

■ Top Cut 4 • Stainless 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	
M	1	S	P	V36	WU40PH	120	140	160	140	160	230	150	170	240	150	170	240
			C	V36	WU40PH												
		U	P	V36	WU40PH	110	120	140	130	150	210	130	160	210	130	160	210
			C	V36	WU40PH												
		I	P	V36	WU40PH	90	100	120	130	150	200	130	160	200	130	160	200
			C	V36	WU40PH												
	2	S	P	V36	WU40PH	120	140	160	140	160	200	150	170	210	150	170	210
			C	V36	WU40PH												
		U	P	V36	WU40PH	110	120	140	130	150	180	130	160	200	130	160	200
			C	V36	WU40PH												
		I	P	V36	WU40PH	90	100	120	120	140	170	130	150	180	130	150	180
			C	V36	WU40PH												
	3	S	P	V36	WU40PH	110	120	140	130	150	180	140	160	200	140	160	200
			C	V36	WU40PH												
		U	P	V36	WU40PH	90	110	120	120	130	160	130	140	180	130	140	180
			C	V36	WU40PH												
		I	P	V36	WU40PH	80	100	110	100	120	150	110	130	160	110	130	160
			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