

■ ABDE... • ABDF...

Material Group	Side Milling (A) and Slotting (B)		K600		Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%.											
	A	B	Cutting Speed — vc m/min		mm	D1 — Diameter										
	ap	ae	ap	mm		max	1.5	2.0	4.0	6.0	8.0	10.0	12.0	16.0	20.0	
N	1	1.5 x D	0.5 x D	1.0 x D	500	2000	fz	0.014	0.018	0.036	0.054	0.072	0.090	0.108	0.144	0.180
	2	1.5 x D	0.5 x D	1.0 x D	500	1500	fz	0.012	0.016	0.032	0.049	0.065	0.081	0.097	0.130	0.162
N	3	1.5 x D	0.5 x D	1.0 x D	500	1500	fz	0.009	0.013	0.025	0.038	0.050	0.063	0.076	0.101	0.126
	4	1.5 x D	0.5 x D	1.0 x D	400	750	fz	0.009	0.013	0.025	0.038	0.050	0.063	0.076	0.101	0.126
	5	1.5 x D	0.5 x D	1.0 x D	250	1000	fz	0.012	0.016	0.032	0.049	0.065	0.081	0.097	0.130	0.162

NOTE: These guidelines may require variations to achieve optimum results. For better surface finish, reduce feed per tooth.
For cutting aluminium with high silicon, TiCN coating is recommended.
Ap for milling machine with ceramic bearings spindle, multiply by 0.5.
For better surface finish, reduce feed per tooth.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For tools with reach >3 x D, reduce fz by 20%.
For tools with reach >5 x D, reduce fz by 30%.
For tools with reach >10 x D, reduce vc and fz by 30%.

■ ABDE... • Extended Neck

Material Group	Side Milling (A) and Slotting (B)		K600		Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%.										
	A	B	Cutting Speed — vc m/min		mm	D1 — Diameter									
	ap	ae	ap	mm		max	6.0	8.0	16.0	12.0	16.0	20.0			
N	1	1 x D	0.5 x D	1.0 x D	500	2000	fz	0.060	0.080	0.100	0.120	0.160	0.200		
	2	1 x D	0.5 x D	1.0 x D	500	1500	fz	0.054	0.072	0.090	0.108	0.144	0.180		
N	3	1 x D	0.5 x D	1.0 x D	500	1500	fz	0.042	0.056	0.070	0.084	0.112	0.140		
	4	1 x D	0.5 x D	1.0 x D	400	750	fz	0.042	0.056	0.070	0.084	0.112	0.140		
	5	1 x D	0.5 x D	1.0 x D	250	1000	fz	0.054	0.072	0.090	0.108	0.144	0.180		

NOTE: These guidelines may require variations to achieve optimum results. For better surface finish, reduce feed per tooth.
For cutting aluminium with high silicon, TiCN coating is recommended.
Ap for milling machine with ceramic bearings spindle, multiply by 0.5.
For better surface finish, reduce feed per tooth.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameter.
For tools with reach >3 x D, reduce fz by 20%.
For tools with reach >5 x D, reduce fz by 30%.
For tools with reach >10 x D, reduce vc and fz by 30%.

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