Top Cut 4 • Steel • 2 x D/3 x D • Feed Chart • Metric

Top Cut 4						Recommended Feed Rate by Diameter (mm/r)											
						Insert Size A			Insert Size B			Insert Size C			Insert Size D		
						TCF040203AC TCF040204AP 12,00–13,99mm			TCF060203BC TCF050204BP 14,00–18,99mm			TCF070304CC TCF070306CP 19,00–23,99mm			TCF090305DC TCF080308DP 24,00–29,99mm		
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max
P	1	S	P	V36	WU25CH	0,06	**0,08**	0,10	0,08	**0,10**	0,13	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
		U	P	V36	WU40PH	0,06	**0,08**	0,10	0,08	**0,10**	0,13	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
		I	P	V36	WU40PH	0,06	**0,08**	0,10	0,08	**0,10**	0,13	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
	2	S	P	V34	WPK10CH	0,06	**0,08**	0,10	0,08	**0,12**	0,15	0,10	**0,13**	0,16	0,11	**0,14**	0,17
			C	V34	WU40PH												
		U	P	V34	WU25CH	0,06	**0,08**	0,10	0,08	**0,12**	0,15	0,10	**0,13**	0,16	0,11	**0,14**	0,17
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,06	**0,08**	0,10	0,08	**0,12**	0,15	0,10	**0,13**	0,16	0,11	**0,14**	0,17
			C	V34	WU40PH												
	3	S	P	V34	WPK10CH	0,08	**0,11**	0,15	0,10	**0,12**	0,16	0,11	**0,14**	0,18	0,12	**0,15**	0,20
			C	V34	WU40PH												
		U	P	V34	WU25CH	0,08	**0,11**	0,14	0,10	**0,12**	0,15	0,11	**0,14**	0,16	0,12	**0,15**	0,18
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,08	**0,11**	0,14	0,10	**0,12**	0,15	0,11	**0,14**	0,16	0,12	**0,15**	0,18
			C	V34	WU40PH												
	4	S	P	V34	WPK10CH	0,08	**0,11**	0,15	0,10	**0,12**	0,16	0,11	**0,14**	0,18	0,12	**0,15**	0,20
			C	V34	WU40PH												
		U	P	V34	WU25CH	0,08	**0,11**	0,14	0,10	**0,12**	0,15	0,11	**0,14**	0,16	0,12	**0,15**	0,18
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,08	**0,11**	0,14	0,10	**0,12**	0,15	0,11	**0,14**	0,16	0,12	**0,15**	0,18
			C	V34	WU40PH												
	5	S	P	V36	WU25CH	0,06	**0,08**	0,10	0,08	**0,10**	0,14	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
		U	P	V36	WU40PH	0,06	**0,08**	0,10	0,08	**0,10**	0,14	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
		I	P	V36	WU40PH	0,06	**0,08**	0,10	0,08	**0,10**	0,14	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
	6	S	P	V36	WU25CH	0,06	**0,08**	0,10	0,08	**0,10**	0,14	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
		U	P	V36	WU40PH	0,06	**0,08**	0,10	0,08	**0,10**	0,14	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
		I	P	V36	WU40PH	0,06	**0,08**	0,10	0,08	**0,10**	0,14	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.
For 5 x D, diameter range 12–23,99mm (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above recommendations.
For 5 x D, diameter range 24–68mm (insert sizes D to H), it is highly recommended to start with feed and speed values reduced by 15% less than above recommendations.
For 4 x D and 5 x D, it is recommended to reduce the feed rate during entry and exit by 30–50%.

