



Product innovations 6/19

EPM solid carbide cutters

The perfect entry into the Solid Carbide Milling Performance Class



GB



ZCC Cutting Tools Europe GmbH

your Partner | your Value



EPM series

The perfect entry into the Solid Carbide Milling Performance Class

EPM concept

- One focused product portfolio for the most important applications.
- One universal portfolio covering the most relevant material groups.
- A particularly attractive price-performance ratio.

EPM features

- Nano TiAlN coated carbide substrate, specially developed for High-Performance milling of steel (up to 55HRC), stainless steel and cast iron, optimized wear resistance and toughness for a wide range of applications.
- Stable cutting edge
- End mills and ball nose cutters
- Diameter range 3,0–20,0 mm

EPM customer values

- Easier and faster product selection due to expanded application range
- Proven, enhanced technology for reliable quality
- Optimized price-/performance ratio



EPM – 2 E L P – D12 R0.5 – M08 – W

1

2

3

4

5

6

7

8

9

Application	
Code	Description
GR	General roughing
GM	Semi-finishing
GF	Finishing
PM	High-performance machining
EPM	«Ecoline» – High-performance machining
HM	Hard machining
HH	High-speed hard machining
NM	General machining of non-ferrous metals
AL	General machining of Al and Al alloys
ALP	High-performance machining of Al and Al alloys
ALG	General machining of Al and Al alloys
UM	HSC/HPC machining
VSM	General machining of heat-resistant alloys

Number
of teeth

1

2

Cutting edge type	
Code	Description
E	Square shoulder mill with protective chamfer
F	Square shoulder mill with sharp cutting edges
B	Ball nose cutter
R	Torus mill
W	Ripper
H	High-feed mill

3

Cutting edge length	
Code	Description
L	Long
X	Extra long
F	Short

4

Type	
Code	Description
S	Mini diameter
P	Ground neck
C	Conical neck

5

Diameter [mm]	
Code	Description
D3.0	3,0
D8.0	8,0
D20.0	20,0
...	

6

Radius [mm]	
Code	Description
R0.5	0,5
R1.0	1,5
R3.0	3,0
...	

7

Features	
Code	Description
G	Spiral angle 30°
M	Neck length [mm]
S	Thin shank
AIR	For aerospace industry

8

Weldon shank	
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9



a Groove milling



b Square shoulder milling



c Profile milling



d Slot milling



e Face milling



f Chamfer milling



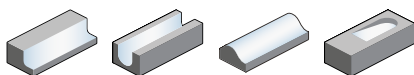
g Plunge milling



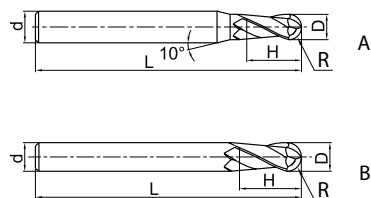
h Circular milling/Ramping

Ball nose cutter High-performance machining

EPM-2B



- Factory standard
- Centre cutting
- Helix angle 30°



Article	*	Dimensions [mm]					Teeth	Geometry	Grade
		R	D	d (h6)	H	L			
EPM-2B-R1.5		1.5	3	6	6	50	2	A	●
EPM-2B-R2.0		2	4	6	8	50	2	A	●
EPM-2B-R2.5		2.5	5	6	10	50	2	A	●
EPM-2B-R3.0		3	6	6	12	50	2	B	●
EPM-2B-R4.0		4	8	8	16	60	2	B	●
EPM-2B-R5.0		5	10	10	20	75	2	B	●
EPM-2B-R6.0		6	12	12	24	75	2	B	●
EPM-2B-R7.0		7	14	14	28	75	2	B	●
EPM-2B-R8.0		8	16	16	32	100	2	B	●
EPM-2B-R10.0		10	20	20	40	100	2	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

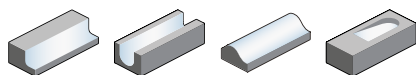
✓ Very suitable

✓ Suitable

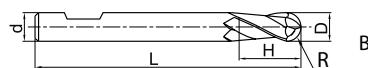
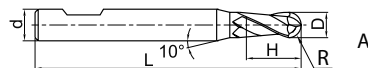
Ball nose cutter

