	4	200	0.0450	29.0	4975	179	895

Titanium alloys
> 300 HB
[Ti6Al4V]

M 3	2.30	0.50	3	40	0.0040	5.7	5535	15	65
M 4	3.00	0.70	3	40	0.0050	8.0	4245	16	65
M 5	4.00	0.80	3	40	0.0065	9.8	3185	12	60
M 6	4.80	1.00	3	40	0.0080	11.3	2655	13	65
M 8	6.40	1.25	3	40	0.0105	14.1	1990	13	65
M 10	7.95	1.50	4	40	0.0135	18.6	1600	17	85
M 12	9.95	1.75	4	40	0.0165	21.4	1280	15	85
M 16	12.80	2.00	4	40	0.0215	29.0	995	17	85

Thread milling cutters

1.5xd, chamfer 45°, Incool



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56		Inox Stainless	Ti Titanium	Aluminium GG(G)
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Example: Order-N°.									Article-N°.		ø-Code		TiCN
									EH24200		.044		EH24200
Ø Code	d	P	l ₁	l ₂	d ₁ h ₆	D ₁	R _k 6H						
.044*	M 3	0.50	48	5.3	6	2.30	1.125	3				●	
.058	M 4	0.70	48	7.4	6	3.00	1.465	3				●	
.084	M 5	0.80	54	9.2	6	4.00	1.960	3				●	
.088	M 6	1.00	62	10.5	8	4.80	2.350	3				●	
.160	M 8	1.25	74	13.1	10	6.40	3.138	3				●	
.174	M10	1.50	80	17.3	12	7.95	3.900	4				●	
.240	M12	1.75	90	20.1	14	9.95	4.887	4				●	
.246	M16	2.00	102	27.0	18	12.80	6.300	4				●	
* without internal cooling													

TM

Application



Material

Steel
850 - 1100 N/mm²

MF	D1 [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	L _K [mm]	n [mm ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
M 4	3.00	0.50	3	80	0.0075	7.9	8490	48	190
M 5	4.00	0.50	3	80	0.0100	9.4	6365	38	190
M 6	4.80	0.50	3	80	0.0120	10.6	5305	38	190
M 6	4.80	0.75	3	80	0.0120	10.8	5305	38	190
M 8	6.40	0.75	3	80	0.0160	14.1	3980	38	190
M 8	6.40	1.00	3	80	0.0160	14.5	3980	38	190
M 10	7.95	1.00	4	80	0.0200	17.8	3205	52	255
M 10	7.95	1.25	4	80	0.0200	18.2	3205	52	255
M 12	9.95	1.00	4	80	0.0250	20.8	2560	44	255

Steel
850 - 1100 N/mm²

M 12	9.95	1.50	4	80	0.0250	21.6	2560	44	255
M 14	11.20	1.50	4	80	0.0280	25.1	2275	51	255
M 16	12.80	1.50	4	80	0.0320	28.3	1990	51	255

Steel
1300 - 1500 N/mm²

M 4	3.00	0.50	3	50	0.0065	7.9	5305	26	105
M 5	4.00	0.50	3	50	0.0090	9.4	3980	21	105
M 6	4.80	0.50	3	50	0.0105	10.6	3315	21	105
M 6	4.80	0.75	3	50	0.0105	10.8	3315	21	105
M 8	6.40	0.75	3	50	0.0140	14.1	2485	21	105
M 8	6.40	1.00	3	50	0.0140	14.5	2485	21	105
M 10	7.95	1.00	4	50	0.0175	17.8	2000	29	140
M 10	7.95	1.25	4	50	0.0175	18.2	2000	29	140
M 12	9.95	1.00	4	50	0.0220	20.8	1600	24	140

Steel
1300 - 1500 N/mm²

M 12	9.95	1.50	4	50	0.0220	21.6	1600	24	140
M 14	11.20	1.50	4	50	0.0250	25.1	1420	28	140
M 16	12.80	1.50	4	50	0.0285	28.3	1245	28	140

