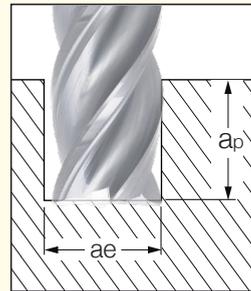


Side Milling

	Side Milling			Fz mm/t		
	Vc (m/min)	ap	ae	Ø 6-8	Ø 10-12	Ø 16-20
Steel up to 45 HRC	150-200	2D	0.4xD	0.025-0.050	0.050-0.065	0.060-0.07
Hardened Steel 45-55 HRC	60-120	2D	0.4xD	0.015-0.040	0.030-0.040	0.040-0.06
Stainless Steels	70-110	2D	0.4xD	0.025-0.035	0.035-0.040	0.040-0.06
Titanium	50-70	2D	0.4xD	0.020-0.040	0.040-0.050	0.050-0.06
Inconel	15-25	2D	0.4xD	0.010-0.030	0.030-0.040	0.030-0.05
Cast Iron	150-200	2D	0.4xD	0.035-0.050	0.060-0.065	0.065-0.07



Slotting

	Slotting			Fz mm/t		
	Vc (m/min)	ap	ae	Ø 6-8	Ø 10-12	Ø 16-20
Steel up to 45 HRC	150-200	D	D	0.02-0.030	0.030-0.045	0.03-0.045
Hardened Steel 45-55 HRC	60-120	D	D	0.01-0.015	0.025-0.045	0.03-0.045
Stainless Steels	70-110	D	D	0.02-0.030	0.035-0.040	0.04-0.045
Titanium	50-70	D	D	0.01-0.015	0.030-0.045	0.03-0.040
Inconel	15-25	D	D	0.01-0.016	0.030-0.045	0.03-0.040
Cast Iron	150-200	D	D	0.03-0.040	0.040-0.045	0.04-0.045