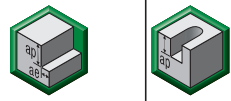



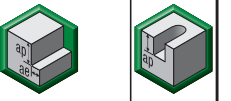

■ Series 7525 • Vision Plus

Material Group																		
	Side Milling (A) and Slotting (B)			TiAlN			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.											
	A		B	Cutting Speed – vc m/min			D1 – Diameter											
	ap	ae	ap	min	max	mm	3,0	4,0	5,0	6,0	8,0	10,0	12,0	16,0	20,0	25,0		
P	3	3 x D	0,2 x D	0,5 x D	160	–	180	fz	0,019	0,026	0,033	0,040	0,055	0,067	0,077	0,096	0,111	0,125
	4	3 x D	0,2 x D	0,3 x D	140	–	160	fz	0,017	0,024	0,030	0,036	0,049	0,059	0,069	0,084	0,097	0,107
H	1	3 x D	0,2 x D	0,3 x D	120	–	140	fz	0,017	0,024	0,030	0,036	0,049	0,059	0,069	0,084	0,097	0,107
	2	3 x D	0,15 x D	0,2 x D	80	–	130	fz	0,013	0,018	0,022	0,027	0,037	0,044	0,051	0,063	0,071	0,078
	3	3 x D	0,05 x D	–	70	–	100	fz	0,010	0,014	0,018	0,021	0,029	0,035	0,041	0,051	0,059	0,067
	4	3 x D	0,03 x D	–	50	–	70	fz	0,007	0,009	0,012	0,014	0,019	0,023	0,027	0,034	0,039	0,044

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.
For better surface finish, reduce feed per tooth.

Application Data • Series 7585 7595 • Vision Plus™

■ Series 7585 7595 • Vision Plus

Material Group																			
	Side Milling (A) and Slotting (B)			TiAlN			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.												
	A		B	Cutting Speed – vc m/min			D1 – Diameter												
	ap	ae	ap	min	max	mm	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0		
P	3	1 x D	0,4 x D	1 x D	120	–	160	fz	0,019	0,033	0,040	0,055	0,067	0,077	0,077	0,096	0,096	0,111	0,125
	4	1 x D	0,4 x D	0,75 x D	90	–	150	fz	0,017	0,030	0,036	0,049	0,059	0,069	0,069	0,084	0,084	0,097	0,107
H	1	1 x D	0,4 x D	0,75 x D	80	–	140	fz	0,017	0,030	0,036	0,049	0,059	0,069	0,069	0,084	0,084	0,097	0,107
	2	1 x D	0,3 x D	0,5 x D	70	–	120	fz	0,013	0,022	0,027	0,037	0,044	0,051	0,051	0,063	0,063	0,071	0,078
	3	1 x D	0,15 x D	0,3 x D	60	–	90	fz	0,010	0,018	0,021	0,029	0,035	0,041	0,041	0,051	0,051	0,059	0,067
	4	1 x D	0,1 x D	0,15 x D	50	–	70	fz	0,007	0,012	0,014	0,019	0,023	0,027	0,027	0,034	0,034	0,039	0,044

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.
For better surface finish, reduce feed per tooth.