High-performance machining

EPM-2B-W



- Type of shank DIN 6535HA
- Centre cutting
- Helix angle 30°



Article	*	Dimensions [mm]					Teeth	Geometry	Grade
		R	D	d (h6)	H	L			
EPM-2B-R1.5-W		1.5	3	6	4	50	2	A	●
EPM-2B-R2.0-W		2	4	6	5	54	2	A	●
EPM-2B-R2.5-W		2.5	5	6	6	54	2	A	●
EPM-2B-R3.0-W		3	6	6	7	54	2	B	●
EPM-2B-R4.0-W		4	8	8	9	58	2	B	●
EPM-2B-R5.0-W		5	10	10	11	66	2	B	●
EPM-2B-R6.0-W		6	12	12	12	73	2	B	●
EPM-2B-R8.0-W		8	16	16	16	83	2	B	●
EPM-2B-R10.0-W		10	20	20	20	92	2	B	●

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
✓	✓	✓			✓

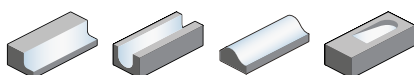
✓ Very suitable

✓ Suitable

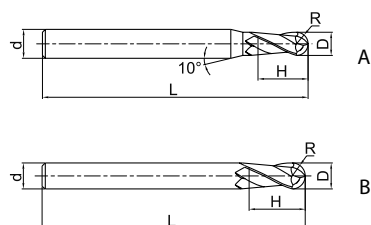
Ball nose cutter long cutting edge

High-performance machining

EPM-2BL



- Factory standard
- Centre cutting
- Helix angle 30°



Article	*	Dimensions [mm]					Teeth	Geometry	Grade
		R	D	d (h6)	H	L			
EPM-2BL-R1.5		1.5	3	6	6	75	2	A	●
EPM-2BL-R2.0		2	4	6	8	75	2	A	●
EPM-2BL-R2.5		2.5	5	6	10	75	2	A	●
EPM-2BL-R3.0		3	6	6	12	75	2	B	●
EPM-2BL-R4.0		4	8	8	16	100	2	B	●
EPM-2BL-R5.0		5	10	10	20	100	2	B	●
EPM-2BL-R6.0		6	12	12	24	100	2	B	●
EPM-2BL-R7.0		7	14	14	28	100	2	B	●
EPM-2BL-R8.0		8	16	16	32	150	2	B	●
EPM-2BL-R10.0		10	20	20	40	150	2	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

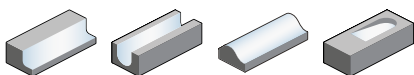
✓ Very suitable

✓ Suitable

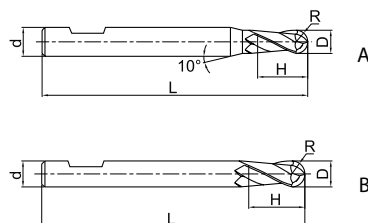
Ball nose cutter long cutting edge

High-performance machining

EPM-2BL-W



- Type of shank DIN 6535HA
- Centre cutting
- Helix angle 30°



Article	*	Dimensions [mm]					Teeth	Geometry	Grade
		R	D	d (h6)	H	L			
EPM-2BL-R1.5-W		1.5	3	6	4	57	2	A	●
EPM-2BL-R2.0-W		2	4	6	5	57	2	A	●
EPM-2BL-R2.5-W		2.5	5	6	6	57	2	A	●
EPM-2BL-R3.0-W		3	6	6	7	57	2	B	●
EPM-2BL-R4.0-W		4	8	8	9	63	2	B	●
EPM-2BL-R5.0-W		5	10	10	11	72	2	B	●
EPM-2BL-R6.0-W		6	12	12	12	83	2	B	●
EPM-2BL-R8.0-W		8	16	16	16	92	2	B	●
EPM-2BL-R10.0-W		10	20	20	20	104	2	B	●

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
✓	✓	✓			✓

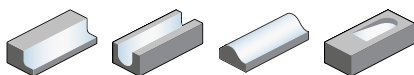
✓ Very suitable

✓ Suitable

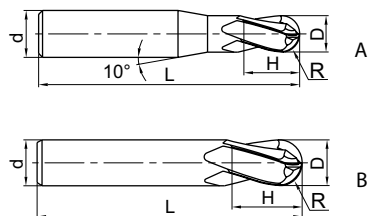
Ball nose cutter

High-performance machining

EPM-4B



- Factory standard
- Centre cutting
- Helix angle 30°



Article	*	Dimensions [mm]					Teeth	Geometry	Grade
		R	D	d (h6)	H	L			
EPM-4B-R1.5		1.5	3	6	6	50	4	A	●
EPM-4B-R2.0		2	4	6	8	50	4	A	●
EPM-4B-R2.5		2.5	5	6	10	50	4	A	●
EPM-4B-R3.0		3	6	6	12	50	4	B	●
EPM-4B-R4.0		4	8	8	16	60	4	B	●
EPM-4B-R5.0		5	10	10	20	75	4	B	●
EPM-4B-R6.0		6	12	12	24	75	4	B	●
EPM-4B-R7.0		7	14	14	28	75	4	B	●
EPM-4B-R8.0		8	16	16	32	100	4	B	●
EPM-4B-R9.0		9	18	18	36	100	4	B	●
EPM-4B-R10.0		10	20	20	40	100	4	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

