

■ Top Cut 4 • Steel • 2 x D/3 x D • Speed Chart • Metric

Top Cut 4					Recommended Cutting Speed by Diameter (m/min)												
					Insert Size A			Insert Size B			Insert Size C			Insert Size D			
					TCF040203AC TCF040204AP 12,00–13,99mm			TCF060203BC TCF050204BP 14,00–18,99mm			TCF070304CC TCF070306CP 19,00–23,99mm			TCF090305DC TCF080308DP 24,00–29,99mm			
Material Group	Condition	Pocket Seat	Geometry	Grade	min	Start	max	min	Start	max	min	Start	max	min	Start	max	
P	1	S	P	V36	WU25CH	120	140	160	140	160	240	150	180	260	160	180	260
			C	V36	WU40PH												
		U	P	V36	WU40PH	110	120	140	130	150	220	130	170	250	140	170	250
			C	V36	WU40PH												
		I	P	V36	WU40PH	90	100	120	130	150	210	130	170	240	140	170	240
			C	V36	WU40PH												
	2	S	P	V34	WPK10CH	120	140	160	140	170	260	150	190	280	160	190	280
			C	V34	WU40PH												
		U	P	V34	WU25CH	110	120	140	130	170	240	140	180	260	150	180	260
			C	V34	WU40PH												
		I	P	V34	WU40PH	90	100	120	130	170	230	130	170	240	140	170	240
			C	V34	WU40PH												
	3	S	P	V34	WPK10CH	120	140	180	140	170	270	150	200	290	160	200	310
			C	V34	WU40PH												
		U	P	V34	WU25CH	110	120	160	130	160	260	140	200	280	150	200	280
			C	V34	WU40PH												
		I	P	V34	WU40PH	100	110	140	120	150	250	130	180	260	140	180	260
			C	V34	WU40PH												
	4	S	P	V34	WPK10CH	120	140	180	140	170	270	150	200	290	160	200	310
			C	V34	WU40PH												
		U	P	V34	WU25CH	110	120	160	130	160	260	140	200	280	150	200	280
			C	V34	WU40PH												
		I	P	V34	WU40PH	100	110	140	120	150	250	130	180	260	140	180	260
			C	V34	WU40PH												
	5	S	P	V36	WU25CH	120	140	160	140	170	240	150	180	250	160	180	250
			C	V36	WU40PH												
		U	P	V36	WU40PH	110	120	140	130	160	230	140	170	240	150	170	240
			C	V36	WU40PH												
		I	P	V36	WU40PH	90	100	120	130	160	230	130	160	220	140	160	220
			C	V36	WU40PH												
	6	S	P	V36	WU25CH	120	140	160	140	170	200	140	170	210	150	170	210
			C	V36	WU40PH												
		U	P	V36	WU40PH	110	120	140	120	150	190	130	160	200	140	160	200
			C	V36	WU40PH												
		I	P	V36	WU40PH	90	100	120	110	130	180	120	140	190	120	140	190
			C	V36	WU40PH												

NOTE: For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above recommendations.

For 5 x D, diameter range 12–23,99mm (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above recommendations.

For 5 x D, diameter range 24–68mm (insert sizes D to H), it is highly recommended to start with feed and speed values reduced by 15% less than above recommendations.

For 4 x D and 5 x D, it is recommended to reduce the feed rate during entry and exit by 30–50%.

Condition: S = stable conditions,

U = unstable cutting conditions,

I = interrupted cutting conditions

Pocket Seat: P = periphery insert,

C = centre insert