

## Series 75N5 • Vision Plus

Material Group					TiAlN		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.												
	Side Milling (A) and Slotting (B)		Cutting Speed – vc m/min														D1 – Diameter		
	A		B		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	
	ap	ae	ap	ap				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	0,026	0,033	0,040	0,055	0,067	0,077	0,087	0,096	0,104	0,111	0,125
	4	1 x D	0,4 x D	0,75 x D	90	–	150	fz	0,024	0,030	0,036	0,049	0,059	0,069	0,077	0,084	0,091	0,097	0,107
H	1	1 x D	0,4 x D	0,75 x D	80	–	140	fz	0,024	0,030	0,036	0,049	0,059	0,069	0,077	0,084	0,091	0,097	0,107
	2	1 x D	0,3 x D	0,5 x D	70	–	120	fz	0,018	0,022	0,027	0,037	0,044	0,051	0,057	0,063	0,067	0,071	0,078
	3	1 x D	0,15 x D	0,3 x D	60	–	90	fz	0,014	0,018	0,021	0,029	0,035	0,041	0,046	0,051	0,055	0,059	0,067
	4	1 x D	0,1 x D	0,15 x D	50	–	70	fz	0,009	0,012	0,014	0,019	0,023	0,027	0,031	0,034	0,037	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 75N8 • Vision Plus™

## Series 75N8 • Vision Plus

Material Group					TiAlN		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.					
	Side Milling (A) and Slotting (B)		Cutting Speed – vc m/min								D1 – Diameter	
	A		B		min	max	mm	6,0	8,0	10,0	12,0	
	ap	ap	ap	ap				mm	6,0	8,0	10,0	12,0
P	3	0,75 x D	0,2 x D	0,2 x D	120	–	160	fz	0,040	0,055	0,067	0,077
	4	0,75 x D	0,2 x D	0,2 x D	90	–	150	fz	0,036	0,049	0,059	0,069
H	1	0,75 x D	0,2 x D	0,2 x D	80	–	140	fz	0,036	0,049	0,059	0,069
	2	0,75 x D	0,2 x D	0,2 x D	70	–	120	fz	0,027	0,037	0,044	0,051
	3	0,75 x D	0,1 x D	0,1 x D	60	–	90	fz	0,021	0,029	0,035	0,041
	4	0,75 x D	0,05 x D	0,05 x D	50	–	70	fz	0,014	0,019	0,023	0,027

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.