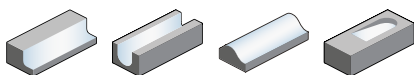
✓ Very suitable

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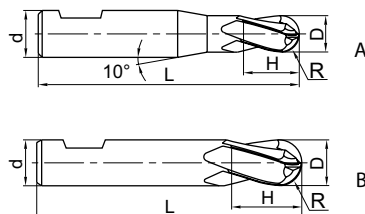
Ball nose cutter

High-performance machining

EPM-4B-W



- Type of shank DIN 6535HA
- Centre cutting
- Helix angle 30°



Article	*	Dimensions [mm]					Teeth	Geometry	Grade
		R	D	d (h6)	H	L			KMG406
EPM-4B-R1.5-W		1.5	3	6	4	50	4	A	●
EPM-4B-R2.0-W		2	4	6	5	54	4	A	●
EPM-4B-R2.5-W		2.5	5	6	6	54	4	A	●
EPM-4B-R3.0-W		3	6	6	7	54	4	B	●
EPM-4B-R4.0-W		4	8	8	9	58	4	B	●
EPM-4B-R5.0-W		5	10	10	11	66	4	B	●
EPM-4B-R6.0-W		6	12	12	12	73	4	B	●
EPM-4B-R7.0-W		7	14	14	14	75	4	B	●
EPM-4B-R8.0-W		8	16	16	16	83	4	B	●
EPM-4B-R9.0-W		9	18	18	18	84	4	B	●
EPM-4B-R10.0-W		10	20	20	20	92	4	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

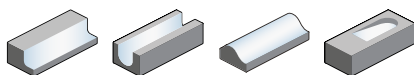
✓ Very suitable

✓ Suitable

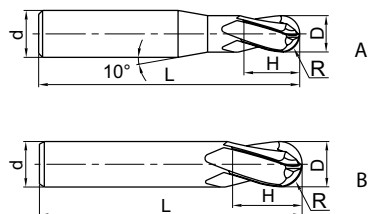
Ball nose cutter long cutting edge

High-performance machining

EPM-4BL



- Factory standard
- Centre cutting
- Helix angle 30°



Article	*	Dimensions [mm]					Teeth	Geometry	Grade
		R	D	d (h6)	H	L			
EPM-4BL-R1.5		1.5	3	6	6	75	4	A	●
EPM-4BL-R2.0		2	4	6	8	75	4	A	●
EPM-4BL-R2.5		2.5	5	6	10	75	4	A	●
EPM-4BL-R3.0		3	6	6	12	75	4	B	●
EPM-4BL-R4.0		4	8	8	16	100	4	B	●
EPM-4BL-R5.0		5	10	10	20	100	4	B	●
EPM-4BL-R6.0		6	12	12	24	100	4	B	●
EPM-4BL-R7.0		7	14	14	28	100	4	B	●
EPM-4BL-R8.0		8	16	16	32	150	4	B	●
EPM-4BL-R10.0		10	20	20	40	150	4	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

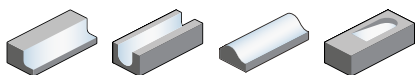
✓ Very suitable

✓ Suitable

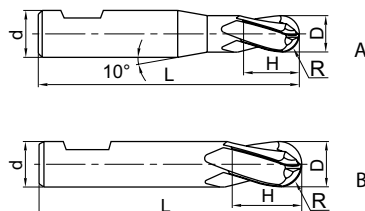
Ball nose cutter long cutting edge

High-performance machining

EPM-4BL-W



- Type of shank DIN 6535HA
- Centre cutting
- Helix angle 30°



Article	*	Dimensions [mm]					Teeth	Geometry	Grade
		R	D	d (h6)	H	L			
EPM-4BL-R1.5-W		1.5	3	6	4	57	4	A	●
EPM-4BL-R2.0-W		2	4	6	5	57	4	A	●
EPM-4BL-R2.5-W		2.5	5	6	6	57	4	A	●
EPM-4BL-R3.0-W		3	6	6	7	57	4	B	●
EPM-4BL-R4.0-W		4	8	8	9	63	4	B	●
EPM-4BL-R5.0-W		5	10	10	11	72	4	B	●
EPM-4BL-R6.0-W		6	12	12	12	83	4	B	●
EPM-4BL-R8.0-W		8	16	16	16	92	4	B	●
EPM-4BL-R10.0-W		10	20	20	20	104	4	B	●

