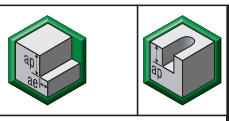
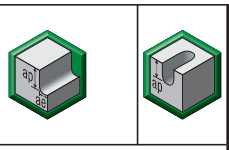
Series 4A0R



Material Group		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%.							
		A		B	Cutting Speed — vc SFM				D1 — Diameter						
								frac.	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min		max	dec.	.2500	.3125	.3750	.5000	.6250	.7500	1.000
N	1	1.5 x D	0.5 x D	1 x D	1640	–	6560	IPT	.0030	.0038	.0045	.0060	.0075	.0090	.0120
	2	1.5 x D	0.5 x D	1 x D	1640	–	4920	IPT	.0024	.0030	.0036	.0048	.0060	.0072	.0096
	3	1.5 x D	0.5 x D	1 x D	1640	–	4920	IPT	.0021	.0026	.0032	.0042	.0053	.0063	.0084
	4	1.5 x D	0.5 x D	1 x D	1310	–	2460	IPT	.0021	.0026	.0032	.0042	.0053	.0063	.0084
	5	1.5 x D	0.5 x D	1 x D	820	–	3280	IPT	.0027	.0034	.0041	.0054	.0068	.0081	.0108

NOTE: Side milling applications — For longest reach (L3) tools, reduce ae by 30%.
Slot milling applications — For longest reach (L3) tools, reduce ap by 30%.
For cutting aluminum with high silicon, coating is recommended.
For spindles with ceramic bearings, multiply ap by 0.5.
For better surface finish, reduce feed per tooth.
Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on diameters >1/2".

Series 4A0B



Material Group		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%.							
		A		B	Cutting Speed — vc SFM				D1 — Diameter						
								frac.	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min		max	dec.	.2500	.3125	.3750	.5000	.6250	.7500	1.000
N	1	1.5 x D	0.5 x D	1 x D	1640	–	6560	IPT	.0028	.0034	.0041	.0055	.0069	.0083	.0110
	2	1.5 x D	0.5 x D	1 x D	1640	–	4920	IPT	.0022	.0028	.0033	.0044	.0055	.0066	.0088
	3	1.5 x D	0.5 x D	1 x D	1640	–	4920	IPT	.0019	.0024	.0029	.0039	.0048	.0058	.0077
	4	1.5 x D	0.5 x D	1 x D	1310	–	2460	IPT	.0019	.0024	.0029	.0039	.0048	.0058	.0077
	5	1.5 x D	0.5 x D	1 x D	820	–	3280	IPT	.0025	.0031	.0037	.0050	.0062	.0074	.0099

NOTE: For cutting aluminum with high silicon, coating is recommended.
For spindles with ceramic bearings, multiply ap by 0.5.
For better surface finish, reduce feed per tooth.
Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on diameters >1/2".