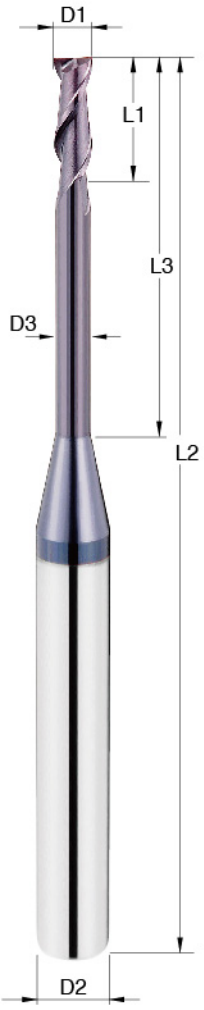
EFFICIENCY MILLS

EFA



MG

2 Flutes

35°

HRC 55

TiAlN

Finishing
Semi-Finishing

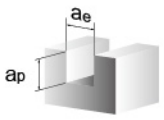
Slotting

▶ Long Neck / Square / for P K

unit: mm

Order No.	Diameter D1	Neck Dia D3	Flute Length L1	Effective Length L3	O.A.L. L2	Shank Dia D2
EFA **01006**	1.0	0.95	3	6	50	4
EFA **01008**	1.0	0.95	3	8	50	4
EFA **01010**	1.0	0.95	3	10	50	4
EFA **01012**	1.0	0.95	3	12	50	4
EFA **01508**	1.5	1.45	4	8	50	4
EFA **01510**	1.5	1.45	4	10	50	4
EFA **01512**	1.5	1.45	4	12	50	4
EFA **01516**	1.5	1.45	4	16	50	4
EFA **02008**	2.0	1.92	6	8	50	4
EFA **02010**	2.0	1.92	6	10	50	4
EFA **02012**	2.0	1.92	6	12	50	4
EFA **02016**	2.0	1.92	6	16	50	4
EFA **02020**	2.0	1.92	6	20	50	4
EFA **02510**	2.5	2.40	8	10	50	4
EFA **02512**	2.5	2.40	8	12	50	4
EFA **02516**	2.5	2.40	8	16	50	4
EFA **02520**	2.5	2.40	8	20	50	4
EFA **03010**	3.0	2.90	8	10	50	6
EFA **03012**	3.0	2.90	8	12	50	6
EFA **03016**	3.0	2.90	8	16	50	6
EFA **03020**	3.0	2.90	8	20	75	6
EFA **03025**	3.0	2.90	8	25	75	6

▼ *Depth of cut*



ae=D1

▼ *Recommended cutting condition for EFA*

MATERIAL		Carbon Steels . Alloy Steels S45C , FC , FCD , SCM , S50C , SKS...	Alloy Steels . Tool Steels SCr , SNCM , SKD11 , SKD61 , NAK80...	Hardened Steels SKD11
Dia.(D1)	EFFECTIVE LENGTH	SPEED (min^{-1})	FEED mm / min	DEPTH OF CUT ap (mm)
1	4	25000	1500	0.05
	6	25000	1500	0.03
	10	25000	1500	0.01
1.5	4	15000	1200	0.1
	8	15000	1200	0.05
	10	15000	1200	0.025
	12	15000	1200	0.018
2	8	12000	900	0.2
	10	8800	700	0.12
	12	7500	600	0.05
	16	7000	500	0.02
3	8	8000	600	0.5
	12	8000	600	0.45
	16	5500	450	0.18
	20	4000	300	0.15
4	10	6000	400	0.7
	16	6000	400	0.4