

High-Performance Solid Carbide End Mills • Finishing

Application Data • Series 024112



■ Series 024112

Material Group												
	Side Milling (A) and Slotting (B)				K10F-DIA			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.				
					DIA							
	A		B		Cutting Speed – vc m/min			D1 – Diameter				
ap	ae	ap	min		max	mm	4,0	6,0	8,0	10,0		
N	6	0,7 x D	0,5 x D	0,5 x D	100	–	750	fz	0,040	0,060	0,080	0,100

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.