Condition: S = stable conditions,
U = unstable cutting conditions,
I = interrupted cutting conditions
Pocket Seat: P = periphery insert,
C = centre insert

Top Cut 4 • Steel • 2 x D/3 x D • Speed Chart • Metric

Top Cut 4						Recommended Cutting Speed by Diameter (m/min)											
						Insert Size A			Insert Size B			Insert Size C			Insert Size D		
						TCF040203AC TCF040204AP 12,00–13,99mm			TCF060203BC TCF050204BP 14,00–18,99mm			TCF070304CC TCF070306CP 19,00–23,99mm			TCF090305DC TCF080308DP 24,00–29,99mm		
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max
P	1	S	P	V36	WU25CH	120	**140**	160	140	**160**	240	150	**180**	260	160	**180**	260
			C	V36	WU40PH												
		U	P	V36	WU40PH	110	**120**	140	130	**150**	220	130	**170**	250	140	**170**	250
			C	V36	WU40PH												
		I	P	V36	WU40PH	90	**100**	120	130	**150**	210	130	**170**	240	140	**170**	240
			C	V36	WU40PH												
	2	S	P	V34	WPK10CH	120	**140**	160	140	**170**	260	150	**190**	280	160	**190**	280
			C	V34	WU40PH												
		U	P	V34	WU25CH	110	**120**	140	130	**170**	240	140	**180**	260	150	**180**	260
			C	V34	WU40PH												
		I	P	V34	WU40PH	90	**100**	120	130	**170**	230	130	**170**	240	140	**170**	240
			C	V34	WU40PH												
	3	S	P	V34	WPK10CH	120	**140**	180	140	**170**	270	150	**200**	290	160	**200**	310
			C	V34	WU40PH												
		U	P	V34	WU25CH	110	**120**	160	130	**160**	260	140	**200**	280	150	**200**	280
			C	V34	WU40PH												
		I	P	V34	WU40PH	100	**110**	140	120	**150**	250	130	**180**	260	140	**180**	260
			C	V34	WU40PH												
	4	S	P	V34	WPK10CH	120	**140**	180	140	**170**	270	150	**200**	290	160	**200**	310
			C	V34	WU40PH												
		U	P	V34	WU25CH	110	**120**	160	130	**160**	260	140	**200**	280	150	**200**	280
			C	V34	WU40PH												
		I	P	V34	WU40PH	100	**110**	140	120	**150**	250	130	**180**	260	140	**180**	260
			C	V34	WU40PH												
	5	S	P	V36	WU25CH	120	**140**	160	140	**170**	240	150	**180**	250	160	**180**	250
			C	V36	WU40PH												
		U	P	V36	WU40PH	110	**120**	140	130	**160**	230	140	**170**	240	150	**170**	240
			C	V36	WU40PH												
		I	P	V36	WU40PH	90	**100**	120	130	**160**	230	130	**160**	220	140	**160**	220
			C	V36	WU40PH												
	6	S	P	V36	WU25CH	120	**140**	160	140	**170**	200	140	**170**	210	150	**170**	210
			C	V36	WU40PH												
		U	P	V36	WU40PH	110	**120**	140	120	**150**	190	130	**160**	200	140	**160**	200
			C	V36	WU40PH												
		I	P	V36	WU40PH	90	**100**	120	110	**130**	180	120	**140**	190	120	**140**	190
			C	V36	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.
For 5 x D, diameter range 12–23,99mm (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above recommendations.
For 5 x D, diameter range 24–68mm (insert sizes D to H), it is highly recommended to start with feed and speed values reduced by 15% less than above recommendations.
For 4 x D and 5 x D, it is recommended to reduce the feed rate during entry and exit by 30–50%.

Condition: S = stable conditions,
U = unstable cutting conditions,
I = interrupted cutting conditions
Pocket Seat: P = periphery insert,
C = centre insert

