

■ Series 70N7 • 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
H	2	0,03 x D	0,55 x D	100	–	120	fz	0,200	0,300	0,300	0,400	0,500	0,600
	3	0,03 x D	0,55 x D	80	–	100	fz	0,200	0,300	0,300	0,400	0,500	0,600
	4	0,03 x D	0,55 x D	50	–	70	fz	0,150	0,200	0,250	0,300	0,400	0,500

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