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
✓	✓	✓			✓

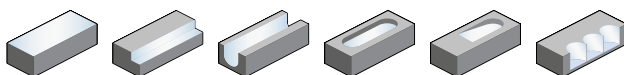
✓ Very suitable

✓ Suitable

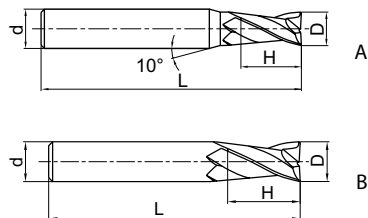
End mill

High-performance machining

EPM-2E



- Factory standard
- Centre cutting
- Helix angle 30°



Article	*	Dimensions [mm]				Teeth	Geometry	Grade
		D	d (h6)	H	L			KMG406
EPM-2E-D3.0		3	6	8	50	2	A	●
EPM-2E-D4.0		4	6	11	50	2	A	●
EPM-2E-D5.0		5	6	13	50	2	A	●
EPM-2E-D6.0		6	6	16	50	2	B	●
EPM-2E-D8.0		8	8	20	60	2	B	●
EPM-2E-D10.0		10	10	25	75	2	B	●
EPM-2E-D12.0		12	12	30	75	2	B	●
EPM-2E-D14.0		14	14	32	75	2	B	●
EPM-2E-D16.0		16	16	45	100	2	B	●
EPM-2E-D18.0		18	18	45	100	2	B	●
EPM-2E-D20.0		20	20	45	100	2	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

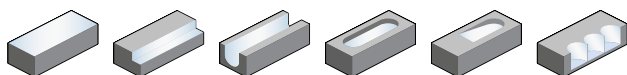
✓ Very suitable

✓ Suitable

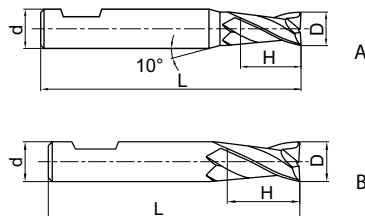
End mill

High-performance machining

EPM-2E-W



- Type of shank DIN 6535HA
- Centre cutting
- Helix angle 30°



Article	*	Dimensions [mm]				Teeth	Geometry	Grade
		D	d (h6)	H	L			KMG406
EPM-2E-D3.0-W		3	6	4	50	2	A	●
EPM-2E-D4.0-W		4	6	5	54	2	A	●
EPM-2E-D5.0-W		5	6	6	54	2	A	●
EPM-2E-D6.0-W		6	6	7	54	2	B	●
EPM-2E-D8.0-W		8	8	9	58	2	B	●
EPM-2E-D10.0-W		10	10	11	66	2	B	●
EPM-2E-D12.0-W		12	12	12	73	2	B	●
EPM-2E-D14.0-W		14	14	14	75	2	B	●
EPM-2E-D16.0-W		16	16	16	82	2	B	●
EPM-2E-D18.0-W		18	18	18	84	2	B	●
EPM-2E-D20.0-W		20	20	20	92	2	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

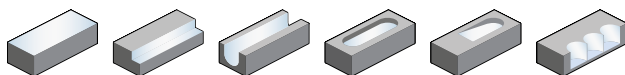
✓ Very suitable

✓ Suitable

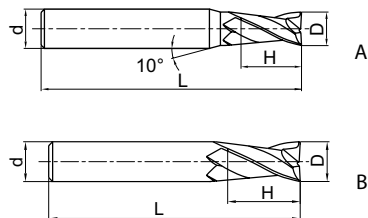
End mill long cutting edge

High-performance machining

EPM-2EL



- Factory standard
- Centre cutting
- Helix angle 30°



Article	*	Dimensions [mm]				Teeth	Geometry	Grade
		D	d (h6)	H	L			KMG406
EPM-2EL-D3.0		3	6	12	75	2	A	●
EPM-2EL-D4.0		4	6	15	75	2	A	●
EPM-2EL-D5.0		5	6	20	75	2	A	●
EPM-2EL-D6.0		6	6	20	75	2	B	●
EPM-2EL-D8.0		8	8	25	100	2	B	●
EPM-2EL-D10.0		10	10	30	100	2	B	●
EPM-2EL-D12.0		12	12	35	100	2	B	●
EPM-2EL-D14.0		14	14	40	100	2	B	●
EPM-2EL-D16.0		16	16	50	150	2	B	●
EPM-2EL-D20.0		20	20	55	150	2	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

