Series D618 • Vision Plus

Material Group		Side Milling (A)		TiAlN			Recommended feed per tooth (fz = mm/th) for side milling (A).								
		A		Cutting Speed — vc m/min				D1 — Diameter							
		ap	ae	min		max	mm	3,0	4,0	5,0	6,0	8,0	10,0	12,0	16,0	20,0
P	3	2 x D	0,15 x D	120	–	160	fz	0,019	0,026	0,033	0,040	0,055	0,067	0,077	0,096	0,111
	4	2 x D	0,15 x D	90	–	150	fz	0,017	0,024	0,030	0,036	0,049	0,059	0,069	0,084	0,097
H	1	2 x D	0,15 x D	80	–	140	fz	0,017	0,024	0,030	0,036	0,049	0,059	0,069	0,084	0,097
	2	2 x D	0,15 x D	70	–	120	fz	0,013	0,018	0,022	0,027	0,037	0,044	0,051	0,063	0,071
	3	2 x D	0,1 x D	60	–	90	fz	0,010	0,014	0,018	0,021	0,029	0,035	0,041	0,051	0,059
	4	2 x D	0,05 x D	50	–	70	fz	0,007	0,009	0,012	0,014	0,019	0,023	0,027	0,034	0,039

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

Series 422837 422831 • Vision Plus

Material Group		Side Milling (A)		K10UF-DCHP AlTiN			Recommended feed per tooth (fz = mm/th) for side milling (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	25,0
P	3	1,5 x D	0,2 x D	120	–	160	fz	0,040	0,055	0,067	0,077	0,096	0,111	0,125
	4	1,5 x D	0,2 x D	90	–	150	fz	0,036	0,049	0,059	0,069	0,084	0,097	0,107
H	1	1,5 x D	0,2 x D	80	–	140	fz	0,036	0,049	0,059	0,069	0,084	0,097	0,107
	2	1,5 x D	0,15 x D	60	–	80	fz	0,027	0,037	0,044	0,051	0,063	0,071	0,078
	3	1,5 x D	0,1 x D	50	–	70	fz	0,021	0,029	0,035	0,041	0,051	0,059	0,067
	4	1,5 x D	0,05 x D	40	–	60	fz	0,014	0,019	0,023	0,027	0,034	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.
For Series 422831, ap max = 2,5 x D by 50% ae.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on diameters >12mm.