

■ Series 5W1S • VariMill II Long

Material Group													
	Side Milling (A)		AITiN-MT		Recommended feed per tooth (IPT = inch/th) for side milling (A).								
	A		Cutting Speed – vc SFM		frac.	D1 – Diameter							
	ap	ae	min	max		dec.	1/4	5/16	3/8	1/2	5/8	3/4	1
P	1	Ap1 max	0.05 x D*	990	1320	IPT	.0018	.0023	.0027	.0035	.0039	.0043	.0050
	2	Ap1 max	0.05 x D*	924	1254	IPT	.0018	.0023	.0027	.0035	.0039	.0043	.0050
	3	Ap1 max	0.05 x D*	792	1056	IPT	.0015	.0020	.0023	.0029	.0034	.0038	.0046
	4	Ap1 max	0.05 x D*	594	990	IPT	.0014	.0018	.0020	.0026	.0030	.0033	.0039
	5	Ap1 max	0.05 x D*	396	660	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0036
	6	Ap1 max	0.05 x D*	330	495	IPT	.0010	.0013	.0015	.0019	.0022	.0024	.0028
M	1	Ap1 max	0.05 x D*	594	759	IPT	.0015	.0020	.0023	.0029	.0034	.0038	.0046
	2	Ap1 max	0.05 x D*	396	528	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0036
	3	Ap1 max	0.05 x D*	396	462	IPT	.0010	.0013	.0015	.0019	.0022	.0024	.0028
K	1	Ap1 max	0.05 x D*	792	990	IPT	.0018	.0023	.0027	.0035	.0039	.0043	.0050
	2	Ap1 max	0.05 x D*	726	858	IPT	.0015	.0020	.0028	.0029	.0034	.0038	.0046
	3	Ap1 max	0.05 x D*	660	858	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0036
S	1	Ap1 max	0.05 x D*	330	594	IPT	.0015	.0020	.0028	.0029	.0034	.0038	.0046
	2	Ap1 max	0.05 x D*	165	264	IPT	.0008	.0010	.0012	.0016	.0018	.0020	.0025
	3	Ap1 max	0.05 x D*	396	528	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0036
	4	Ap1 max	0.05 x D*	330	396	IPT	.0011	.0014	.0017	.0022	.0025	.0028	.0033
H	1	Ap1 max	0.05 x D*	462	528	IPT	.0014	.0018	.0020	.0026	.0030	.0033	.0039

High-Performance Solid Carbide End Mills

*For the above cutting data, do not exceed an overall ae of .032".

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.

Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.

Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.