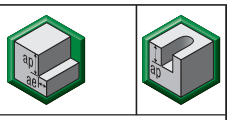
Series 022814 022817



Material Group		Side Milling (A) and Slotting (B)			K10F uncoated				Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.									
		A		B	Cutting Speed — vc m/min				D1 — Diameter									
		ap	ae	ap	min		max	mm	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0
N	1	1,5 x D	0,5 x D	1 x D	500	–	2000	fz	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180
	2	1,5 x D	0,5 x D	1 x D	500	–	1500	fz	0,032	0,041	0,049	0,065	0,081	0,097	0,113	0,130	0,146	0,162
	3	1,5 x D	0,5 x D	1 x D	500	–	1500	fz	0,025	0,032	0,038	0,050	0,063	0,076	0,088	0,101	0,113	0,126
	4	1,5 x D	0,5 x D	1 x D	400	–	750	fz	0,029	0,036	0,043	0,058	0,072	0,086	0,101	0,115	0,130	0,144
	5	1,5 x D	0,5 x D	1 x D	250	–	1000	fz	0,032	0,041	0,049	0,065	0,081	0,097	0,113	0,130	0,146	0,162

NOTE: Multiply ap for milling machine spindle with ceramic bearings 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 diameters >12mm.

Series 4102



Material Group		Side Milling (A) and Slotting (B)			uncoated				Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.									
		A		B	Cutting Speed — vc m/min				D1 — Diameter									
		ap	ae	ap	min		max	mm	1,5	2,0	3,0	4,0	6,0	8,0	10,0	12,0	16,0	18,0	20,0
N	1	1,5 x D	0,5 x D	1 x D	500	–	2000	fz	0,014	0,018	0,027	0,036	0,054	0,072	0,090	0,108	0,144	0,162	0,180
	2	1,5 x D	0,5 x D	1 x D	500	–	1500	fz	0,012	0,016	0,024	0,032	0,049	0,065	0,081	0,097	0,130	0,146	0,162
	3	1,5 x D	0,5 x D	1 x D	500	–	1500	fz	0,009	0,013	0,019	0,025	0,038	0,050	0,063	0,076	0,101	0,113	0,126
	4	1,5 x D	0,5 x D	1 x D	400	–	750	fz	0,011	0,014	0,022	0,029	0,043	0,058	0,072	0,086	0,115	0,130	0,144
	5	1,5 x D	0,5 x D	1 x D	250	–	1000	fz	0,012	0,016	0,024	0,032	0,049	0,065	0,081	0,097	0,130	0,146	0,162

NOTE: Multiply ap for milling machine spindle with ceramic bearings 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 diameters >12mm.