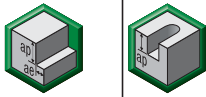



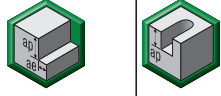

■ Series 6A0R

Material Group															
	Side Milling (A) and Slotting (B)			uncoated			TiCN			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			D1 – Diameter					
	ap	ae	ap	min		max	min		max	frac.	1/2	3/4	1	1 1/4	
N	1	1.25 x D	0.5 x D	1 x D	1050	–	1750	1500	–	2500	IPT	.0055	.0075	.0085	.0100
	2	1.25 x D	0.5 x D	1 x D	840	–	1400	1200	–	2000	IPT	.0050	.0068	.0077	.0090

NOTE: Side milling applications – For longest length tools, reduce ae by 30%.
 Slot milling applications – For longest length tools, reduce ap by 30%.
 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 diameters >1/2".

Application Data • Series 6ANR

■ Series 6ANR

Material Group												
	Side Milling (A) and Slotting (B)			TiCN			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.					
	A		B	Cutting Speed – vc SFM			D1 – Diameter					
	ap	ae	ap	min		max	frac.	1/2	3/4	1	1 1/4	
N	1	1 x D	0.3 x D	0.75 x D	1500	–	2500	IPT	.0055	.0075	.0085	.0100
	2	1 x D	0.3 x D	0.5 x D	1200	–	2000	IPT	.0050	.0068	.0077	.0090

NOTE: Side milling applications – For longest length tools, reduce ae by 30%.
 Slot milling applications – For longest length tools, reduce ap by 30%.
 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 diameters >1/2".