

High-Performance Solid Carbide End Mills • Roughing

Application Data • Series 422150 422152



Series 422150 422152

Material Group								Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.							
	Side Milling (A) and Slotting (B)		K30F-DCHP		AITiN										
	A		B		Cutting Speed – vc m/min			D1 – Diameter							
	ap	ae	ap	min		max	mm	6,0	8,0	10,0	12,0	16,0	20,0	25,0	
P	1	1,5 x D	0,5 x D	1 x D	150	–	200	fz	0,031	0,041	0,049	0,060	0,073	0,082	0,087
	2	1,5 x D	0,5 x D	1 x D	140	–	190	fz	0,031	0,041	0,049	0,060	0,073	0,082	0,087
	3	1,5 x D	0,4 x D	1 x D	120	–	160	fz	0,025	0,034	0,041	0,051	0,063	0,073	0,080
	4	1,5 x D	0,4 x D	0,75 x D	90	–	150	fz	0,023	0,030	0,037	0,045	0,055	0,063	0,068
	5	1,5 x D	0,4 x D	0,75 x D	60	–	100	fz	0,021	0,027	0,033	0,040	0,050	0,058	0,064
K	1	1,5 x D	0,5 x D	1 x D	120	–	160	fz	0,031	0,041	0,049	0,060	0,073	0,082	0,087
	2	1,5 x D	0,4 x D	1 x D	110	–	140	fz	0,025	0,034	0,041	0,051	0,063	0,073	0,080
	3	1,5 x D	0,4 x D	1 x D	100	–	130	fz	0,021	0,027	0,033	0,040	0,050	0,058	0,064
S	1	1,5 x D	0,5 x D	1 x D	50	–	90	fz	0,025	0,034	0,041	0,051	0,063	0,073	0,080
H	1	1,5 x D	0,3 x D	0,75 x D	80	–	140	fz	0,023	0,030	0,037	0,045	0,055	0,063	0,068

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.
Low cutting force through chipbreaker for use with unstable clamping and components.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameters.

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