

■ Series 49G9

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	6,0	8,0	10,0	12,0	16,0	18,0	20,0	
N	1	1 x D	0,5 x D	1 x D	500	–	2000	fz	0,072	0,096	0,120	0,144	0,192	0,216	0,240
	2	1 x D	0,5 x D	1 x D	500	–	1500	fz	0,065	0,086	0,108	0,130	0,173	0,194	0,216
	3	1 x D	0,5 x D	1 x D	500	–	1500	fz	0,050	0,067	0,084	0,101	0,134	0,151	0,168
	4	1 x D	0,5 x D	1 x D	400	–	750	fz	0,058	0,077	0,096	0,115	0,154	0,173	0,192
	5	1 x D	0,5 x D	1 x D	250	–	1000	fz	0,065	0,086	0,108	0,130	0,173	0,194	0,216

NOTE: 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.