Series 524149



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K10F-DCL DLC Cutting Speed — vc m/min min		max	Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%. mm	D1 — Diameter 3,0	4,0	5,0	6,0	8,0	10,0	12,0
N	1	1,2 x D	0,5 x D	1 x D	500	–	2000	fz	0,021	0,028	0,035	0,042	0,056	0,070	0,084
	2	1,2 x D	0,5 x D	1 x D	500	–	1500	fz	0,019	0,025	0,032	0,038	0,050	0,063	0,076
	3	1,2 x D	0,5 x D	1 x D	500	–	1500	fz	0,017	0,022	0,028	0,034	0,045	0,056	0,067
	4	1,2 x D	0,5 x D	1 x D	250	–	750	fz	0,015	0,020	0,025	0,029	0,039	0,049	0,059
	6	1,2 x D	0,5 x D	1 x D	100	–	500	fz	0,021	0,028	0,035	0,042	0,056	0,070	0,084

NOTE: For better surface finish, reduce feed per tooth.

Application Data • Series 022849

Series 022849



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K10F uncoated Cutting Speed — vc m/min min		max	Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%. mm	D1 — Diameter 2,0	3,0	4,0	5,0	6,0	8,0	10,0	12,0
N	1	1,2 x D	0,5 x D	1 x D	500	–	2000	fz	0,014	0,021	0,028	0,035	0,042	0,056	0,070	0,084
	2	1,2 x D	0,5 x D	1 x D	500	–	1500	fz	0,011	0,017	0,022	0,028	0,034	0,045	0,056	0,067

NOTE: For better surface finish, reduce feed per tooth.

Application Data • Series D502

Series D502



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	uncoated Cutting Speed — vc m/min min		max	TiAlN Cutting Speed — vc m/min min		max	Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%. mm	D1 — Diameter 3,0	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	20,0
N	1	1,5 x D	0,5 x D	1 x D	500	–	2000	500	–	2000	fz	0,027	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,180
	2	1,5 x D	0,5 x D	1 x D	500	–	1500	500	–	1500	fz	0,024	0,032	0,041	0,049	0,065	0,081	0,097	0,113	0,130	0,162
	3	1,5 x D	0,5 x D	1 x D	500	–	1500	500	–	1500	fz	0,019	0,025	0,032	0,038	0,050	0,063	0,076	0,088	0,101	0,126
	4	1,5 x D	0,5 x D	1 x D	400	–	750	400	–	750	fz	0,022	0,029	0,036	0,043	0,058	0,072	0,086	0,101	0,115	0,144
	5	1,5 x D	0,5 x D	1 x D	250	–	1000	250	–	1000	fz	0,024	0,032	0,041	0,049	0,065	0,081	0,097	0,113	0,130	0,162

NOTE: For cutting aluminium with high silicon, TiAlN coating is recommended.
Multiply ap for milling machine spindle with ceramic bearings by 0,5.
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.