

Short Series

S	Order No	Code	d1h9	d2h6	d3	l1	l2	l3	Corner	Weldon Order No
	13100	100.4.0100.0510.K0000.0025.0000.0000.00.S04H1A03.01	1	4	-	51	2,5	-	Ch 0.00	13101
	13102	100.4.0200.0510.C0008.0040.0190.0060.00.S04H1A03.01	2	4	1,95	51	4	6	Ch 0.08	13103
	13104	100.4.0200.0580.C0008.0040.0190.0060.00.S06H1A03.01	2	6	1,95	58	4	6	Ch 0.08	13105
	13106	100.4.0250.0580.C0015.0060.0240.0100.00.S06H1A03.01	2,5	6	2,4	58	6	10	Ch 0.15	13107
	13108	100.4.0250.0580.C0015.0120.0240.0160.00.S06H1A03.01	2,5	6	2,4	58	12	16	Ch 0.15	13109
*	13110	100.4.0300.0580.C0015.0080.0280.0120.00.S06B1A01.01	3	6	2,8	58	8	12	Ch 0.15	13111
	13112	100.4.0300.0580.C0015.0120.0280.0160.00.S06B1A01.01	3	6	2,8	58	12	16	Ch 0.15	13113
*	13114	100.4.0400.0580.C0015.0110.0380.0150.00.S06B1A01.01	4	6	3,8	58	11	15	Ch 0.15	13115
*	13116	100.4.0500.0580.C0025.0120.0480.0160.00.S06B1A01.01	5	6	4,8	58	12	16	Ch 0.25	13117
*	13118	100.4.0600.0580.C0025.0140.0580.0180.00.S06B1A01.01	6	6	5,8	58	14	18	Ch 0.25	13119
*	13120	100.4.0700.0640.C0030.0190.0680.0250.00.S08B1A01.01	7	8	6,8	64	19	25	Ch 0.30	13121
*	13122	100.4.0800.0640.C0030.0200.0780.0270.00.S08B1A01.01	8	8	7,8	64	20	27	Ch 0.30	13123
*	13124	100.4.1000.0730.C0040.0220.0970.0310.00.S10B1A01.01	10	10	9,7	73	22	31	Ch 0.40	13125
*	13126	100.4.1200.0820.C0050.0270.1170.0370.00.S12B1A01.01	12	12	11,7	82	27	37	Ch 0.50	13127
*	13128	100.4.1400.0820.C0050.0320.1360.0390.00.S14B1A01.01	14	14	13,6	82	32	39	Ch 0.50	13129
*	13130	100.4.1600.0930.C0060.0340.1550.0480.00.S16B1A01.01	16	16	15,5	93	34	48	Ch 0.60	13131
*	13132	100.4.1600.1000.C0060.0320.1560.0480.00.S16B1A01.01	16	16	15,6	100	32	48	Ch 0.60	13133
*	13134	100.4.1800.0930.C0060.0350.1760.0520.00.S18B1A01.01	18	18	17,6	93	35	52	Ch 0.60	13135
*	13136	100.4.2000.1050.C0060.0420.1960.0590.00.S20B1A01.01	20	20	19,6	105	42	59	Ch 0.60	13137

Long Series

S	Order No	Code	d1h9	d2h6	d3	l1	l2	l3	Corner	Weldon Order No
*	13138	100.4.0600.1000.C0010.0250.0580.0350.00.S06B1A01.01	6	6	5,8	100	25	35	Ch 0.10	13139
*	13140	100.4.0800.1000.C0010.0350.0780.0450.00.S08B1A01.01	8	8	7,8	100	35	45	Ch 0.10	13141
*	13142	100.4.1000.1100.C0010.0400.0970.0500.00.S10B1A01.01	10	10	9,7	110	40	50	Ch 0.10	13143
*	13144	100.4.1200.1100.C0010.0400.1170.0500.00.S12B1A01.01	12	12	11,7	110	40	50	Ch 0.10	13145
*	13146	100.4.1600.1100.C0060.0550.1580.0700.00.S16B1A01.01	16	16	15,8	110	55	70	Ch 0.60	13147
*	13148	100.4.1600.1250.C0015.0550.1560.0720.00.S16B1A01.01	16	16	15,6	125	55	72	Ch 0.15	13149

Cutting Parameters

Material	Slotting ap=1.5 - 10	Slotting ap=1.0 - 0.50	Shoulder Milling ap=1.50 / ae=0.35 - 0.200	Finish Milling ap=1.50 / ae=0.20 - 0.100
	Vc (m/min)	Vc (m/min)	Vc (m/min)	Vc (m/min)



Steel	Unalloyed Steel	105-125	180-200	150-200	200-250
	Steel	70-90	120-150	150-180	170-220
	Tempered Steel	70-90	120-150	130-160	150-180
	Cold Work Tool Steel	55-75	100-130	120-150	130-160
Stainless Steel	Hot Work Tool Steel	40-60	70-100	100-130	120-150
	AISI 304 - 416 - 420	15-20	25-35	20-30	25-35
	AISI 316 - 440	15-20	25-35	20-30	25-35
	17-4 PH 15-5 PH	15-20	25-35	20-30	25-35
Cast Iron	Chrome-Cobalt Alloy	15-30	30-50	35-60	45-60
	Duplex F51	15-30	30-50	35-60	45-60
	Super Duplex F55	15-30	30-50	35-60	45-60
	Gray Cast Iron	70-90	120-160	160-200	180-220
Hardened Steel	Alloyed Cast Iron	70-90	120-160	160-200	180-220
	Precision Cast Iron	70-90	120-160	160-200	180-220
	> 54 HRC	15-20	25-35	35-40	35-45

Feed Per Tooth (mm/tooth)

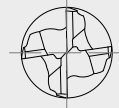
Ø	ap=1.50	ap=10	ap=0.500	ae=0.350	ae=0.300	ae=0.250	ae=0.200	ae=0.150	ae=0.100
3	0.012	0.015	0.020	0.015	0.017	0.020	0.023	0.025	0.035
4	0.014	0.017	0.021	0.017	0.022	0.025	0.032	0.035	0.040
5	0.017	0.020	0.024	0.020	0.025	0.030	0.035	0.040	0.045
6	0.020	0.022	0.028	0.022	0.028	0.033	0.038	0.045	0.050
8	0.025	0.030	0.035	0.030	0.035	0.045	0.055	0.060	0.070
10	0.030	0.035	0.040	0.035	0.042	0.050	0.060	0.072	0.085
12	0.035	0.041	0.047	0.041	0.049	0.057	0.068	0.078	0.090
14	0.036	0.042	0.048	0.042	0.050	0.058	0.069	0.080	0.094
16	0.045	0.055	0.065	0.061	0.070	0.082	0.094	0.110	0.125
18	0.050	0.068	0.072	0.072	0.085	0.095	0.100	0.120	0.135
20	0.055	0.070	0.090	0.090	0.105	0.120	0.140	0.150	0.165

ULTRABITE

100

High Performance

Z4



≤ 62 HRC

+AlCrN

FORM HA DIN 6535

FORM HB DIN 6535



Steel	●
Stainless Steel	●
Hardened Steel ≤54 HRC	●
Hardened Steel >54 HRC	●
Cast Iron	●
Graphite	○
Non Ferrous Material	○
HRSA	○
Titanium	○

● Recommended ● Acceptable ○ Not Recommended

*Marked products can be delivered quickly from stock.