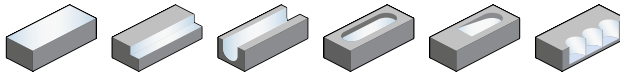
✓ Very suitable

✓ Suitable

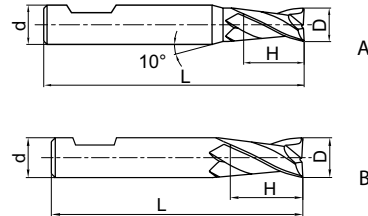
End mill long cutting edge

High-performance machining

EPM-2EL-W



- Type of shank DIN 6535HA
- Centre cutting
- Helix angle 30°



Article	*	Dimensions [mm]				Teeth	Geometry	Grade
		D	d (h6)	H	L			KMG406
EPM-2EL-D3.0-W		3	6	6	57	2	A	●
EPM-2EL-D4.0-W		4	6	8	57	2	A	●
EPM-2EL-D5.0-W		5	6	10	57	2	A	●
EPM-2EL-D6.0-W		6	6	10	57	2	B	●
EPM-2EL-D8.0-W		8	8	16	63	2	B	●
EPM-2EL-D10.0-W		10	10	19	72	2	B	●
EPM-2EL-D12.0-W		12	12	22	83	2	B	●
EPM-2EL-D14.0-W		14	14	22	83	2	B	●
EPM-2EL-D16.0-W		16	16	26	92	2	B	●
EPM-2EL-D18.0-W		18	18	26	92	2	B	●
EPM-2EL-D20.0-W		20	20	32	104	2	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

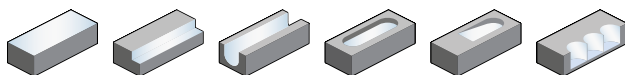
✓ Very suitable

✓ Suitable

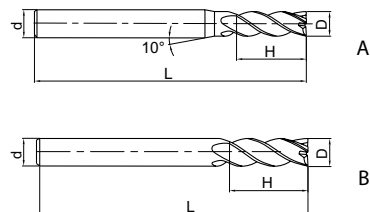
End mill

High-performance machining

EPM-4E



- Factory standard
- Centre cutting
- Helix angle 45°



Article	*	Dimensions [mm]				Teeth	Geometry	Grade
		D	d (h6)	H	L			KMG406
EPM-4E-D3.0		3	6	8	50	4	A	●
EPM-4E-D4.0		4	6	11	50	4	A	●
EPM-4E-D5.0		5	6	13	50	4	A	●
EPM-4E-D6.0		6	6	16	50	4	B	●
EPM-4E-D8.0		8	8	20	60	4	B	●
EPM-4E-D10.0		10	10	25	75	4	B	●
EPM-4E-D12.0		12	12	30	75	4	B	●
EPM-4E-D14.0		14	14	32	75	4	B	●
EPM-4E-D16.0		16	16	45	100	4	B	●
EPM-4E-D18.0		18	18	45	100	4	B	●
EPM-4E-D20.0		20	20	45	100	4	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

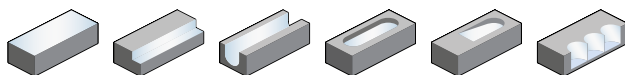
✓ Very suitable

✓ Suitable

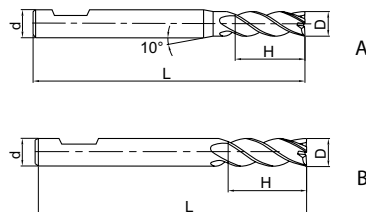
End mill

High-performance machining

EPM-4E-W



- Type of shank DIN 6535HA
- Centre cutting
- Helix angle 45°



Article	*	Dimensions [mm]				Teeth	Geometry	Grade
		D	d (h6)	H	L			KMG406
EPM-4E-D3.0-W		3	6	4	50	4	A	●
EPM-4E-D4.0-W		4	6	5	54	4	A	●
EPM-4E-D5.0-W		5	6	6	54	4	A	●
EPM-4E-D6.0-W		6	6	7	54	4	B	●
EPM-4E-D8.0-W		8	8	9	58	4	B	●
EPM-4E-D10.0-W		10	10	11	66	4	B	●
EPM-4E-D12.0-W		12	12	12	73	4	B	●
EPM-4E-D14.0-W		14	14	14	75	4	B	●
EPM-4E-D16.0-W		16	16	16	82	4	B	●
EPM-4E-D18.0-W		18	18	18	84	4	B	●
EPM-4E-D20.0-W		20	20	20	92	4	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

