

High-Performance Solid Carbide End Mills • Aluminium

Application Data • Series 022852 524152



Series 022852 524152

Material Group	Side Milling (A) and Slotting (B)		K10F		K10F-DCL		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.												
			uncoated		DLC														
	A		B		Cutting Speed – vc m/min		Cutting Speed – vc m/min		D1 – Diameter										
	ap	ae	ap	min	max	min	max	mm	3,0	4,0	6,0	8,0	10,0	12,0	14,0	16,0			
N	1	1,2 x D	0,5 x D	1 x D	500	–	2000	500	–	2000	fz	0,021	0,028	0,042	0,056	0,070	0,084	0,098	0,112
	2	1,2 x D	0,5 x D	1 x D	500	–	1500	500	–	1500	fz	0,019	0,025	0,038	0,050	0,063	0,076	0,088	0,101
	3	1,2 x D	0,5 x D	1 x D	–	–	–	500	–	1500	fz	0,017	0,022	0,034	0,045	0,056	0,067	0,078	0,090
	4	1,2 x D	0,5 x D	1 x D	–	–	–	400	–	750	fz	0,015	0,020	0,029	0,039	0,049	0,059	0,069	0,078
	5	1,2 x D	0,5 x D	1 x D	–	–	–	750	–	1200	fz	0,021	0,028	0,042	0,056	0,070	0,084	0,098	0,112
	6	1,2 x D	0,5 x D	1 x D	–	–	–	750	–	1200	fz	0,021	0,028	0,042	0,056	0,070	0,084	0,098	0,112

NOTE: For cutting aluminium with high silicon, DLC 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.

Application Data • Series 024101

Series 024101

Material Group	Side Milling (A) and Slotting (B)		PCD		Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.							
			PCD-PT									
	A		B		Cutting Speed – vc m/min		D1 – Diameter					
	ap	ae	ap	min	max	mm	6,0	8,0	10,0	12,0		
N	2	1 x D	0,5 x D	0,7 x D	400	–	2500	fz	0,055	0,075	0,095	0,100
	3	1 x D	0,5 x D	0,7 x D	300	–	1500	fz	0,055	0,075	0,095	0,100
	4	1 x D	0,5 x D	0,7 x D	500	–	3000	fz	0,055	0,075	0,095	0,100
	5	1 x D	0,5 x D	0,7 x D	200	–	1000	fz	0,055	0,075	0,095	0,100
	6	1 x D	0,5 x D	0,7 x D	400	–	800	fz	0,055	0,075	0,095	0,100
	6	1 x D	0,5 x D	0,7 x D	400	–	800	fz	0,055	0,075	0,095	0,100

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