

■ Series 4SOR • Victory Grades



Material Group	Side Milling (A) and Slotting (B)		WP15PE				Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.							
	A		B		Cutting Speed – vc SFM		frac.	D1 – Diameter						
	ap	ae	ap	min				max	dec.	1/4	3/8	1/2	5/8	3/4
	ap	ae	ap	min	max	dec.	.2500	.3750	.5000	.6250	.7500	1.0000		
P	0	1 x D	0.5 x D	0.5 x D	490	–	660	IPT	.0015	.0022	.0027	.0032	.0035	.0039
	1	1 x D	0.5 x D	0.5 x D	490	–	660	IPT	.0015	.0022	.0027	.0032	.0035	.0039
	2	1 x D	0.5 x D	0.5 x D	460	–	620	IPT	.0015	.0022	.0027	.0032	.0035	.0039
	3	1 x D	0.4 x D	0.5 x D	390	–	520	IPT	.0012	.0018	.0023	.0027	.0031	.0036
	4	1 x D	0.3 x D	0.4 x D	300	–	490	IPT	.0011	.0016	.0021	.0024	.0027	.0031
M	5	1 x D	0.4 x D	0.5 x D	200	–	330	IPT	.0010	.0015	.0019	.0022	.0025	.0029
	1	1 x D	0.4 x D	0.5 x D	300	–	380	IPT	.0012	.0018	.0023	.0027	.0031	.0036
	2	1 x D	0.4 x D	0.5 x D	200	–	260	IPT	.0010	.0015	.0019	.0022	.0025	.0029
K	3	1 x D	0.4 x D	0.5 x D	200	–	230	IPT	.0008	.0012	.0015	.0018	.0020	.0023
	1	1 x D	0.5 x D	0.5 x D	390	–	490	IPT	.0015	.0022	.0027	.0032	.0035	.0039
	2	1 x D	0.4 x D	0.5 x D	360	–	460	IPT	.0012	.0018	.0023	.0027	.0031	.0036
S	3	1 x D	0.4 x D	0.5 x D	360	–	430	IPT	.0010	.0015	.0019	.0022	.0025	.0029
	1	1 x D	0.5 x D	0.3 x D	160	–	300	IPT	.0012	.0018	.0023	.0027	.0031	.0036
H	3	1 x D	0.5 x D	0.4 x D	200	–	260	IPT	.0010	.0015	.0019	.0022	.0025	.0029
	1	1 x D	0.3 x D	0.3 x D	260	–	460	IPT	.0011	.0016	.0021	.0024	.0027	.0031

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