







■ Series 022814 022817

Material Group																		
	Side Milling (A) and Slotting (B)			K10F		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.												
				uncoated														
	A		B	Cutting Speed – vc m/min		D1 – Diameter												
	ap	ae	ap	min	max	mm	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0		
N	1	1,5 x D	0,5 x D	1 x D	500	–	2000	fz	0,036	0,045	0,054	0,072	0,090	0,108	0,126	0,144	0,162	0,180
	2	1,5 x D	0,5 x D	1 x D	500	–	1500	fz	0,032	0,041	0,049	0,065	0,081	0,097	0,113	0,130	0,146	0,162
	3	1,5 x D	0,5 x D	1 x D	500	–	1500	fz	0,025	0,032	0,038	0,050	0,063	0,076	0,088	0,101	0,113	0,126
	4	1,5 x D	0,5 x D	1 x D	400	–	750	fz	0,029	0,036	0,043	0,058	0,072	0,086	0,101	0,115	0,130	0,144
	5	1,5 x D	0,5 x D	1 x D	250	–	1000	fz	0,032	0,041	0,049	0,065	0,081	0,097	0,113	0,130	0,146	0,162

NOTE: 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.

Application Data • Series 4102

■ Series 4102

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%.													
				Cutting Speed – vc m/min		D1 – Diameter													
		ap	ae	ap	min	max	mm	1,5	2,0	3,0	4,0	6,0	8,0	10,0	12,0	16,0	18,0	20,0	
N	1	1,5 x D	0,5 x D	1 x D	500	–	2000	fz	0,014	0,018	0,027	0,036	0,054	0,072	0,090	0,108	0,144	0,162	0,180
	2	1,5 x D	0,5 x D	1 x D	500	–	1500	fz	0,012	0,016	0,024	0,032	0,049	0,065	0,081	0,097	0,130	0,146	0,162
	3	1,5 x D	0,5 x D	1 x D	500	–	1500	fz	0,009	0,013	0,019	0,025	0,038	0,050	0,063	0,076	0,101	0,113	0,126
	4	1,5 x D	0,5 x D	1 x D	400	–	750	fz	0,011	0,014	0,022	0,029	0,043	0,058	0,072	0,086	0,115	0,130	0,144
	5	1,5 x D	0,5 x D	1 x D	250	–	1000	fz	0,012	0,016	0,024	0,032	0,049	0,065	0,081	0,097	0,130	0,146	0,162

NOTE: 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.