Top Cut 4 • Steel • 2 x D/3 x D • Feed Chart • Metric

Top Cut 4						Recommended Feed Rate by Diameter (mm/r)											
						Insert Size E			Insert Size F			Insert Size G			Insert Size H		
						TCF120405EC TCF100408EP 30,00–36,99mm			TCF150406FC TCF120412FP 37,00–45,99mm			TCF180508GC TCF150512GP 46,00–56,99mm			TCF210608HC TCF180614HP 57,00–68,00mm		
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max
P	1	S	P	V36	WU25CH	0,13	**0,14**	0,18	0,15	**0,17**	0,20	0,16	**0,23**	0,27	0,17	**0,24**	0,29
			C	V36	WU40PH												
		U	P	V36	WU40PH	0,06	**0,08**	0,10	0,08	**0,10**	0,13	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
		I	P	V36	WU40PH	0,06	**0,08**	0,10	0,08	**0,10**	0,13	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
	2	S	P	V34	WPK10CH	0,06	**0,08**	0,10	0,08	**0,12**	0,15	0,10	**0,13**	0,16	0,11	**0,14**	0,17
			C	V34	WU40PH												
		U	P	V34	WU25CH	0,06	**0,08**	0,10	0,08	**0,12**	0,15	0,10	**0,13**	0,16	0,11	**0,14**	0,17
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,06	**0,08**	0,10	0,08	**0,12**	0,15	0,10	**0,13**	0,16	0,11	**0,14**	0,17
			C	V34	WU40PH												
	3	S	P	V34	WPK10CH	0,08	**0,11**	0,15	0,10	**0,12**	0,16	0,11	**0,14**	0,18	0,12	**0,15**	0,20
			C	V34	WU40PH												
		U	P	V34	WU25CH	0,08	**0,11**	0,14	0,10	**0,12**	0,15	0,11	**0,14**	0,16	0,12	**0,15**	0,18
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,08	**0,11**	0,14	0,10	**0,12**	0,15	0,11	**0,14**	0,16	0,12	**0,15**	0,18
			C	V34	WU40PH												
	4	S	P	V34	WPK10CH	0,08	**0,11**	0,15	0,10	**0,12**	0,16	0,11	**0,14**	0,18	0,12	**0,15**	0,20
			C	V34	WU40PH												
		U	P	V34	WU25CH	0,08	**0,11**	0,14	0,10	**0,12**	0,15	0,11	**0,14**	0,16	0,12	**0,15**	0,18
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,08	**0,11**	0,14	0,10	**0,12**	0,15	0,11	**0,14**	0,16	0,12	**0,15**	0,18
			C	V34	WU40PH												
	5	S	P	V36	WU25CH	0,06	**0,08**	0,10	0,08	**0,10**	0,14	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
		U	P	V36	WU40PH	0,06	**0,08**	0,10	0,08	**0,10**	0,14	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
		I	P	V36	WU40PH	0,06	**0,08**	0,10	0,08	**0,10**	0,14	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
	6	S	P	V36	WU25CH	0,06	**0,08**	0,10	0,08	**0,10**	0,14	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
		U	P	V36	WU40PH	0,06	**0,08**	0,10	0,08	**0,10**	0,14	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												
		I	P	V36	WU40PH	0,06	**0,08**	0,10	0,08	**0,10**	0,14	0,10	**0,12**	0,15	0,11	**0,13**	0,16
			C	V36	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.
For 5 x D, diameter range 12–23,99mm (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above recommendations.
For 5 x D, diameter range 24–68mm (insert sizes D to H), it is highly recommended to start with feed and speed values reduced by 15% less than above recommendations.
For 4 x D and 5 x D, it is recommended to reduce the feed rate during entry and exit by 30–50%.

Condition: S = stable conditions,
U = unstable cutting conditions,
I = interrupted cutting conditions
Pocket Seat: P = periphery insert,
C = centre insert

