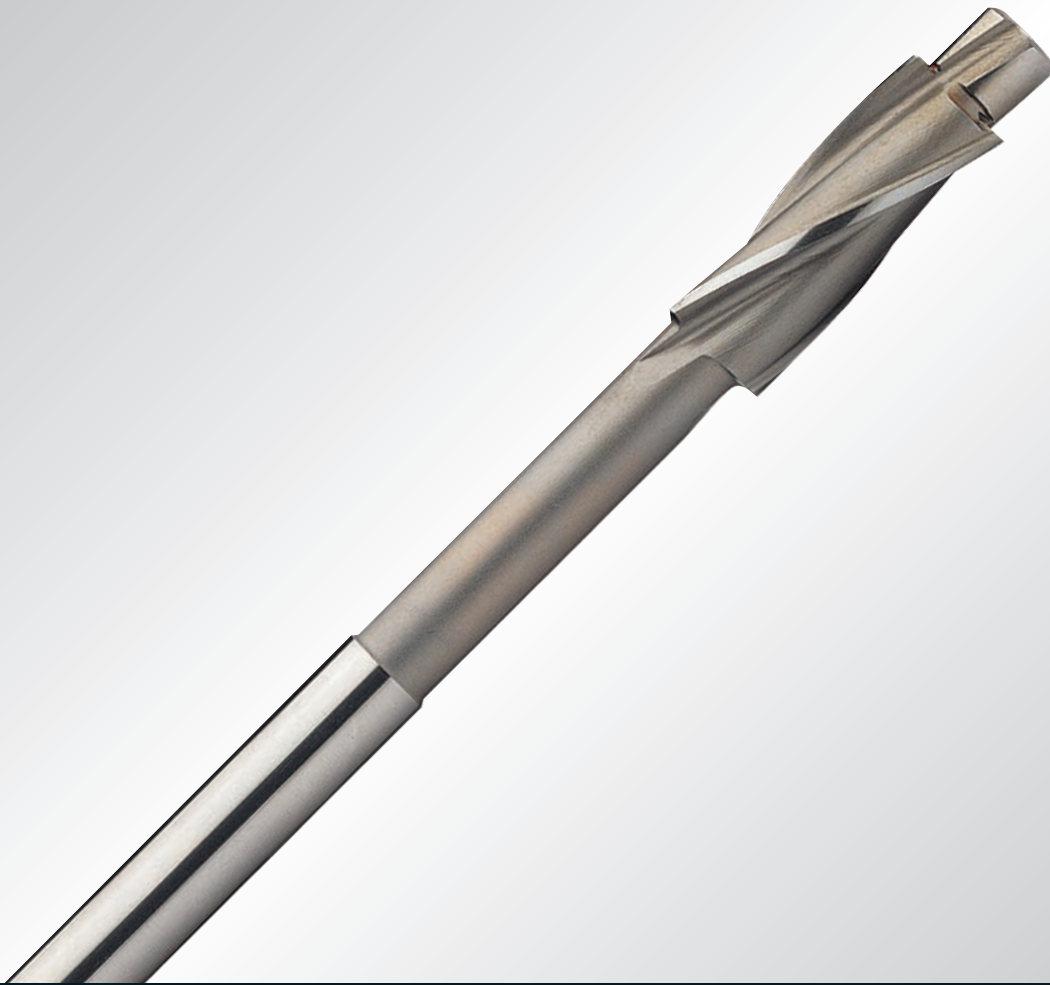


HSS



Being the best through innovation



COUNTERBORES

FLACHSENKER

- General Purpose
- Für allgemeinen Einsatz



COUNTERBORES

EL950 SERIES

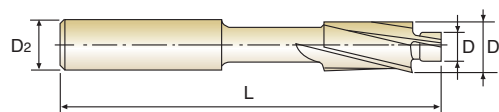
 PLAIN SHANK
GLATTER ZYLINDERSCHAFT

HSS-E, 3 FLUTE COUNTERBORES for 180° CAPSCREW

HSS-E, 3 SCHNEIDEN FLACHSENKER MIT FESTEM FÜHRUNGSZAPFEN

► The counterbores with solid pilot are designed for machining as fillister screw caps or ejector caps in molds.