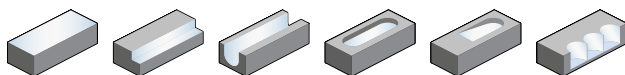
✓ Very suitable

✓ Suitable

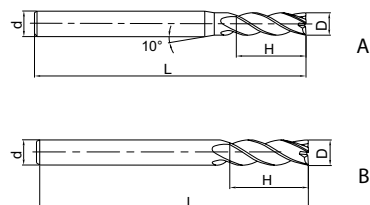
End mill long cutting edge

High-performance machining

EPM-4EL



- Factory standard
- Centre cutting
- Helix angle 45°



Article	*	Dimensions [mm]				Teeth	Geometry	Grade
		D	d (h6)	H	L			KMG406
EPM-4EL-D3.0		3	6	12	75	4	A	●
EPM-4EL-D4.0		4	6	15	75	4	A	●
EPM-4EL-D5.0		5	6	20	75	4	A	●
EPM-4EL-D6.0		6	6	20	75	4	B	●
EPM-4EL-D8.0		8	8	25	100	4	B	●
EPM-4EL-D10.0		10	10	30	100	4	B	●
EPM-4EL-D12.0		12	12	35	100	4	B	●
EPM-4EL-D14.0		14	14	40	100	4	B	●
EPM-4EL-D16.0		16	16	50	150	4	B	●
EPM-4EL-D20.0		20	20	55	150	4	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

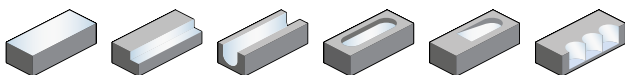
✓ Very suitable

✓ Suitable

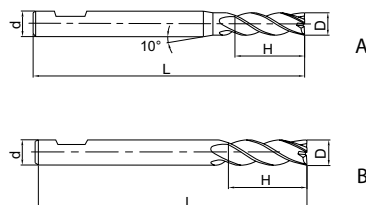
End mill long cutting edge

High-performance machining

EPM-4EL-W



- Type of shank DIN 6535HA
- Centre cutting
- Helix angle 45°



Article	*	Dimensions [mm]				Teeth	Geometry	Grade
		D	d (h6)	H	L			KMG406
EPM-4EL-D3.0-W		3	6	8	57	4	A	●
EPM-4EL-D4.0-W		4	6	11	57	4	A	●
EPM-4EL-D5.0-W		5	6	13	57	4	A	●
EPM-4EL-D6.0-W		6	6	13	57	4	B	●
EPM-4EL-D8.0-W		8	8	19	63	4	B	●
EPM-4EL-D10.0-W		10	10	22	72	4	B	●
EPM-4EL-D12.0-W		12	12	26	83	4	B	●
EPM-4EL-D14.0-W		14	14	26	83	4	B	●
EPM-4EL-D16.0-W		16	16	32	92	4	B	●
EPM-4EL-D18.0-W		18	18	32	92	4	B	●
EPM-4EL-D20.0-W		20	20	38	104	4	B	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓			✓