Top Cut 4 • Steel • 2 x D/3 x D • Speed Chart • Metric

Top Cut 4						Recommended Cutting Speed by Diameter (m/min)											
						Insert Size E			Insert Size F			Insert Size G			Insert Size H		
						TCF120405EC TCF100408EP 30,00–36,99mm			TCF150406FC TCF120412FP 37,00–45,99mm			TCF180508GC TCF150512GP 46,00–56,99mm			TCF210608HC TCF180614HP 57,00–68,00mm		
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max
P	1	S	P	V36	WU25CH	160	180	260	160	180	260	160	180	260	160	180	260
			C	V36	WU40PH												
		U	P	V36	WU40PH	140	170	250	140	170	250	140	170	250	140	170	250
			C	V36	WU40PH												
		I	P	V36	WU40PH	140	170	240	140	170	240	140	170	240	140	170	240
			C	V36	WU40PH												
	2	S	P	V34	WPK10CH	160	190	280	160	190	280	160	190	280	160	190	280
			C	V34	WU40PH												
		U	P	V34	WU25CH	150	180	260	150	180	260	150	180	260	150	180	260
			C	V34	WU40PH												
		I	P	V34	WU40PH	140	170	240	140	170	240	140	170	240	140	170	240
			C	V34	WU40PH												
	3	S	P	V34	WPK10CH	160	200	310	160	200	310	160	200	310	160	200	310
			C	V34	WU40PH												
		U	P	V34	WU25CH	150	200	280	150	200	280	150	200	280	150	200	280
			C	V34	WU40PH												
		I	P	V34	WU40PH	140	180	260	140	180	260	140	180	260	140	180	260
			C	V34	WU40PH												
	4	S	P	V34	WPK10CH	160	200	310	160	200	310	160	200	310	160	200	310
			C	V34	WU40PH												
		U	P	V34	WU25CH	150	200	280	150	200	280	150	200	280	150	200	280
			C	V34	WU40PH												
		I	P	V34	WU40PH	140	180	260	140	180	260	140	180	260	140	180	260
			C	V34	WU40PH												
	5	S	P	V36	WU25CH	160	180	250	160	180	250	160	180	250	160	180	250
			C	V36	WU40PH												
		U	P	V36	WU40PH	150	170	240	150	170	240	150	170	240	150	170	240
			C	V36	WU40PH												
		I	P	V36	WU40PH	140	160	220	140	160	220	140	160	220	140	160	220
			C	V36	WU40PH												
	6	S	P	V36	WU25CH	150	170	210	150	170	210	150	170	210	150	170	210
			C	V36	WU40PH												
		U	P	V36	WU40PH	140	160	200	140	160	200	140	160	200	140	160	200
			C	V36	WU40PH												
		I	P	V36	WU40PH	120	140	190	120	140	190	120	140	190	120	140	190
			C	V36	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.
For 5 x D, diameter range 12–23,99mm (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above recommendations.
For 5 x D, diameter range 24–68mm (insert sizes D to H), it is highly recommended to start with feed and speed values reduced by 15% less than above recommendations.
For 4 x D and 5 x D, it is recommended to reduce the feed rate during entry and exit by 30–50%.

Condition: S = stable conditions,
U = unstable cutting conditions,
I = interrupted cutting conditions
Pocket Seat: P = periphery insert,
C = centre insert

Top Cut 4 • Stainless Steel • 2 x D/3 x D • Feed Chart • Metric

Top Cut 4						Recommended Feed Rate by Diameter (mm/r)											
						Insert Size A			Insert Size B			Insert Size C			Insert Size D		
						TCF040203AC TCF040204AP 12,00–13,99mm			TCF060203BC TCF050204BP 14,00–18,99mm			TCF070304CC TCF070306CP 19,00–23,99mm			TCF090305DC TCF080308DP 24,00–29,99mm		
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max
M	1	S	P	V36	WU40PH	0,06	**0,08**	0,12	0,07	**0,10**	0,13	0,08	**0,10**	0,15	0,10	**0,12**	0,16
			C	V36	WU40PH												
		U	P	V36	WU40PH	0,06	**0,08**	0,12	0,07	**0,10**	0,12	0,08	**0,10**	0,14	0,10	**0,12**	0,15
			C	V36	WU40PH												
		I	P	V36	WU40PH	0,06	**0,08**	0,11	0,07	**0,10**	0,11	0,08	**0,10**	0,14	0,10	**0,12**	0,15
			C	V36	WU40PH												
	2	S	P	V36	WU40PH	0,06	**0,08**	0,12	0,07	**0,10**	0,13	0,08	**0,10**	0,15	0,10	**0,12**	0,16
			C	V36	WU40PH												
		U	P	V36	WU40PH	0,06	**0,08**	0,12	0,07	**0,10**	0,12	0,08	**0,10**	0,14	0,10	**0,12**	0,15
			C	V36	WU40PH												
		I	P	V36	WU40PH	0,06	**0,08**	0,11	0,07	**0,10**	0,11	0,08	**0,10**	0,14	0,10	**0,12**	0,15
			C	V36	WU40PH												
	3	S	P	V36	WU40PH	0,06	**0,08**	0,12	0,07	**0,10**	0,13	0,08	**0,10**	0,15	0,10	**0,12**	0,16
			C	V36	WU40PH												
		U	P	V36	WU40PH	0,06	**0,08**	0,12	0,07	**0,10**	0,12	0,08	**0,10**	0,14	0,10	**0,12**	0,15
			C	V36	WU40PH												
		I	P	V36	WU40PH	0,06	**0,08**	0,11	0,07	**0,10**	0,11	0,08	**0,10**	0,14	0,10	**0,12**	0,15
			C	V36	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.
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For 5 x D, diameter range 24–68mm (insert sizes D to H), it is highly recommended to start with feed and speed values reduced by 15% less than above recommendations.
For 4 x D and 5 x D, it is recommended to reduce the feed rate during entry and exit by 30–50%.