► Die Flachsenker mit festem Führungszapfen dienen dem 180° Ansenken für Zylinderkopfschrauben und Auswerferstiften in Formen



P1339

MEDIUM

Unit : mm

EDP No.	ITEM No.	Screw Size	Pilot Diameter D(e8)	Cutter Diameter D1(z9)	Shank Diameter D2(h9)	Overall Length L
PLAIN	PLAIN					
EL950003	YG54M3-M	M3	3.4	6.0	5	71
EL950035	YG54M3.5-M	M3.5	3.9	6.5	5	71
EL950004	YG54M4-M	M4	4.5	8.0	5	71
EL950005	YG54M5-M	M5	5.5	10.0	8	80
EL950006	YG54M6-M	M6	6.6	11.0	8	80
EL950008	YG54M8-M	M8	9.0	15.0	12.5	100
EL950010	YG54M10-M	M10	11.0	18.0	12.5	100
EL950012	YG54M12-M	M12	14.0	20.0	12.5	100

FINE

Unit : mm

EDP No.	ITEM No.	Screw Size	Pilot Diameter D(e8)	Cutter Diameter D1(z9)	Shank Diameter D2(h9)	Overall Length L
PLAIN	PLAIN					
EL950901	YG54M3-F	M3	3.2	6.0	5	71
EL950902	YG54M3.5-F	M3.5	3.7	6.5	5	71
EL950903	YG54M4-F	M4	4.3	8.0	5	71
EL950904	YG54M5-F	M5	5.3	10.0	8	80
EL950905	YG54M6-F	M6	6.4	11.0	8	80
EL950906	YG54M8-F	M8	8.4	15.0	12.5	100
EL950907	YG54M10-F	M10	10.5	18.0	12.5	100
EL950908	YG54M12-F	M12	13.0	20.0	12.5	100

BEFORE THREADING

Unit : mm

EDP No.	ITEM No.	Screw Size	Pilot Diameter D(e8)	Cutter Diameter D1(z9)	Shank Diameter D2(h9)	Overall Length L
PLAIN	PLAIN					
EL950909	YG54M3-T	M3	2.5	6.0	5	71
EL950910	YG54M3.5-T	M3.5	2.9	6.5	5	71
EL950911	YG54M4-T	M4	3.3	8.0	5	71
EL950912	YG54M5-T	M5	4.2	10.0	8	80
EL950913	YG54M6-T	M6	5.0	11.0	8	80
EL950914	YG54M8-T	M8	6.8	15.0	12.5	100
EL950915	YG54M10-T	M10	8.5	18.0	12.5	100
EL950916	YG54M12-T	M12	10.2	20.0	12.5	100

Tolerances according to DIN 7160 & 7161

Toleranzen nach DIN 7160 & 7161

Nominal-Diameter in mm / Nennmaßbereich in mm				
	from 1 to 3 von 1 bis 3	over 3 to 6 über 3 bis 6	over 6 to 10 über 6 bis 10	over 10 to 18 über 10 bis 18
Tolerance range in μm / Toleranzwerte in μm				
e8	-14 -28	-20 -38	-25 -47	-32 -59
h9	0 -25	0 -30	0 -36	0 -43

Nominal-Diameter in mm / Nennmaßbereich in mm				
	from 6 to 10 von 6 bis 10	over 10 to 14 über 10 bis 14	over 14 to 18 über 14 bis 18	over 18 to 24 über 18 bis 24
Tolerance range in μm / Toleranzwerte in μm				
z9	+78 +42	+93 +50	+103 +60	+125 +73

HSS-E, 3 FLUTE COUNTERBORES for 180° CAPSCREW
HSS-E, 3 SCHNEIDEN FLACHSENKER mit FESTEM FÜHRUNGZAPFEN
EL950 SERIES

MATERIAL	ALUMINUM & ALUMINUM ALLOYS	CARBON STEELS ALLOY STEELS	CARBON STEELS ALLOY STEELS TOOL STEELS	CARBON STEELS ALLOY STEELS TOOL STEELS	CARBON STEELS ALLOY STEELS TOOL STEELS
HARDNESS			~ HRc20	HRc20 ~ HRc35	HRc35 ~ HRc40
STRENGTH		~ 500N/mm ²	500 ~ 800N/mm ²	800 ~ 1100N/mm ²	1100 ~ 1300N/mm ²
CUTTER DIAMETER	RPM	RPM	RPM	RPM	RPM
6.0	2100	590	480	380	320
6.5	2100	590	480	380	320
8.0	1700	470	380	300	250
10.0	1200	380	320	260	170
11.0	1100	300	240	190	160
15.0	840	240	195	155	130
18.0	670	190	160	120	80
20.0	550	160	125	95	70

RPM = rev./min.