

■ Series 024111

Material Group																
	Side Milling (A) and Slotting (B)				uncoated			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.								
	A		B		Cutting Speed – vc m/min			D1 – Diameter								
	ap	ae	ap	min	–	max	mm	2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0	
N	6	0,7 x D	0,5 x D	0,5 x D	100	–	750	fz	0,020	0,030	0,040	0,050	0,060	0,080	0,100	0,120

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.