Condition: S = stable conditions,
U = unstable cutting conditions,
I = interrupted cutting conditions
Pocket Seat: P = periphery insert,
C = centre insert

Top Cut 4 • Stainless Steel • 2 x D/3 x D • Speed Chart • Metric

Top Cut 4						Recommended Cutting Speed by Diameter (m/min)											
						Insert Size A			Insert Size B			Insert Size C			Insert Size D		
						TCF040203AC TCF040204AP 12,00–13,99mm			TCF060203BC TCF050204BP 14,00–18,99mm			TCF070304CC TCF070306CP 19,00–23,99mm			TCF090305DC TCF080308DP 24,00–29,99mm		
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max
M	1	S	P	V36	WU40PH	120	**140**	160	140	**160**	230	150	**170**	240	150	**170**	240
			C	V36	WU40PH												
		U	P	V36	WU40PH	110	**120**	140	130	**150**	210	130	**160**	210	130	**160**	210
			C	V36	WU40PH												
		I	P	V36	WU40PH	90	**100**	120	130	**150**	200	130	**160**	200	130	**160**	200
			C	V36	WU40PH												
	2	S	P	V36	WU40PH	120	**140**	160	140	**160**	200	150	**170**	210	150	**170**	210
			C	V36	WU40PH												
		U	P	V36	WU40PH	110	**120**	140	130	**150**	180	130	**160**	200	130	**160**	200
			C	V36	WU40PH												
		I	P	V36	WU40PH	90	**100**	120	120	**140**	170	130	**150**	180	130	**150**	180
			C	V36	WU40PH												
	3	S	P	V36	WU40PH	110	**120**	140	130	**150**	180	140	**160**	200	140	**160**	200
			C	V36	WU40PH												
		U	P	V36	WU40PH	90	**110**	120	120	**130**	160	130	**140**	180	130	**140**	180
			C	V36	WU40PH												
		I	P	V36	WU40PH	80	**100**	110	100	**120**	150	110	**130**	160	110	**130**	160
			C	V36	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.
For 5 x D, diameter range 12–23,99mm (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above recommendations.
For 5 x D, diameter range 24–68mm (insert sizes D to H), it is highly recommended to start with feed and speed values reduced by 15% less than above recommendations.
For 4 x D and 5 x D, it is recommended to reduce the feed rate during entry and exit by 30–50%.

Condition: S = stable conditions,
U = unstable cutting conditions,
I = interrupted cutting conditions
Pocket Seat: P = periphery insert,
C = centre insert

