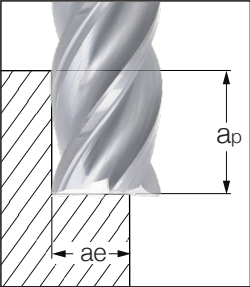
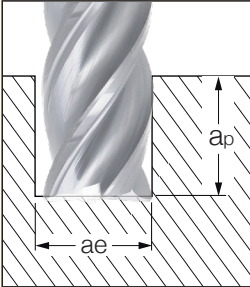


|                  |                                                                                   |    |       |             |            |             |                                                                                    |    |    |             |             |             |
|------------------|-----------------------------------------------------------------------------------|----|-------|-------------|------------|-------------|------------------------------------------------------------------------------------|----|----|-------------|-------------|-------------|
|                  |  |    |       |             |            |             |  |    |    |             |             |             |
|                  | Side Milling                                                                      |    |       |             |            |             | Slotting                                                                           |    |    |             |             |             |
|                  | Side Milling                                                                      |    |       | Fz mm/t     |            |             | Side Milling                                                                       |    |    | Fz mm/t     |             |             |
|                  | Vc (m/min)                                                                        | ap | ae    | Ø 6-8       | Ø 10-12    | Ø16-25      | Vc (m/min)                                                                         | ap | ae | Ø 6-8       | Ø 10-12     | Ø16-25      |
| Stainless Steels | 70-110                                                                            | 2D | 0.4xD | 0.025-0.045 | 0.04-0.050 | 0.050-0.065 | 70-110                                                                             | D  | D  | 0.025-0.035 | 0.035-0.045 | 0.045-0.050 |
| Titanium         | 50-70                                                                             | 2D | 0.4xD | 0.020-0.040 | 0.04-0.050 | 0.050-0.060 | 50-70                                                                              | D  | D  | 0.010-0.015 | 0.030-0.045 | 0.030-0.045 |
| Inconel          | 15-25                                                                             | 2D | 0.4xD | 0.010-0.030 | 0.03-0.050 | 0.030-0.050 | 15-25                                                                              | D  | D  | 0.010-0.016 | 0.030-0.045 | 0.030-0.045 |