MEFCSH3

cylindrical shank, 3 flutes

OSAWA NORM | VA | UMG ENDLESS | <45 HRC | 50° | SQUARE | Z3 ≤ Ø18 | Z4 > Ø18

P	M	K	N	S	H
★	★			★	

★ 1st choice ☆ suitable

SLOTTING | SIDE MILLING

D	D Tol.	C	C Tol.	d(h6)	l	l1	L	z	EDP No.	Stock
6	0/-0.030			6	13		50	3	MEFCSH3060	●
8	0/-0.030			8	19		60	3	MEFCSH3080	●
10	0/-0.030			10	22		70	3	MEFCSH3100	●
12	0/-0.030			12	26		75	3	MEFCSH3120	●
16	0/-0.030			16	32		100	3	MEFCSH3160	●
18	0/-0.030			18	32		90	3	MEFCSH3180	●
20	0/-0.030			20	38		105	4	MEFCSH4200	●

● stock standard ○ non-stock standard ∇ stock exhaustion

CUTTING PARAMETERS

MEFCSH3

SLOTTING	Material Group ISO 513	P1 P2 P3			P4 M1 M2			P5 M3 M4 S1 S2 S4			M5 S3 S5		
	Hardness/Rm	< 700 N/mm²			700-1000 N/mm²			< 35 HRC			< 45 HRC		
	ap x ae	**0.5D x D**			**0.5D x D**			**0.3D x D**			**0.2D x D**		
	Vc (m/min)	**80-100**			**60-80**			**40-60**			**30-50**		
	D (mm)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)
	6	4780	0.022	220	3720	0.013	140	2650	0.012	100	2120	0.012	80
	8	3580	0.029	210	2790	0.017	140	1990	0.015	90	1590	0.016	80
	10	2870	0.036	220	2230	0.021	140	1590	0.019	90	1270	0.020	80
	12	2390	0.046	230	1860	0.027	150	1330	0.024	100	1060	0.026	80
	14	2050	0.053	230	1590	0.031	150	1140	0.028	90	910	0.030	80
	16	1790	0.065	240	1390	0.038	160	1000	0.034	100	800	0.036	90
	18	1590	0.075	250	1240	0.044	160	880	0.039	100	710	0.042	90
	20	1430	0.086	260	1110	0.051	170	800	0.045	110	640	0.048	90

SIDE MILLING	Material Group ISO 513	P1 P2 P3			P4 M1 M2			P5 M3 M4 S1 S2 S4			M5 S3 S5		
	Hardness/Rm	< 700 N/mm²			700-1000 N/mm²			< 35 HRC			< 45 HRC		
	ap x ae	**1.5D x 0.3D**			**1.5D x 0.3D**			**1.5D x 0.2D**			**1.5D x 0.1D**		
	Vc (m/min)	**80-120**			**60-80**			**40-60**			**100-140**		
	D (mm)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)
	6	4780	0.026	260	3720	0.015	170	2650	0.014	110	2120	0.014	90
	8	3580	0.035	260	2790	0.020	170	1990	0.019	110	1590	0.019	90
	10	2870	0.043	260	2230	0.026	170	1590	0.024	110	1270	0.024	90
	12	2390	0.055	280	1860	0.033	180	1330	0.031	120	1060	0.031	100
	14	2050	0.064	270	1590	0.038	180	1140	0.036	120	910	0.036	100
	16	1790	0.078	290	1390	0.046	190	1000	0.043	130	800	0.043	100
	18	1590	0.090	300	1240	0.053	200	880	0.050	130	710	0.050	110
	20	1430	0.104	310	1110	0.061	200	800	0.058	140	640	0.058	110