Top Cut 4 • Stainless Steel • 2 x D/3 x D • Feed Chart • Metric

Top Cut 4						Recommended Feed Rate by Diameter (mm/r)											
						Insert Size E			Insert Size F			Insert Size G			Insert Size H		
						TCF120405EC TCF100408EP 30,00–36,99mm			TCF150406FC TCF120412FP 37,00–45,99mm			TCF180508GC TCF150512GP 46,00–56,99mm			TCF210608HC TCF180614HP 57,00–68,00mm		
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max
M	1	S	P	V36	WU40PH	0,12	**0,14**	0,20	0,14	**0,16**	0,25	0,16	**0,18**	0,28	0,16	**0,20**	0,30
			C	V36	WU40PH												
		U	P	V36	WU40PH	0,11	**0,13**	0,18	0,12	**0,14**	0,22	0,14	**0,16**	0,25	0,14	**0,18**	0,26
			C	V36	WU40PH												
		I	P	V36	WU40PH	0,11	**0,13**	0,18	0,12	**0,14**	0,22	0,14	**0,16**	0,25	0,14	**0,18**	0,26
			C	V36	WU40PH												
	2	S	P	V36	WU40PH	0,12	**0,14**	0,20	0,14	**0,16**	0,25	0,16	**0,18**	0,28	0,16	**0,20**	0,30
			C	V36	WU40PH												
		U	P	V36	WU40PH	0,11	**0,13**	0,18	0,12	**0,14**	0,22	0,14	**0,16**	0,25	0,14	**0,18**	0,26
			C	V36	WU40PH												
		I	P	V36	WU40PH	0,11	**0,13**	0,18	0,12	**0,14**	0,22	0,14	**0,16**	0,25	0,14	**0,18**	0,26
			C	V36	WU40PH												
	3	S	P	V36	WU40PH	0,12	**0,14**	0,20	0,14	**0,16**	0,25	0,16	**0,18**	0,28	0,16	**0,20**	0,30
			C	V36	WU40PH												
		U	P	V36	WU40PH	0,11	**0,13**	0,18	0,12	**0,14**	0,22	0,14	**0,16**	0,25	0,14	**0,18**	0,26
			C	V36	WU40PH												
		I	P	V36	WU40PH	0,11	**0,13**	0,18	0,12	**0,14**	0,22	0,14	**0,16**	0,25	0,14	**0,18**	0,26
			C	V36	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.
For 5 x D, diameter range 12–23,99mm (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above recommendations.
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Condition: S = stable conditions,
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I = interrupted cutting conditions
Pocket Seat: P = periphery insert,
C = centre insert

Top Cut 4 • Stainless Steel • 2 x D/3 x D • Speed Chart • Metric

Top Cut 4						Recommended Cutting Speed by Diameter (m/min)											
						Insert Size E			Insert Size F			Insert Size G			Insert Size H		
						TCF120405EC TCF100408EP 30,00–36,99mm			TCF150406FC TCF120412FP 37,00–45,99mm			TCF180508GC TCF150512GP 46,00–56,99mm			TCF210608HC TCF180614HP 57,00–68,00mm		
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max
M	1	S	P	V36	WU40PH	150	**170**	240	150	**170**	240	150	**170**	240	150	**170**	240
			C	V36	WU40PH												
		U	P	V36	WU40PH	130	**160**	210	130	**160**	210	130	**160**	210	130	**160**	210
			C	V36	WU40PH												
		I	P	V36	WU40PH	130	**160**	200	130	**160**	200	130	**160**	200	130	**160**	200
			C	V36	WU40PH												
	2	S	P	V36	WU40PH	150	**170**	210	150	**170**	210	150	**170**	210	150	**170**	210
			C	V36	WU40PH												
		U	P	V36	WU40PH	130	**160**	200	130	**160**	200	130	**160**	200	130	**160**	200
			C	V36	WU40PH												
		I	P	V36	WU40PH	130	**150**	180	130	**150**	180	130	**150**	180	130	**150**	180
			C	V36	WU40PH												
	3	S	P	V36	WU40PH	140	**160**	200	140	**160**	200	140	**160**	200	140	**160**	200
			C	V36	WU40PH												
		U	P	V36	WU40PH	130	**140**	180	130	**140**	180	130	**140**	180	130	**140**	180
			C	V36	WU40PH												
		I	P	V36	WU40PH	110	**130**	160	110	**130**	160	110	**130**	160	110	**130**	160
			C	V36	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.
For 5 x D, diameter range 12–23,99mm (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above recommendations.
For 5 x D, diameter range 24–68mm (insert sizes D to H), it is highly recommended to start with feed and speed values reduced by 15% less than above recommendations.
For 4 x D and 5 x D, it is recommended to reduce the feed rate during entry and exit by 30–50%.

