

Indexable Drills

Application Data • Top Cut 4™



■ Top Cut 4 • Cast Iron • 2 x D/3 x D • Feed Chart • Metric

Top Cut 4					Recommended Feed Rate by Diameter (mm/r)												
					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	
K	1	S	P	V34	WPK10CH	0,14	0,16	0,26	0,16	0,20	0,3	0,18	0,22	0,32	0,20	0,24	0,36
			C	V34	WU25CH												
		U	P	V34	WU25CH	0,14	0,16	0,26	0,16	0,20	0,3	0,18	0,22	0,32	0,20	0,24	0,36
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,14	0,16	0,26	0,16	0,20	0,3	0,18	0,22	0,32	0,20	0,24	0,36
			C	V34	WU40PH												
	2	S	P	V34	WPK10CH	0,14	0,16	0,26	0,16	0,20	0,3	0,18	0,22	0,32	0,20	0,24	0,36
			C	V34	WU25CH												
		U	P	V34	WU25CH	0,14	0,16	0,26	0,16	0,20	0,3	0,18	0,22	0,32	0,20	0,24	0,36
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,14	0,16	0,26	0,16	0,20	0,3	0,18	0,22	0,32	0,20	0,24	0,36
			C	V34	WU40PH												
	3	S	P	V34	WPK10CH	0,14	0,16	0,26	0,16	0,20	0,3	0,18	0,22	0,32	0,20	0,24	0,36
			C	V34	WU25CH												
		U	P	V34	WU25CH	0,14	0,16	0,26	0,16	0,20	0,3	0,18	0,22	0,32	0,20	0,24	0,36
			C	V34	WU40PH												
		I	P	V34	WU40PH	0,14	0,16	0,26	0,16	0,20	0,3	0,18	0,22	0,32	0,20	0,24	0,36
			C	V34	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