

■ Series 4103

Material Group	Side Milling (A) and Slotting (B)			uncoated		TiCN		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			Cutting Speed – vc m/min			D1 – Diameter									
	ap	ae	ap	min		max	min		max	mm	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0	
	N	1	1 x D	0,5 x D	0,7 x D	500	–	2000	500	–	2000	fz	0,027	0,036	0,054	0,072	0,090	0,108	0,144
	2	1 x D	0,5 x D	0,7 x D	500	–	1500	500	–	1500	fz	0,024	0,032	0,049	0,065	0,081	0,097	0,130	0,162

NOTE: For cutting aluminium with high silicon, TiCN coating is recommended.
 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.

Application Data • Series 4909

■ Series 4909

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	max	6,0	8,0	10,0	12,0	16,0	20,0	25,0		
	N	1	1,5 x D	0,5 x D	1 x D	500	–	2000	fz	0,066	0,088	0,110	0,132	0,176	0,220	0,275
	2	1,5 x D	0,5 x D	1 x D	500	–	1500	fz	0,059	0,079	0,099	0,119	0,158	0,198	0,248	

NOTE: For cutting aluminium with high silicon TiCN coating is recommended.
 Multiply ap for milling machine spindle with ceramic bearings by 0,5.
 Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on diameters >12mm.