Condition: S = stable conditions,
U = unstable cutting conditions,
I = interrupted cutting conditions
Pocket Seat: P = periphery insert,
C = centre insert

Top Cut 4 • Cast Iron • 2 x D/3 x D • Feed Chart • Metric

Top Cut 4						Recommended Feed Rate by Diameter (mm/r)											
						Insert Size A			Insert Size B			Insert Size C			Insert Size D		
						TCF040203AC TCF040204AP 12,00–13,99mm			TCF060203BC TCF050204BP 14,00–18,99mm			TCF070304CC TCF070306CP 19,00–23,99mm			TCF090305DC TCF080308DP 24,00–29,99mm		
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max
K	1	S	P	V34	WPK10CH	0,08	**0,10**	0,14	0,08	**0,10**	0,16	0,10	**0,13**	0,18	0,12	**0,16**	0,24
			C	V34	WU25CH												
		U	P	V34	WU25CH	0,08	**0,10**	0,14	0,08	**0,10**	0,16	0,10	**0,13**	0,18	0,12	**0,16**	0,24
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,08	**0,10**	0,14	0,08	**0,10**	0,16	0,10	**0,13**	0,18	0,12	**0,16**	0,24
			C	V34	WU40PH												
	2	S	P	V34	WPK10CH	0,08	**0,10**	0,14	0,08	**0,10**	0,16	0,10	**0,13**	0,18	0,12	**0,16**	0,24
			C	V34	WU25CH												
		U	P	V34	WU25CH	0,08	**0,10**	0,14	0,08	**0,10**	0,16	0,10	**0,13**	0,18	0,12	**0,16**	0,24
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,08	**0,10**	0,14	0,08	**0,10**	0,16	0,10	**0,13**	0,18	0,12	**0,16**	0,24
			C	V34	WU40PH												
	3	S	P	V34	WPK10CH	0,08	**0,10**	0,14	0,08	**0,10**	0,16	0,10	**0,13**	0,18	0,12	**0,16**	0,24
			C	V34	WU25CH												
		U	P	V34	WU25CH	0,08	**0,10**	0,14	0,08	**0,10**	0,16	0,10	**0,13**	0,18	0,12	**0,16**	0,24
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,08	**0,10**	0,14	0,08	**0,10**	0,16	0,10	**0,13**	0,18	0,12	**0,16**	0,24
			C	V34	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.
For 5 x D, diameter range 12–23,99mm (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above recommendations.
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Condition: S = stable conditions,
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Pocket Seat: P = periphery insert,
C = centre insert

Top Cut 4 • Cast Iron • 2 x D/3 x D • Speed Chart • Metric

Top Cut 4						Recommended Cutting Speed by Diameter (m/min)											
						Insert Size A			Insert Size B			Insert Size C			Insert Size D		
						TCF040203AC TCF040204AP 12,00–13,99mm			TCF060203BC TCF050204BP 14,00–18,99mm			TCF070304CC TCF070306CP 19,00–23,99mm			TCF090305DC TCF080308DP 24,00–29,99mm		
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max
K	1	S	P	V34	WPK10CH	120	**140**	180	140	**170**	250	150	**180**	260	160	**200**	280
			C	V34	WU25CH												
		U	P	V34	WU25CH	110	**120**	160	130	**160**	240	140	**170**	250	150	**180**	260
			C	V34	WU40PH												
		I	P	V34	WU40PH	100	**110**	140	120	**150**	230	130	**160**	240	140	**170**	260
			C	V34	WU40PH												
	2	S	P	V34	WPK10CH	120	**140**	180	130	**160**	240	140	**180**	250	150	**180**	260
			C	V34	WU25CH												
		U	P	V34	WU25CH	110	**120**	160	120	**150**	230	130	**160**	240	140	**160**	250
			C	V34	WU40PH												
		I	P	V34	WU40PH	100	**110**	140	120	**150**	220	130	**160**	240	140	**160**	250
			C	V34	WU40PH												
	3	S	P	V34	WPK10CH	120	**140**	160	130	**160**	240	140	**170**	240	150	**170**	250
			C	V34	WU25CH												
		U	P	V34	WU25CH	110	**120**	140	120	**150**	230	130	**160**	230	140	**160**	240
			C	V34	WU40PH												
		I	P	V34	WU40PH	90	**100**	120	120	**150**	230	130	**160**	230	140	**160**	220
			C	V34	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.
For 5 x D, diameter range 12–23,99mm (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above recommendations.
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C = centre insert

