## Series 75N5 • Vision Plus



| Material Group | | Side Milling (A) and Slotting (B) | | | TiAlN | | | 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 | 4,0 | 5,0 | 6,0 | 8,0 | 10,0 | 12,0 | 14,0 | 16,0 | 18,0 | 20,0 | 25,0 |
| P | 3 | 1 x D | 0,4 x D | 1 x D | 120 | – | 160 | fz | 0,026 | 0,033 | 0,040 | 0,055 | 0,067 | 0,077 | 0,087 | 0,096 | 0.,104 | 0,111 | 0,125 |
| | 4 | 1 x D | 0,4 x D | 0,75 x D | 90 | – | 150 | fz | 0,024 | 0,030 | 0,036 | 0,049 | 0,059 | 0,069 | 0,077 | 0,084 | 0,091 | 0,097 | 0,107 |
| H | 1 | 1 x D | 0,4 x D | 0,75 x D | 80 | – | 140 | fz | 0,024 | 0,030 | 0,036 | 0,049 | 0,059 | 0,069 | 0,077 | 0,084 | 0,091 | 0,097 | 0,107 |
| | 2 | 1 x D | 0,3 x D | 0,5 x D | 70 | – | 120 | fz | 0,018 | 0,022 | 0,027 | 0,037 | 0,044 | 0,051 | 0,057 | 0,063 | 0,067 | 0,071 | 0,078 |
| | 3 | 1 x D | 0,15 x D | 0,3 x D | 60 | – | 90 | fz | 0,014 | 0,018 | 0,021 | 0,029 | 0,035 | 0,041 | 0,046 | 0,051 | 0,055 | 0,059 | 0,067 |
| | 4 | 1 x D | 0,1 x D | 0,15 x D | 50 | – | 70 | fz | 0,009 | 0,012 | 0,014 | 0,019 | 0,023 | 0,027 | 0,031 | 0,034 | 0,037 | 0,039 | 0,044 |

*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 better surface finish, reduce feed per tooth.*





## Series 75N8 • Vision Plus



| Material Group | | Side Milling (A) and Slotting (B) | | | TiAlN | | | 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 | ap | ap | min | | max | mm | 6,0 | 8,0 | 10,0 | 12,0 |
| P | 3 | 0,75 x D | 0,2 x D | 0,2 x D | 120 | – | 160 | fz | 0,040 | 0,055 | 0,067 | 0,077 |
| | 4 | 0,75 x D | 0,2 x D | 0,2 x D | 90 | – | 150 | fz | 0,036 | 0,049 | 0,059 | 0,069 |
| H | 1 | 0,75 x D | 0,2 x D | 0,2 x D | 80 | – | 140 | fz | 0,036 | 0,049 | 0,059 | 0,069 |
| | 2 | 0,75 x D | 0,2 x D | 0,2 x D | 70 | – | 120 | fz | 0,027 | 0,037 | 0,044 | 0,051 |
| | 3 | 0,75 x D | 0,1 x D | 0,1 x D | 60 | – | 90 | fz | 0,021 | 0,029 | 0,035 | 0,041 |
| | 4 | 0,75 x D | 0,05 x D | 0,05 x D | 50 | – | 70 | fz | 0,014 | 0,019 | 0,023 | 0,027 |

*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 better surface finish, reduce feed per tooth.*