



| Side Milling             |         |    |       |             |             |            |             |
|--------------------------|---------|----|-------|-------------|-------------|------------|-------------|
| Side Milling             |         |    |       | Fz mm/t     |             |            |             |
| Vc (m/min)               | ap      | ae |       | Ø 3-5       | Ø 6-8       | Ø 10-12    | Ø16-20      |
| Steel up to 45 HRC       | 150-200 | 2D | 0.2xD | 0.005-0.025 | 0.030-0.060 | 0.06-0.070 | 0.070-0.080 |
| Hardened Steel 45-55 HRC | 60-120  | 2D | 0.2xD | 0.005-0.020 | 0.015-0.040 | 0.04-0.050 | 0.050-0.060 |
| Stainless Steels         | 70-110  | 2D | 0.2xD | 0.005-0.020 | 0.025-0.045 | 0.04-0.050 | 0.050-0.065 |
| Titanium                 | 50-70   | 2D | 0.2xD | 0.005-0.020 | 0.020-0.040 | 0.04-0.050 | 0.050-0.060 |
| Inconel                  | 15-25   | 2D | 0.2xD | 0.005-0.015 | 0.010-0.030 | 0.03-0.050 | 0.030-0.050 |
| Cast Iron                | 150-200 | 2D | 0.2xD | 0.005-0.025 | 0.035-0.050 | 0.06-0.065 | 0.065-0.070 |