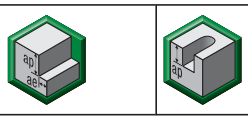
Series 75N2 • Vision Plus



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
P	3	0,75 x D	0,1 x D	0,4 x D	160	–	180	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070
	4	0,75 x D	0,1 x D	0,4 x D	140	–	160	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062
H	1	0,75 x D	0,1 x D	0,4 x D	120	–	140	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062
	2	0,75 x D	0,05 x D	0,3 x D	100	–	130	fz	0,016	0,020	0,025	0,029	0,034	0,037	0,040
	3	0,75 x D	0,03 x D	0,2 x D	70	–	100	fz	0,013	0,016	0,019	0,023	0,026	0,029	0,032
	4	0,75 x D	0,01 x D	0,1 x D	50	–	70	fz	0,008	0,011	0,013	0,015	0,018	0,019	0,021

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.

Series 422875 • Vision Plus



Material Group		Side Milling (A) and Slotting (B)			K10UF-DCHP AlTiN			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
P	3	0,5 x D	0,4 x D	0,3 x D	108	–	144	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070
	4	0,5 x D	0,4 x D	0,3 x D	81	–	135	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062
H	1	0,5 x D	0,4 x D	0,3 x D	72	–	126	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062
	2	0,5 x D	0,3 x D	0,2 x D	63	–	108	fz	0,012	0,016	0,020	0,025	0,034	0,040	0,047
	3	0,5 x D	0,15 x D	0,15 x D	54	–	81	fz	0,009	0,013	0,016	0,019	0,026	0,032	0,037
	4	0,5 x D	0,1 x D	0,1 x D	45	–	63	fz	0,006	0,008	0,011	0,013	0,018	0,021	0,025

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 ap/ae 0.05 x D, increase fz by 40%.
For better surface finish, reduce feed per tooth.