

Series 4C03

Material Group																								
	Side Milling (A) and Slotting (B)			uncoated		TiCN		TiAlN		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.														
	A		B	Cutting Speed – vc SFM		Cutting Speed – vc SFM		Cutting Speed – vc SFM		D1 – Diameter														
	ap	ae	ap	min	max	min	max	min	max	frac.	1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1				
P	0	1.5 x D	0.3 x D	0.5 x D	245	–	330	392	–	528	490	–	660	IPT	.0088	.0135	.0183	.0234	.0273	.0308	.0340	.0395	.0438	.0489
	1	1.5 x D	0.3 x D	0.5 x D	245	–	330	392	–	528	490	–	660	IPT	.0088	.0135	.0183	.0234	.0273	.0308	.0340	.0395	.0438	.0489
	2	1.5 x D	0.3 x D	0.5 x D	230	–	310	368	–	496	460	–	620	IPT	.0088	.0135	.0183	.0234	.0273	.0308	.0340	.0395	.0438	.0489
	3	1.5 x D	0.3 x D	0.5 x D	195	–	260	312	–	416	390	–	520	IPT	.0072	.0111	.0152	.0195	.0229	.0260	.0289	.0341	.0386	.0451
	4	1.5 x D	0.3 x D	0.3 x D	150	–	245	240	–	392	300	–	490	IPT	.0066	.0101	.0138	.0175	.0204	.0231	.0257	.0301	.0337	.0386
	5	1.5 x D	0.3 x D	0.5 x D	100	–	165	160	–	264	200	–	330	IPT	.0059	.0091	.0123	.0156	.0183	.0208	.0231	.0273	.0309	.0361
M	1	1.5 x D	0.3 x D	0.5 x D	150	–	190	240	–	304	300	–	380	IPT	.0072	.0111	.0152	.0195	.0229	.0260	.0289	.0341	.0386	.0451
	2	1.5 x D	0.3 x D	0.5 x D	100	–	130	160	–	208	200	–	260	IPT	.0059	.0091	.0123	.0156	.0183	.0208	.0231	.0273	.0309	.0361
	3	1.5 x D	0.3 x D	0.5 x D	100	–	115	160	–	184	200	–	230	IPT	.0050	.0076	.0103	.0131	.0153	.0173	.0191	.0223	.0249	.0281
K	1	1.5 x D	0.3 x D	0.5 x D	195	–	245	312	–	392	390	–	490	IPT	.0088	.0135	.0183	.0234	.0273	.0308	.0340	.0395	.0438	.0489
	2	1.5 x D	0.3 x D	0.5 x D	180	–	230	288	–	368	360	–	460	IPT	.0072	.0111	.0152	.0195	.0229	.0260	.0289	.0341	.0386	.0451
	3	1.5 x D	0.3 x D	0.5 x D	180	–	215	288	–	344	360	–	430	IPT	.0059	.0091	.0123	.0156	.0183	.0208	.0231	.0273	.0309	.0361
S	1	1.5 x D	0.3 x D	0.3 x D	80	–	150	128	–	240	160	–	300	IPT	.0072	.0111	.0152	.0195	.0229	.0260	.0289	.0341	.0386	.0451
	2	1.5 x D	0.3 x D	0.3 x D	40	–	65	64	–	104	80	–	130	IPT	.0039	.0060	.0081	.0103	.0121	.0138	.0153	.0182	.0206	.0243
	3	1.5 x D	0.3 x D	0.3 x D	100	–	130	160	–	208	200	–	260	IPT	.0059	.0091	.0123	.0156	.0183	.0208	.0231	.0273	.0309	.0361
	4	1.5 x D	0.3 x D	0.5 x D	80	–	100	128	–	160	160	–	200	IPT	.0048	.0077	.0108	.0143	.0168	.0191	.0213	.0251	.0284	.0331
H	1	1.5 x D	0.3 x D	0.3 x D	130	–	230	208	–	368	260	–	460	IPT	.0066	.0101	.0138	.0175	.0204	.0231	.0257	.0301	.0337	.0386

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.

High-Performance Solid Carbide End Mills