

SOLID CARBIDE

INSERTS

FACE MILLS

90° MILLS

SLOTTING

DIE AND MOLD

CERAMIC MILLS

CLASSIC MILLS

THREAD MILLS

TECHNICAL DATA

INDEX

F4AL...AWM/L/X30L...

| | | | Reduce speed by 20% for slotting applications | | | | | | |
|-------|-------------|--------|---|---|-------|-------|-------|-------|-------|
| | Application | | Vc KC637M | Recommended fz- Feed Per Tooth (mm/th) for side cutting operations. For slotting operations, reduce fz by 20%. | | | | | |
| | 3D Milling | | | D1 - Diameter (mm) | | | | | |
| Group | ap | ae | m/min | 3 | 4 | 5 | 6 | 8 | 10 |
| P4 | 0.05XD | 0.05XD | 245 | 0,060 | 0,060 | 0,075 | 0,090 | 0,140 | 0,160 |
| P5 | 0.05XD | 0.05XD | 160 | 0,050 | 0,050 | 0,065 | 0,080 | 0,120 | 0,135 |
| P6 | 0.05XD | 0.05XD | 160 | 0,050 | 0,050 | 0,065 | 0,080 | 0,120 | 0,135 |
| M1 | 0.05XD | 0.05XD | 190 | 0,050 | 0,050 | 0,065 | 0,080 | 0,120 | 0,135 |
| K1 | 0.05XD | 0.05XD | 410 | 0,080 | 0,080 | 0,100 | 0,120 | 0,180 | 0,200 |
| K2 | 0.05XD | 0.05XD | 400 | 0,080 | 0,080 | 0,100 | 0,120 | 0,180 | 0,200 |
| H1 | 0.05XD | 0.05XD | 245 | 0,060 | 0,060 | 0,075 | 0,090 | 0,140 | 0,160 |
| H2 | 0.05XD | 0.05XD | 190 | 0,050 | 0,050 | 0,065 | 0,080 | 0,120 | 0,135 |
| H3 | 0.05XD | 0.05XD | 150 | 0,050 | 0,050 | 0,065 | 0,080 | 0,120 | 0,135 |
| H4 | 0.05XD | 0.05XD | 105 | 0,050 | 0,050 | 0,065 | 0,080 | 0,120 | 0,135 |

These guidelines may require possible variations to achieve optimum results.

F2AL...AWS/M/L00...

| | | | Reduce speed by 20% for slotting applications | | | | | | |
|-------|-------------|--------|---|---|-------|-------|-------|-------|-------|
| | Application | | Vc KC637M | Recommended fz- Feed Per Tooth (mm/th) for side cutting operations. For slotting operations, reduce fz by 20%. | | | | | |
| | 3D Milling | | | D1 - Diameter (mm) | | | | | |
| Group | ap | ae | m/min | 4 | 5 | 6 | 8 | 10 | 12 |
| P4 | 0.05XD | 0.05XD | 260 | 0,060 | 0,075 | 0,090 | 0,140 | 0,160 | 0,180 |
| P5 | 0.05XD | 0.05XD | 170 | 0,050 | 0,065 | 0,080 | 0,120 | 0,135 | 0,150 |
| P6 | 0.05XD | 0.05XD | 170 | 0,050 | 0,065 | 0,080 | 0,120 | 0,135 | 0,150 |
| M1 | 0.05XD | 0.05XD | 200 | 0,050 | 0,065 | 0,080 | 0,120 | 0,135 | 0,150 |
| K1 | 0.05XD | 0.05XD | 430 | 0,080 | 0,100 | 0,120 | 0,180 | 0,200 | 0,220 |
| K2 | 0.05XD | 0.05XD | 410 | 0,080 | 0,100 | 0,120 | 0,180 | 0,200 | 0,220 |
| H1 | 0.05XD | 0.05XD | 260 | 0,060 | 0,075 | 0,090 | 0,140 | 0,160 | 0,180 |
| H2 | 0.05XD | 0.05XD | 200 | 0,050 | 0,065 | 0,080 | 0,120 | 0,135 | 0,150 |
| H3 | 0.05XD | 0.05XD | 160 | 0,050 | 0,065 | 0,080 | 0,120 | 0,135 | 0,150 |
| H4 | 0.05XD | 0.05XD | 115 | 0,050 | 0,065 | 0,080 | 0,120 | 0,135 | 0,150 |