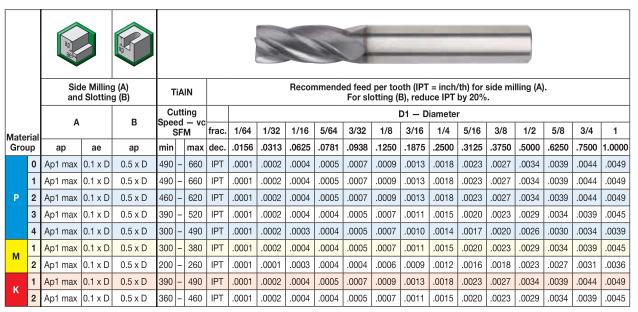
#### ■ Series I4C..S I4S..S I4C..R I4S..R • TiAIN • VariMill GP



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.

### ■ Series I4C..S I4S..S I4C..R I4S..R • Uncoated • VariMill GP

		ap 1 ag Ca		ap																
			Side Milling (A) and Slotting (B)				uncoated Recommended feed per tooth (IPT = inch/th) for side milling (A).  For slotting (B), reduce IPT by 20%.													
Material Group			А			Cutting Speed – vc SFM			D1 — Diameter											
								frac.	1/16	5/64	3/32	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
			ae	ар	min		max	dec.	.0625	.0781	.0938	.1250	.1875	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
		O Ap1 max	0.1 x D	0.5 x D	390	-	520	IPT	.0004	.0005	.0007	.0009	.0013	.0018	.0023	.0027	.0034	.0039	.0044	.0049
ı	, [	1 1.25 x D	0.1 x D	0.5 x D	390	-	520	IPT	.0004	.0005	.0007	.0009	.0013	.0018	.0023	.0027	.0034	.0039	.0044	.0049
		2 1.25 x D	0.1 x D	0.5 x D	370	-	500	IPT	.0004	.0005	.0007	.0009	.0013	.0018	.0023	.0027	.0034	.0039	.0044	.0049

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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.



# Application Data • Series I4C..L I4S..L I4C..X I4S..X • VariMill™ GP

## Series I4C..L I4S..L I4C..X I4S..X • TiAIN • VariMill GP

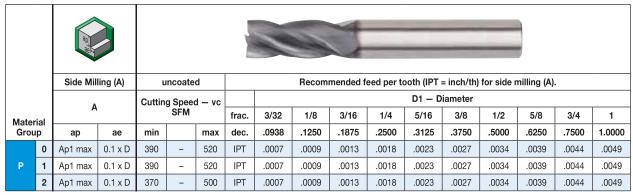
		Sido Mill	ling (A)		TiAIN Recommended feed per tooth (IPT = inch/th) for side milling (A).														
Material Group		Side Milling (A)		Cutting Speed - vc SFM				Recommended feed per tooth (IPT = inch/th) for side milling (A).  D1 — Diameter											
							frac.	3/32	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1		
		ар	ae	min		max	dec.	.0938	.1250	.1875	.2500	.3125	.3750	.5000	.6250	.7500	1.0000		
	0	Ap1 max	0.1 x D	490	-	660	IPT	.0007	.0009	.0013	.0018	.0023	.0027	.0034	.0039	.0044	.0049		
	1	Ap1 max	0.1 x D	490	-	660	IPT	.0007	.0009	.0013	.0018	.0023	.0027	.0034	.0039	.0044	.0049		
Р	2	Ap1 max	0.1 x D	460	-	620	IPT	.0007	.0009	.0013	.0018	.0023	.0027	.0034	.0039	.0044	.0049		
	3	Ap1 max	0.1 x D	390	_	520	IPT	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045		
	4	Ap1 max	0.1 x D	300	-	490	IPT	.0005	.0007	.0010	.0014	.0017	.0020	.0026	.0030	.0034	.0039		
м	1	Ap1 max	0.1 x D	300	-	380	IPT	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045		
IVI	2	Ap1 max	0.1 x D	200	-	260	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036		
К	1	Ap1 max	0.1 x D	390	-	490	IPT	.0007	.0009	.0013	.0018	.0023	.0027	.0034	.0039	.0044	.0049		
, ,	2	Ap1 max	0.1 x D	360	_	460	IPT	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045		

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.

## ■ Series I4C..L I4S..L I4C..X I4S..X • Uncoated • VariMill GP



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.