

														
	Side Milling							Slotting						
	Side Milling			Fz mm/t				Sotting			Fz mm/t			
	Vc (m/min)	ap	ae	Ø 3-5	Ø 6-8	Ø 10-12	Ø 16	Vc (m/min)	ap	ae	Ø 6-8	Ø 10-12	Ø 16	
Steel up to 45 HRC	150-200	2D	0.4xD	0.005-0.025	0.030-0.060	0.06-0.070	0.070-0.080	150-200	2D	D	0.025-0.035	0.030-0.055	0.040-0.055	
Hardened Steel 45-55 HRC	60-120	2D	0.4xD	0.005-0.020	0.015-0.040	0.04-0.050	0.050-0.060	60-120	D	D	0.010-0.015	0.025-0.045	0.030-0.045	
Stainless Steels	70-110	2D	0.4xD	0.005-0.020	0.025-0.045	0.04-0.050	0.050-0.065	70-110	2D	D	0.025-0.035	0.035-0.045	0.045-0.050	
Titanium	50-70	2D	0.4xD	0.005-0.020	0.020-0.040	0.04-0.050	0.050-0.060	50-70	1D	D	0.010-0.015	0.030-0.045	0.030-0.045	
Inconel	15-25	2D	0.4xD	0.005-0.015	0.010-0.030	0.03-0.050	0.030-0.050	15-25	1D	D	0.010-0.016	0.030-0.045	0.030-0.045	
Cast Iron	150-200	2D	0.4xD	0.005-0.025	0.035-0.050	0.06-0.065	0.065-0.070	150-200	2D	D	0.030-0.040	0.040-0.045	0.040-0.045	