

F1AA...AWS/M30...

			Reduce speed by 20% for slotting applications											
Application			Vc K600			Recommended fz- Feed Per Tooth (mm/th) for side cutting operations. For slotting operations, reduce fz by 20%.								
Side Milling		Slotting				D1 - Diameter (mm)								
Group	ap	ae	ap	m/min			2	3	4	5	6	8	10	12
N1	1XD	0.5XD	0.7XD	465			0,020	0,030	0,040	0,050	0,060	0,075	0,100	0,110
N2	1XD	0.5XD	0.7XD	410			0,020	0,030	0,040	0,050	0,060	0,075	0,100	0,110

These guidelines may require possible variations to achieve optimum results.

F2AA...ADL45...

			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%.									
Side Milling		Slotting				D1 - Diameter (mm)									
Group	ap	ae	ap	m/min			4	6	8	10	12	14	16	18	20
N1	1XD	0.5XD	0.7XD	465			650	0,020	0,030	0,040	0,050	0,060	0,075	0,100	0,110
N2	1XD	0.5XD	0.7XD	410			575	0,020	0,030	0,040	0,050	0,060	0,075	0,100	0,110

F2AA...AWM/L/X45R...

			Reduce speed by 20% for slotting applications											
Application			Vc K600			Recommended fz- Feed Per Tooth (mm/th) for side cutting operations. For slotting operations, reduce fz by 20%.								
Side Milling		Slotting				D1 - Diameter (mm)								
Group	ap	ae	ap	m/min			6	8	10	12	16	18	20	25
N1	1XD	0.5XD	0.7XD	465			0,030	0,040	0,050	0,060	0,100	0,110	0,120	0,200
N2	1XD	0.5XD	0.7XD	410			0,030	0,040	0,050	0,060	0,100	0,110	0,120	0,200

F3AA...AWS/L45...

			Reduce speed by 20% for slotting applications												
Application			Vc K600			Recommended fz- Feed Per Tooth (mm/th) for side cutting operations. For slotting operations, reduce fz by 20%.									
Side Milling		Slotting				D1 - Diameter (mm)									
Group	ap	ae	ap	m/min			4	6	8	10	12	14	16	18	20
N1	1XD	0.5XD	0.7XD	465			0,020	0,030	0,040	0,050	0,060	0,075	0,100	0,110	0,120
N2	1XD	0.5XD	0.7XD	410			0,020	0,030	0,040	0,050	0,060	0,075	0,100	0,110	0,120