

Series 664W 660W 661W • WavCut I

| Material Group | | | | | | | | Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%. | | | | |
|----------------|---|-----------------------------------|---------|----------|-----|--------------------------|----|---|-------|-------|-------|-------|
| | | Side Milling (A) and Slotting (B) | | uncoated | | | | | | | | |
| | | A | | B | | Cutting Speed – vc m/min | | D1 – Diameter | | | | |
| | | ap | ae | ap | min | max | mm | 25,0 | 32,0 | 40,0 | 50,0 | |
| P | 5 | 1,5 x D | 0,4 x D | 1 x D | 10 | – | 14 | fz | 0,091 | 0,105 | 0,124 | 0,146 |
| M | 1 | 1,5 x D | 0,4 x D | 1 x D | 10 | – | 14 | fz | 0,114 | 0,131 | 0,155 | 0,182 |
| | 2 | 1,5 x D | 0,4 x D | 1 x D | 10 | – | 12 | fz | 0,091 | 0,105 | 0,124 | 0,146 |
| S | 3 | 1,5 x D | 0,4 x D | 0,75 x D | 6 | – | 11 | fz | 0,091 | 0,105 | 0,124 | 0,146 |
| | 4 | 1,5 x D | 0,4 x D | 0,75 x D | 6 | – | 11 | fz | 0,084 | 0,096 | 0,114 | 0,134 |

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 centres, please adjust parameters accordingly on diameters >12mm.

Application Data • Series 6N06

Series 6N06

| Material Group | | | | | | | | Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%. | | | | | | | | | | | | |
|----------------|---|-----------------------------------|---------|-------|-----|--------------------------|-----|---|----|---------------|-----|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | | Side Milling (A) and Slotting (B) | | TiCN | | TiAlN | | | | | | | | | | | | | | |
| | | A | | B | | Cutting Speed – vc m/min | | Cutting Speed – vc m/min | | D1 – Diameter | | | | | | | | | | |
| | | ap | ae | ap | min | max | min | max | mm | 6,0 | 8,0 | 10,0 | 12,0 | 16,0 | 18,0 | 20,0 | 25,0 | 30,0 | | |
| P | 1 | 1,5 x D | 0,5 x D | 1 x D | 56 | – | 64 | 70 | – | 80 | fz | 0,046 | 0,062 | 0,072 | 0,079 | 0,097 | 0,104 | 0,109 | 0,119 | 0,143 |
| | 2 | 1,5 x D | 0,5 x D | 1 x D | 48 | – | 64 | 60 | – | 80 | fz | 0,046 | 0,062 | 0,072 | 0,079 | 0,097 | 0,104 | 0,109 | 0,119 | 0,143 |
| | 3 | 1,5 x D | 0,5 x D | 1 x D | 40 | – | 56 | 50 | – | 70 | fz | 0,038 | 0,052 | 0,061 | 0,067 | 0,084 | 0,091 | 0,097 | 0,109 | 0,131 |
| | 5 | 1,5 x D | 0,5 x D | 1 x D | 20 | – | 28 | 25 | – | 35 | fz | 0,031 | 0,042 | 0,048 | 0,054 | 0,067 | 0,073 | 0,078 | 0,087 | 0,105 |
| M | 1 | 1,5 x D | 0,5 x D | 1 x D | 20 | – | 28 | 25 | – | 35 | fz | 0,038 | 0,052 | 0,061 | 0,067 | 0,084 | 0,091 | 0,097 | 0,109 | 0,131 |
| | 2 | 1,5 x D | 0,5 x D | 1 x D | 20 | – | 24 | 25 | – | 30 | fz | 0,031 | 0,042 | 0,048 | 0,054 | 0,067 | 0,073 | 0,078 | 0,087 | 0,105 |
| | 3 | 1,5 x D | 0,5 x D | 1 x D | 12 | – | 16 | 15 | – | 20 | fz | 0,026 | 0,035 | 0,040 | 0,045 | 0,055 | 0,059 | 0,062 | 0,068 | 0,082 |
| K | 1 | 1,5 x D | 0,5 x D | 1 x D | 56 | – | 64 | 70 | – | 80 | fz | 0,046 | 0,062 | 0,072 | 0,079 | 0,097 | 0,104 | 0,109 | 0,119 | 0,143 |
| | 2 | 1,5 x D | 0,5 x D | 1 x D | 40 | – | 56 | 50 | – | 70 | fz | 0,038 | 0,052 | 0,061 | 0,067 | 0,084 | 0,091 | 0,097 | 0,109 | 0,131 |
| S | 1 | 1,5 x D | 0,5 x D | 1 x D | 12 | – | 24 | 15 | – | 30 | fz | 0,038 | 0,052 | 0,061 | 0,067 | 0,084 | 0,091 | 0,097 | 0,109 | 0,131 |
| | 2 | 1,5 x D | 0,5 x D | 1 x D | 4 | – | 12 | 5 | – | 15 | fz | 0,021 | 0,027 | 0,032 | 0,036 | 0,045 | 0,048 | 0,052 | 0,059 | 0,071 |
| | 3 | 1,5 x D | 0,5 x D | 1 x D | 12 | – | 22 | 15 | – | 28 | fz | 0,031 | 0,042 | 0,048 | 0,054 | 0,067 | 0,073 | 0,078 | 0,087 | 0,105 |
| | 4 | 1,5 x D | 0,5 x D | 1 x D | 12 | – | 22 | 15 | – | 28 | fz | 0,027 | 0,038 | 0,045 | 0,050 | 0,062 | 0,067 | 0,071 | 0,080 | 0,096 |

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
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High-Performance High-Speed Steel (HSS-E/PM)