

■ Series 77NE • VariMill III ER • With Neck • Semi-Finishing • Victory Grades



Material Group	Side Milling (A)		WS15PE			Recommended feed per tooth (fz = mm/th) for side milling (A).						
	A		Cutting Speed – vc m/min			mm	D1 – Diameter					
	ap	ae	min		max		10,0	12,0	16,0	18,0	20,0	
						fz						
P	4	Ap1 max	0,3 x D	90	–	150	fz	0,054	0,062	0,077	0,083	0,088
	5	Ap1 max	0,3 x D	60	–	100	fz	0,048	0,056	0,070	0,076	0,081
M	1	Ap1 max	0,3 x D	90	–	115	fz	0,061	0,070	0,087	0,095	0,101
	2	Ap1 max	0,3 x D	60	–	80	fz	0,048	0,056	0,070	0,076	0,081
	3	Ap1 max	0,3 x D	60	–	70	fz	0,040	0,047	0,057	0,061	0,065
S	1	Ap1 max	0,3 x D	50	–	90	fz	0,061	0,070	0,087	0,095	0,101
	2	Ap1 max	0,3 x D	25	–	40	fz	0,032	0,037	0,046	0,050	0,054
	3	Ap1 max	0,3 x D	60	–	80	fz	0,048	0,056	0,070	0,076	0,081
	4	Ap1 max	0,3 x D	50	–	60	fz	0,045	0,052	0,064	0,069	0,074
H	1	Ap1 max	0,3 x D	80	–	140	fz	0,054	0,062	0,077	0,083	0,088
	2	Ap1 max	0,3 x D	70	–	120	fz	0,040	0,047	0,057	0,061	0,065

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 >12mm diameters.

■ Series 77NE • VariMill III ER • With Neck • Finishing • Victory Grades



Material Group	Side Milling (A)		WS15PE			Recommended feed per tooth (fz = mm/th) for side milling (A).						
	A		Cutting Speed – vc m/min			mm	D1 – Diameter					
	ap	ae	min		max		10,0	12,0	16,0	18,0	20,0	
						fz						
P	4	Ap1 max	0,06 x D	180	–	300	fz	0,065	0,075	0,092	0,099	0,106
	5	Ap1 max	0,06 x D	120	–	200	fz	0,058	0,067	0,084	0,091	0,097
M	1	Ap1 max	0,06 x D	180	–	230	fz	0,073	0,084	0,105	0,113	0,121
	2	Ap1 max	0,06 x D	120	–	160	fz	0,058	0,067	0,084	0,091	0,097
	3	Ap1 max	0,06 x D	120	–	140	fz	0,048	0,056	0,068	0,073	0,078
S	1	Ap1 max	0,06 x D	100	–	180	fz	0,073	0,084	0,105	0,113	0,121
	2	Ap1 max	0,06 x D	50	–	80	fz	0,038	0,045	0,056	0,060	0,065
	3	Ap1 max	0,06 x D	120	–	160	fz	0,058	0,067	0,084	0,091	0,097
	4	Ap1 max	0,06 x D	100	–	120	fz	0,053	0,062	0,077	0,083	0,089
H	1	Ap1 max	0,06 x D	160	–	280	fz	0,065	0,075	0,092	0,099	0,106
	2	Ap1 max	0,06 x D	140	–	240	fz	0,048	0,056	0,068	0,073	0,078

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 >12mm diameters.

High-Performance Solid Carbide End Mills