

■ 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 E			Insert Size F			Insert Size G			Insert Size H			
					TCF120405EC TCF100408EP 30,00–36,99mm			TCF150406FC TCF120412FP 37,00–45,99mm			TCF180508GC TCF150512GP 46,00–56,99mm			TCF210608HC TCF180614HP 57,00–68,00mm			
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	160	180	260	160	180	260	160	180	260	160	180	260
			C	V36	WU40PH												
		U	P	V36	WU40PH	140	170	250	140	170	250	140	170	250	140	170	250
			C	V36	WU40PH												
		I	P	V36	WU40PH	140	170	240	140	170	240	140	170	240	140	170	240
			C	V36	WU40PH												
	2	S	P	V34	WPK10CH	160	190	280	160	190	280	160	190	280	160	190	280
			C	V34	WU40PH												
		U	P	V34	WU25CH	150	180	260	150	180	260	150	180	260	150	180	260
			C	V34	WU40PH												
		I	P	V34	WU40PH	140	170	240	140	170	240	140	170	240	140	170	240
			C	V34	WU40PH												
	3	S	P	V34	WPK10CH	160	200	310	160	200	310	160	200	310	160	200	310
			C	V34	WU40PH												
		U	P	V34	WU25CH	150	200	280	150	200	280	150	200	280	150	200	280
			C	V34	WU40PH												
		I	P	V34	WU40PH	140	180	260	140	180	260	140	180	260	140	180	260
			C	V34	WU40PH												
	4	S	P	V34	WPK10CH	160	200	310	160	200	310	160	200	310	160	200	310
			C	V34	WU40PH												
		U	P	V34	WU25CH	150	200	280	150	200	280	150	200	280	150	200	280
			C	V34	WU40PH												
		I	P	V34	WU40PH	140	180	260	140	180	260	140	180	260	140	180	260
			C	V34	WU40PH												
	5	S	P	V36	WU25CH	160	180	250	160	180	250	160	180	250	160	180	250
			C	V36	WU40PH												
		U	P	V36	WU40PH	150	170	240	150	170	240	150	170	240	150	170	240
			C	V36	WU40PH												
		I	P	V36	WU40PH	140	160	220	140	160	220	140	160	220	140	160	220
			C	V36	WU40PH												
	6	S	P	V36	WU25CH	150	170	210	150	170	210	150	170	210	150	170	210
			C	V36	WU40PH												
		U	P	V36	WU40PH	140	160	200	140	160	200	140	160	200	140	160	200
			C	V36	WU40PH												
		I	P	V36	WU40PH	120	140	190	120	140	190	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