

■ Series 4AN2 4AN3 4AP2 4AP3

Material Group								Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.									
	Side Milling (A) and Slotting (B)			uncoated			D1 – Diameter										
	A		B	Cutting Speed – vc SFM			frac.	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	
	ap	ae	ap	min		max	dec.	.125	.188	.250	.313	.375	.500	.625	.750	1.000	
N	1	1 x D	0.5 x D	1.0 x D	1640	–	6560	IPT	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	1 x D	0.5 x D	1.0 x D	1640	–	4920	IPT	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	3	1 x D	0.5 x D	1.0 x D	1640	–	4920	IPT	.0009	.0013	.0018	.0022	.0026	.0035	.0044	.0053	.0070
	4	1 x D	0.5 x D	1.0 x D	1310	–	2460	IPT	.0009	.0013	.0018	.0022	.0026	.0035	.0044	.0053	.0070
	5	1 x D	0.5 x D	1.0 x D	820	–	3280	IPT	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090

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".

Application Data • Series 4B02

■ Series 4B02

Material Group								Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.							
	For Side Milling (A) and Slotting (B)			uncoated			D1 – Diameter								
	A		B	Cutting Speed – vc SFM			frac.	1/4	5/16	3/8	1/2	5/8	3/4	1	
	ap	ae	ap	min		max	dec.	.250	.313	.375	.500	.625	.750	1.000	
N	1	1 x D	0.5 x D	1.5 x D	1600	–	6500	IPT	.0100	.0150	.0200	.0300	.0350	.0450	.0500
	2	1 x D	0.5 x D	1.5 x D	1600	–	4500	IPT	.0100	.0150	.0030	.0300	.0350	.0450	.0500

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".