

Tool material

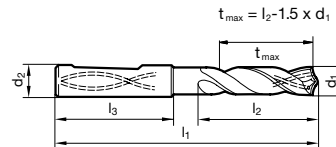
HSCO

Surface



P	Steel	●	web thinning $\geq \varnothing 5.000$ • relieved cone • Co-alloyed high speed steel
M	Stainless steel	●	
K	Cast iron	●	long chipping materials up to 1000 N/mm ² • stainless steels • cast materials
N	Aluminum	●	• non-ferrous metals
S	Titanium alloys	●	
H	Hardened steel	○	

●=Optimal
○=Limited



Speeds and feeds information on pg. 548

Diameter (d1)			d2	l1	t _{max}	l2	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.1969		5.00	6.00	82.00	36.50	44.00	9011310050000
0.2165		5.50	6.00	82.00	35.75	44.00	9011310055000
0.2362		6.00	6.00	82.00	35.00	44.00	9011310060000
0.2500	1/4	E	6.35	8.00	91.00	43.48	9011310063500
0.2559		6.50	8.00	91.00	43.25	53.00	9011310065000
0.2677		6.80	8.00	91.00	42.80	53.00	9011310068000
0.2756		7.00	8.00	91.00	42.50	53.00	9011310070000
0.2811	9/32	K	7.14	8.00	91.00	42.29	9011310071400
0.2953		7.50	8.00	91.00	41.75	53.00	9011310075000
0.3071		7.80	8.00	91.00	41.30	53.00	9011310078000
0.3126	5/16		7.94	8.00	91.00	41.09	9011310079400
0.3150		8.00	8.00	91.00	41.00	53.00	9011310080000
0.3346		8.50	10.00	103.00	48.25	61.00	9011310085000
0.3437	11/32		8.73	10.00	103.00	47.91	9011310087300
0.3543		9.00	10.00	103.00	47.50	61.00	9011310090000
0.3740		9.50	10.00	103.00	46.75	61.00	9011310095000
0.3748	3/8		9.52	10.00	103.00	46.72	9011310095200
0.3937		10.00	10.00	103.00	46.00	61.00	9011310100000
0.4016		10.20	12.00	118.00	55.70	71.00	9011310102000
0.4063	13/32		10.32	12.00	118.00	55.52	9011310103200
0.4134		10.50	12.00	118.00	55.25	71.00	9011310105000
0.4331		11.00	12.00	118.00	54.50	71.00	9011310110000
0.4374	7/16		11.11	12.00	118.00	54.34	9011310111100
0.4528		11.50	12.00	118.00	53.75	71.00	9011310115000

Diameter (d1)			d2	l1	t _{max}	l2	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.4689	15/32	11.91	12.00	118.00	53.14	71.00	9011310119100
0.4724		12.00	12.00	118.00	53.00	71.00	9011310120000
0.4921		12.50	14.00	124.00	58.25	77.00	9011310125000
0.5000	1/2	12.70	14.00	124.00	57.95	77.00	9011310127000
0.5118		13.00	14.00	124.00	57.50	77.00	9011310130000
0.5311	17/32	13.49	14.00	124.00	56.77	77.00	9011310134900
0.5315		13.50	14.00	124.00	56.75	77.00	9011310135000
0.5512		14.00	14.00	124.00	56.00	77.00	9011310140000
0.5626	9/16	14.29	16.00	133.00	61.57	83.00	9011310142900
0.5709		14.50	16.00	133.00	61.25	83.00	9011310145000
0.5906		15.00	16.00	133.00	60.50	83.00	9011310150000
0.5937	19/32	15.08	16.00	133.00	60.38	83.00	9011310150800
0.6102		15.50	16.00	133.00	59.75	83.00	9011310155000
0.6248	5/8	15.87	16.00	133.00	59.20	83.00	9011310158700
0.6299		16.00	16.00	133.00	59.00	83.00	9011310160000
0.6496		16.50	18.00	143.00	68.25	93.00	9011310165000
0.6693		17.00	18.00	143.00	67.50	93.00	9011310170000
0.6890		17.50	18.00	143.00	66.75	93.00	9011310175000
0.7087		18.00	18.00	143.00	66.00	93.00	9011310180000
0.7283		18.50	20.00	153.00	73.25	101.00	9011310185000
0.7480		19.00	20.00	153.00	72.50	101.00	9011310190000
0.7677		19.50	20.00	153.00	71.75	101.00	9011310195000
0.7874		20.00	20.00	153.00	71.00	101.00	9011310200000