



■ Series 70N6 71N6 • Vision Plus X-Feed

Material Group													
		Profile Milling		AlTiN			Recommended Feed Per Tooth (fz = mm/th) for 3D milling/profiling (A)						
		A		Cutting Speed – vc m/min			D1 – Diameter						
		ap	ae	min		max	mm	6,0	8,0	10,0	12,0	16,0	20,0
<b>P</b>	4	0,05 x D	0,55 x D	160	–	180	fz	0,300	0,500	0,500	0,500	0,600	0,700
<b>H</b>	1	0,05 x D	0,55 x D	140	–	160	fz	0,300	0,500	0,500	0,500	0,600	0,700
	2	0,05 x D	0,55 x D	100	–	120	fz	0,200	0,300	0,300	0,400	0,500	0,600

NOTE: Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters on diameters >12mm.