Top Cut 4 • Cast Iron • 2 x D/3 x D • Feed Chart • Metric

Top Cut 4						Recommended Feed Rate by Diameter (mm/r)											
						Insert Size E			Insert Size F			Insert Size G			Insert Size H		
						TCF120405EC TCF100408EP 30,00–36,99mm			TCF150406FC TCF120412FP 37,00–45,99mm			TCF180508GC TCF150512GP 46,00–56,99mm			TCF210608HC TCF180614HP 57,00–68,00mm		
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max
K	1	S	P	V34	WPK10CH	0,14	**0,16**	0,26	0,16	**0,20**	0,3	0,18	**0,22**	0,32	0,20	**0,24**	0,36
			C	V34	WU25CH												
		U	P	V34	WU25CH	0,14	**0,16**	0,26	0,16	**0,20**	0,3	0,18	**0,22**	0,32	0,20	**0,24**	0,36
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,14	**0,16**	0,26	0,16	**0,20**	0,3	0,18	**0,22**	0,32	0,20	**0,24**	0,36
			C	V34	WU40PH												
	2	S	P	V34	WPK10CH	0,14	**0,16**	0,26	0,16	**0,20**	0,3	0,18	**0,22**	0,32	0,20	**0,24**	0,36
			C	V34	WU25CH												
		U	P	V34	WU25CH	0,14	**0,16**	0,26	0,16	**0,20**	0,3	0,18	**0,22**	0,32	0,20	**0,24**	0,36
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,14	**0,16**	0,26	0,16	**0,20**	0,3	0,18	**0,22**	0,32	0,20	**0,24**	0,36
			C	V34	WU40PH												
	3	S	P	V34	WPK10CH	0,14	**0,16**	0,26	0,16	**0,20**	0,3	0,18	**0,22**	0,32	0,20	**0,24**	0,36
			C	V34	WU25CH												
		U	P	V34	WU25CH	0,14	**0,16**	0,26	0,16	**0,20**	0,3	0,18	**0,22**	0,32	0,20	**0,24**	0,36
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,14	**0,16**	0,26	0,16	**0,20**	0,3	0,18	**0,22**	0,32	0,20	**0,24**	0,36
			C	V34	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.
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Top Cut 4 • Cast Iron • 2 x D/3 x D • Speed Chart • Metric

Top Cut 4						Recommended Cutting Speed by Diameter (m/min)											
						Insert Size E			Insert Size F			Insert Size G			Insert Size H		
						TCF120405EC TCF100408EP 30,00–36,99mm			TCF150406FC TCF120412FP 37,00–45,99mm			TCF180508GC TCF150512GP 46,00–56,99mm			TCF210608HC TCF180614HP 57,00–68,00mm		
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max
K	1	S	P	V34	WPK10CH	160	**200**	280	160	**200**	280	160	**200**	280	160	**200**	280
			C	V34	WU25CH												
		U	P	V34	WU25CH	150	**180**	260	150	**180**	260	150	**180**	260	150	**180**	260
			C	V34	WU40PH												
		I	P	V34	WU40PH	140	**170**	260	140	**170**	260	140	**170**	260	140	**170**	260
			C	V34	WU40PH												
	2	S	P	V34	WPK10CH	150	**180**	260	150	**180**	260	150	**180**	260	150	**180**	260
			C	V34	WU25CH												
		U	P	V34	WU25CH	140	**160**	250	140	**160**	250	140	**160**	250	140	**160**	250
			C	V34	WU40PH												
		I	P	V34	WU40PH	140	**160**	250	140	**160**	250	140	**160**	250	140	**160**	250
			C	V34	WU40PH												
	3	S	P	V34	WPK10CH	150	**170**	250	150	**170**	250	150	**170**	250	150	**170**	250
			C	V34	WU25CH												
		U	P	V34	WU25CH	140	**160**	240	140	**160**	240	140	**160**	240	140	**160**	240
			C	V34	WU40PH												
		I	P	V34	WU40PH	140	**160**	220	140	**160**	220	140	**160**	220	140	**160**	220
			C	V34	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.
For 5 x D, diameter range 12–23,99mm (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above recommendations.
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I = interrupted cutting conditions
Pocket Seat: P = periphery insert,
C = centre insert