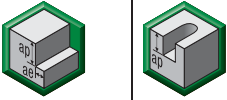



■ Series 4103

Material Group																			
	Side Milling (A) and Slotting (B)			uncoated			TiCN			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			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	16,0	20,0	
N	1	1 x D	0,5 x D	0,7 x D	500	–	2000	500	–	2000	fz	0,027	0,036	0,054	0,072	0,090	0,108	0,144	0,180
	2	1 x D	0,5 x D	0,7 x D	500	–	1500	500	–	1500	fz	0,024	0,032	0,049	0,065	0,081	0,097	0,130	0,162

NOTE: For cutting aluminium with high silicon, TiCN 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 4909

■ Series 4909

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	max	6,0	8,0	10,0	12,0	16,0	20,0	25,0				
N	1	1,5 x D	0,5 x D	1 x D	500	–	2000	fz	0,066	0,088	0,110	0,132	0,176	0,220	0,275			
	2	1,5 x D	0,5 x D	1 x D	500	–	1500	fz	0,059	0,079	0,099	0,119	0,158	0,198	0,248			

NOTE: For cutting aluminium with high silicon TiCN coating is recommended.
 Multiply ap for milling machine spindle with ceramic bearings by 0,5.
 Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on diameters >12mm.