Material

Wrought aluminium
alloys Si < 6%

MF	D1 [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	L _K [mm]	n [mm ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
M 4	3.00	0.50	3	150	0.0105	7.9	15915	125	500
M 5	4.00	0.50	3	150	0.0140	9.4	11935	100	500
M 6	4.80	0.50	3	150	0.0170	10.6	9945	101	505
M 6	4.80	0.75	3	150	0.0170	10.8	9945	101	505
M 8	6.40	0.75	3	150	0.0225	14.1	7460	101	505
M 8	6.40	1.00	3	150	0.0225	14.5	7460	101	505
M 10	7.95	1.00	4	150	0.0280	17.8	6005	138	675
M 10	7.95	1.25	4	150	0.0280	18.2	6005	138	675
M 12	9.95	1.00	4	150	0.0350	20.8	4800	114	670

Wrought aluminium
alloys Si < 6%

M 12	9.95	1.50	4	150	0.0350	21.6	4800	114	670
M 14	11.20	1.50	4	150	0.0395	25.1	4265	135	675
M 16	12.80	1.50	4	150	0.0450	28.3	3730	134	670

Cast iron
GG(G)

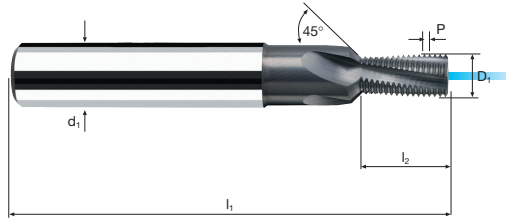
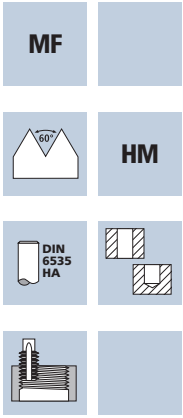
M 4	3.00	0.50	3	120	0.0075	7.9	12735	71	285
M 5	4.00	0.50	3	120	0.0100	9.4	9550	57	285
M 6	4.80	0.50	3	120	0.0120	10.6	7960	57	285
M 6	4.80	0.75	3	120	0.0120	10.8	7960	57	285
M 8	6.40	0.75	3	120	0.0160	14.1	5970	57	285
M 8	6.40	1.00	3	120	0.0160	14.5	5970	57	285
M 10	7.95	1.00	4	120	0.0200	17.8	4805	79	385
M 10	7.95	1.25	4	120	0.0200	18.2	4805	79	385
M 12	9.95	1.00	4	120	0.0250	20.8	3840	66	385

Cast iron
GG(G)

M 12	9.95	1.50	4	120	0.0250	21.6	3840	66	385
M 14	11.20	1.50	4	120	0.0280	25.1	3410	76	380
M 16	12.80	1.50	4	120	0.0320	28.3	2985	76	380

Thread milling cutters

1.5xd, chamfer 45°, Incool



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56		Inox Stainless	Ti Titanium	Aluminium GG(G)
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Example: Order-N°.		Article-N°.		ø-Code						TiCN		
		Eh24220		.046						Eh24220		
Ø Code	d	P	l ₁	l ₂	d ₁ h ₆	D ₁	R _k 6H					
.046	M 4	0.50	48	7.3	6	3.00	1.475	3				●
.048	M 5	0.50	54	8.8	6	4.00	1.975	3				●
.050	M 6	0.50	62	9.8	8	4.80	2.375	3				●
.064	M 6	0.75	62	10.1	8	4.80	2.363	3				●
.066	M 8	0.75	74	13.1	10	6.40	3.163	3				●
.090	M 8	1.00	74	13.5	10	6.40	3.150	3				●
.092	M10	1.00	80	16.5	12	7.95	3.925	4				●
.162	M10	1.25	80	16.9	12	7.95	3.913	4				●
.094	M12	1.00	90	19.5	14	9.95	4.925	4				●
.176	M12	1.50	90	20.3	14	9.95	4.900	4				●
.178	M14	1.50	102	23.3	16	11.20	5.525	4				●
.180	M16	1.50	102	26.3	18	12.80	6.325	4				●

TM