

■ Series D618 • Vision Plus

Material Group	Side Milling (A)		TiAlN		Recommended feed per tooth (fz = mm/th) for side milling (A).												
	A		Cutting Speed – vc m/min			D1 – Diameter											
	ap	ae	min		max	mm	3,0	4,0	5,0	6,0	8,0	10,0	12,0	16,0	20,0		
	P	3	2 x D	0,15 x D	120	–	160	fz	0,019	0,026	0,033	0,040	0,055	0,067	0,077	0,096	0,111
	4	2 x D	0,15 x D	90	–	150	fz	0,017	0,024	0,030	0,036	0,049	0,059	0,069	0,084	0,097	
H	1	2 x D	0,15 x D	80	–	140	fz	0,017	0,024	0,030	0,036	0,049	0,059	0,069	0,084	0,097	
	2	2 x D	0,15 x D	70	–	120	fz	0,013	0,018	0,022	0,027	0,037	0,044	0,051	0,063	0,071	
	3	2 x D	0,1 x D	60	–	90	fz	0,010	0,014	0,018	0,021	0,029	0,035	0,041	0,051	0,059	
	4	2 x D	0,05 x D	50	–	70	fz	0,007	0,009	0,012	0,014	0,019	0,023	0,027	0,034	0,039	

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.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on diameters >12mm.

Application Data • Series 422837 422831 • Vision Plus™

■ Series 422837 422831 • Vision Plus

Material Group	Side Milling (A)		K10UF-DCHP		Recommended feed per tooth (fz = mm/th) for side milling (A).										
	A		Cutting Speed – vc m/min			D1 – Diameter									
	ap	ae	min		max	mm	6,0	8,0	10,0	12,0	16,0	20,0	25,0		
	P	3	1,5 x D	0,2 x D	120	–	160	fz	0,040	0,055	0,067	0,077	0,096	0,111	0,125
	4	1,5 x D	0,2 x D	90	–	150	fz	0,036	0,049	0,059	0,069	0,084	0,097	0,107	
H	1	1,5 x D	0,2 x D	80	–	140	fz	0,036	0,049	0,059	0,069	0,084	0,097	0,107	
	2	1,5 x D	0,15 x D	60	–	80	fz	0,027	0,037	0,044	0,051	0,063	0,071	0,078	
	3	1,5 x D	0,1 x D	50	–	70	fz	0,021	0,029	0,035	0,041	0,051	0,059	0,067	
	4	1,5 x D	0,05 x D	40	–	60	fz	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.
For Series 422831, ap max = 2,5 x D by 50% ae.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on diameters >12mm.