

■ Series 75N2 • Vision Plus

Material Group								Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.							
	Side Milling (A) and Slotting (B)		TiAlN												
	A		B	Cutting Speed – vc m/min			D1 – Diameter								
	ap	ae	ap	min		max	mm	3,0	4,0	5,0	6,0	8,0	10,0	12,0	
P	3	0,75 x D	0,1 x D	0,4 x D	160	–	180	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070
	4	0,75 x D	0,1 x D	0,4 x D	140	–	160	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062
H	1	0,75 x D	0,1 x D	0,4 x D	120	–	140	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062
	2	0,75 x D	0,05 x D	0,3 x D	100	–	130	fz	0,016	0,020	0,025	0,029	0,034	0,037	0,040
	3	0,75 x D	0,03 x D	0,2 x D	70	–	100	fz	0,013	0,016	0,019	0,023	0,026	0,029	0,032
	4	0,75 x D	0,01 x D	0,1 x D	50	–	70	fz	0,008	0,011	0,013	0,015	0,018	0,019	0,021

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.  
 Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.

Application Data • Series 422875 • Vision Plus™

■ Series 422875 • Vision Plus

Material Group								Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.							
	Side Milling (A) and Slotting (B)		K10UF-DCHP												
			AITN												
	A		B	Cutting Speed – vc m/min			D1 – Diameter								
ap	ae	ap	min		max	mm	3,0	4,0	5,0	6,0	8,0	10,0	12,0		
P	3	0,5 x D	0,4 x D	0,3 x D	108	–	144	fz	0,017	0,023	0,030	0,036	0,050	0,061	0,070
	4	0,5 x D	0,4 x D	0,3 x D	81	–	135	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062
H	1	0,5 x D	0,4 x D	0,3 x D	72	–	126	fz	0,016	0,021	0,027	0,033	0,045	0,054	0,062
	2	0,5 x D	0,3 x D	0,2 x D	63	–	108	fz	0,012	0,016	0,020	0,025	0,034	0,040	0,047
	3	0,5 x D	0,15 x D	0,15 x D	54	–	81	fz	0,009	0,013	0,016	0,019	0,026	0,032	0,037
	4	0,5 x D	0,1 x D	0,1 x D	45	–	63	fz	0,006	0,008	0,011	0,013	0,018	0,021	0,025

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.  
 Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.  
 For ap/ae 0.05 x D, increase fz by 40%.  
 For better surface finish, reduce feed per tooth.