✓ Very suitable

✓ Suitable

End mill – EPM series

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]								
						EPM-2E EPM-4E				EPM-2EL EPM-4EL				
						Slot milling		Shoulder milling		Slot milling		Shoulder milling		
						$\varnothing$ [mm]	$a_{p \max}$	$\varnothing$ [mm]	$a_{e \max}$	$\varnothing$ [mm]	$a_{p \max}$	$\varnothing$ [mm]	$a_{e \max}$	
						$0 < x < 3$	$0,15 \times D$	$0 < x \leq 20$	$0,15 \times D$	$0 < x < 3$	$0,15 \times D$	$0 < x \leq 20$	$0,15 \times D$	
						$3 \leq x < 6$	$0,3 \times D$			$3 \leq x < 6$	$0,3 \times D$			
						$6 \leq x \leq 20$	$0,5 \times D$			$6 \leq x \leq 20$	$0,5 \times D$			
KMG406				KMG406										
a_e / D				a_e / D										
1/1	1/2	1/10	f-group	1/1	1/2	1/10	f-group							
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1	165	220	300	1	140	190	255	1	
		approx. 0,45 % C	annealed	190	2	160	210	285	1	135	185	245	1	
		approx. 0,45 % C	tempered	250	3	120	155	210	1	100	135	180	1	
		approx. 0,75 % C	annealed	270	4	100	135	180	1	85	115	155	1	
		approx. 0,75 % C	tempered	300	5	95	125	165	1	80	105	145	1	
	Low-alloyed steel		annealed	180	6	125	165	225	1	110	145	195	1	
			tempered	275	7	100	135	180	1	85	115	155	1	
			tempered	300	8	95	125	165	1	80	105	145	1	
			tempered	350	9	90	115	160	1	75	100	135	1	
	High-alloyed steel and high-alloyed tool steel		annealed	200	10	120	155	210	1	100	135	180	1	
		hardened and tempered	325	11	90	120	160	1	75	105	140	1		
M	Stainless steel	ferritic/martensitic	annealed	200	12	55	75	100	1	45	65	85	1	
		martensitic	tempered	240	13	50	65	85	1	40	55	75	1	
		austenitic	quench hardened	180	14	60	75	105	1	50	65	90	1	
		austenitic-ferritic		230	15	50	65	85	1	40	55	75	1	
K	Grey cast iron	perlitic/ferritic		180	16	125	165	220	1	105	140	190	1	
		perlitic (martensitic)		260	17	100	135	180	1	85	115	155	1	
	Cast iron with spheroidal graphite	ferritic		160	18	150	200	270	1	130	175	230	1	
		perlitic		250	19	120	155	210	1	100	135	180	1	
	Malleable cast iron	ferritic		130	20	165	220	300	1	145	190	255	1	
		perlitic		230	21	135	180	240	1	115	155	205	1	
N	Aluminium wrought alloys	cannot be hardened		60	22									
		hardenable	hardened	100	23									
	Cast aluminium alloys	$\leq 12\%$ Si, cannot be hardened		75	24									
		$\leq 12\%$ Si, hardenable	hardened	90	25									
		$> 12\%$ Si, cannot be hardened		130	26									
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27									
		CuZn, CuSnZn		90	28									
CuSn, Pb-free copper, electrolytic copper		100	29											
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30									
			hardened	280	31									
		Ni or Co bass	annealed	250	32									
			hardened	350	33									
			cast	320	34									
	Titanium alloys	pure titanium		R_m 400	35									
		α and β alloys	hardened	R_m 1050	36									
H	Hardened steel		hardened and tempered	55 HRC	37	80	105	140	1	65	90	120	1	
			hardened and tempered	60 HRC	38									
	Hard cast iron		cast	400	39	105	140	185	1	85	120	160	1	
	Hardened cast iron		hardened and tempered	55 HRC	40									
X	Non-metallic materials	Thermoplasts			41									
		Thermosetting plastics			42									
		Plastic, glass-fibre reinforced GFRP			43									
		Plastic, carbon fibre reinforced CFRP			44									
		Graphite			45									
		Wood			46									

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
Feed rate recommendations on page 22.



Recommended feed rate

Solid carbide milling group 1 – Square shoulder mills EPM series

	a_e / D	Feed rate per cutting edge (f_z) [mm]																	
		Ø0,5	Ø0,8	Ø 1	Ø 2	Ø 3	Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12	Ø 14	Ø 16	Ø 18	Ø 20			
P	1/1	0,01	0,02	0,02	0,02	0,02	0,02	0,03	0,03	0,05	0,07	0,08	0,08	0,09	0,09	0,10			
	1/2	0,01	0,03	0,03	0,03	0,03	0,03	0,04	0,04	0,06	0,09	0,10	0,10	0,12	0,12	0,13			
	1/10	0,02	0,05	0,05	0,05	0,05	0,05	0,07	0,07	0,09	0,14	0,16	0,16	0,18	0,18	0,20			
M	1/1	0,01	0,02	0,02	0,02	0,02	0,02	0,03	0,03	0,04	0,05	0,06	0,06	0,07	0,07	0,08			
	1/2	0,01	0,02	0,02	0,02	0,02	0,02	0,04	0,04	0,05	0,07	0,08	0,08	0,10	0,10	0,11			
	1/10	0,02	0,04	0,04	0,04	0,04	0,04	0,05	0,05	0,07	0,11	0,13	0,13	0,15	0,15	0,16			
K	1/1	0,01	0,02	0,02	0,02	0,02	0,02	0,03	0,03	0,05	0,07	0,08	0,08	0,09	0,09	0,10			
	1/2	0,01	0,03	0,03	0,03	0,03	0,03	0,04	0,04	0,06	0,09	0,10	0,10	0,12	0,12	0,13			
	1/10	0,02	0,05	0,05	0,05	0,05	0,05	0,07	0,07	0,09	0,14	0,16	0,16	0,18	0,18	0,20			
H	1/1	0,01	0,02	0,02	0,02	0,02	0,02	0,03	0,03	0,04	0,05	0,06	0,06	0,07	0,07	0,08			
	1/2	0,01	0,02	0,02	0,02	0,02	0,02	0,04	0,04	0,05	0,07	0,08	0,08	0,10	0,10	0,11			
	1/10	0,02	0,04	0,04	0,04	0,04	0,04	0,05	0,05	0,07	0,11	0,13	0,13	0,15	0,15	0,16			

