

■ Series 4S0F 4S1F

Material Group													
	Side Milling (A)		TiAlN			Recommended feed per tooth (IPT = inch/th) for side milling (A).							
	A		Cutting Speed – vc SFM			D1 – Diameter							
	ap	ae	min		max	frac.	1/4	3/8	1/2	5/8	3/4	1	
P	1	1.5 x D	0.07 x D	500	–	650	IPT	.0018	.0027	.0035	.0039	.0043	.0050
	2	1.5 x D	0.07 x D	450	–	625	IPT	.0018	.0027	.0035	.0039	.0043	.0050
	3	1.5 x D	0.07 x D	400	–	525	IPT	.0015	.0023	.0029	.0034	.0038	.0046
	4	1.5 x D	0.03 x D	300	–	475	IPT	.0014	.0020	.0026	.0030	.0033	.0039
	5	1.5 x D	0.05 x D	200	–	325	IPT	.0012	.0018	.0023	.0027	.0030	.0036
	6	1.5 x D	0.03 x D	150	–	225	IPT	.0010	.0015	.0019	.0022	.0024	.0028
M	1	1.5 x D	0.07 x D	260	–	330	IPT	.0015	.0023	.0029	.0034	.0038	.0046
	2	1.5 x D	0.07 x D	200	–	260	IPT	.0012	.0018	.0023	.0027	.0030	.0036
	3	1.5 x D	0.05 x D	200	–	260	IPT	.0010	.0015	.0019	.0022	.0024	.0028
K	1	1.5 x D	0.07 x D	390	–	520	IPT	.0018	.0027	.0035	.0039	.0043	.0050
	2	1.5 x D	0.07 x D	360	–	460	IPT	.0015	.0023	.0029	.0034	.0038	.0046
	3	1.5 x D	0.05 x D	330	–	430	IPT	.0012	.0018	.0023	.0027	.0030	.0036
S	1	1.5 x D	0.03 x D	150	–	275	IPT	.0015	.0023	.0029	.0034	.0038	.0046
	2	1.5 x D	0.02 x D	70	–	130	IPT	.0008	.0012	.0016	.0018	.0020	.0025
	3	1.5 x D	0.05 x D	160	–	260	IPT	.0012	.0018	.0023	.0027	.0030	.0036
	4	1.5 x D	0.05 x D	150	–	210	IPT	.0011	.0017	.0022	.0025	.0028	.0033
H	1	1.5 x D	0.03 x D	260	–	450	IPT	.0014	.0020	.0026	.0030	.0033	.0039

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.  
Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.

High-Performance Solid Carbide End Mills