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

Solid carbide milling group 5 – Ball nose cutters EPM series

	a_e / D	Feed rate per cutting edge (f_z) [mm]																	
		Ø0,5	Ø0,8	Ø 1	Ø 2	Ø 3	Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12	Ø 14	Ø 16	Ø 18	Ø 20			
P	1/1																		
	1/10	0,02	0,05	0,05	0,05	0,05	0,05	0,07	0,07	0,09	0,14	0,16	0,16	0,18	0,18	0,20			
	1/20	0,03	0,06	0,06	0,06	0,06	0,06	0,08	0,08	0,11	0,17	0,20	0,20	0,23	0,23	0,25			
M	1/1																		
	1/10	0,02	0,04	0,04	0,04	0,04	0,04	0,05	0,05	0,07	0,11	0,13	0,13	0,15	0,15	0,16			
	1/20	0,02	0,05	0,05	0,05	0,05	0,05	0,07	0,07	0,09	0,14	0,16	0,16	0,18	0,18	0,21			
K	1/1																		
	1/10	0,02	0,05	0,05	0,05	0,05	0,05	0,07	0,07	0,09	0,14	0,16	0,16	0,18	0,18	0,20			
	1/20	0,03	0,06	0,06	0,06	0,06	0,06	0,08	0,08	0,11	0,17	0,20	0,20	0,23	0,23	0,25			
H	1/1																		
	1/10	0,02	0,04	0,04	0,04	0,04	0,04	0,05	0,05	0,07	0,11	0,13	0,13	0,15	0,15	0,16			
	1/20	0,02	0,05	0,05	0,05	0,05	0,05	0,07	0,07	0,09	0,14	0,16	0,16	0,18	0,18	0,21			

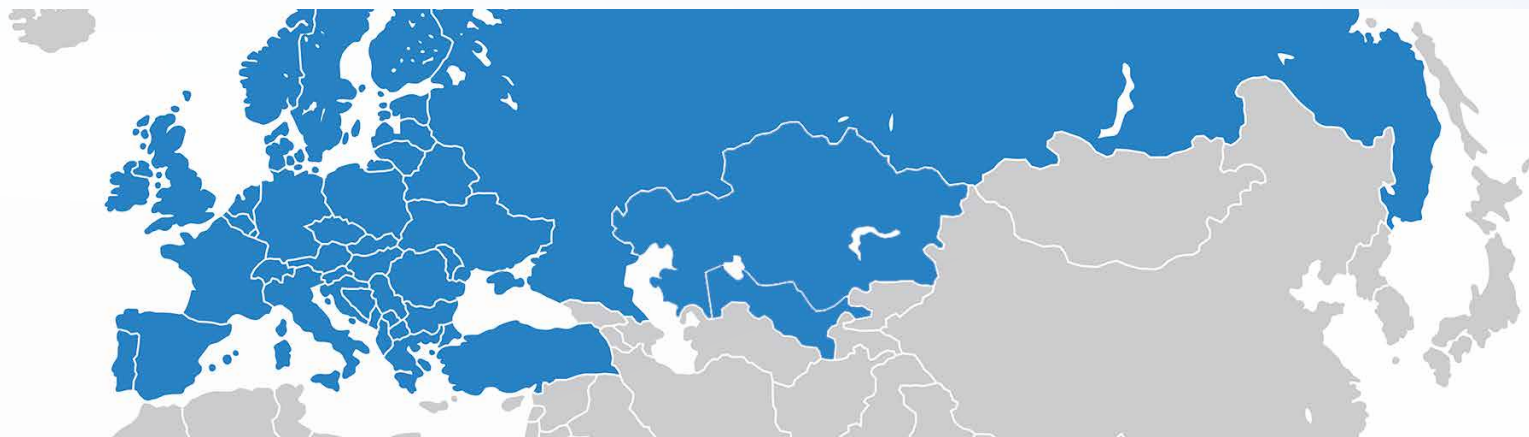
Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

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EPM solid carbide cutters



Regional office France

ZCC Cutting Tools Europe GmbH
Succursale Française

www.zccct-europe.com

14, Allée Charles Pathé, 18000 Bourges, France

Tel.:

ИМТ ГРУП ЕООД

Гр. Габрово

Ул. Любен Каравелов 16

Тел./Факс 066 860 048

Моб. 0887598796

E-mail : imtgroup@abv.bg