

101

High Performance

S	Order No	Code	d1 h9	d2 h6	d3	l1	l2	l3	l4	Corner	Weldon Order No
*	14100	101.4.0300.0570.R0020.0110.0280.0140.05.S06K1C03.01	3	6	2,8	57	11	14	5	R 0.20	14101
*	14102	101.4.0400.0570.R0020.0120.0380.0160.06.S06K1C03.01	4	6	3,8	57	12	16	6	R 0.20	14103
*	14104	101.4.0500.0570.R0020.0130.0480.0170.06.S06K1C03.01	5	6	4,8	57	13	17	6	R 0.20	14105
*	14106	101.4.0500.0570.R0050.0130.0480.0170.06.S06K1C03.01	5	6	4,8	57	13	17	6	R 0.50	14107
*	14108	101.4.0600.0570.R0020.0150.0570.0190.08.S06K1C03.01	6	6	5,7	57	15	19	8	R 0.20	14109
*	14110	101.4.0600.0570.R0050.0150.0570.0190.08.S06K1C03.01	6	6	5,7	57	15	19	8	R 0.50	14111
*	14112	101.4.0700.0630.R0020.0210.0650.0270.10.S08K1C03.01	7	8	6,5	63	21	27	10	R 0.20	14113
*	14114	101.4.0800.0630.R0020.0210.0770.0270.10.S08K1C03.01	8	8	7,7	63	21	27	10	R 0.20	14115
*	14116	101.4.0800.0630.R0050.0210.0770.0270.10.S08K1C03.01	8	8	7,7	63	21	27	10	R 0.50	14117
*	14118	101.4.0800.0630.R0100.0210.0770.0270.10.S08K1C03.01	8	8	7,7	63	21	27	10	R 1.00	14119
*	14120	101.4.0800.0630.R0200.0210.0770.0270.10.S08K1C03.01	8	8	7,7	63	21	27	10	R 2.00	14121
*	14122	101.4.1000.0720.R0020.0210.0950.0260.12.S10K1C03.01	10	10	9,5	72	21	26	12	R 0.20	14123
*	14124	101.4.1000.0720.R0050.0210.0950.0260.12.S10K1C03.01	10	10	9,5	72	21	26	12	R 0.50	14125
*	14126	101.4.1000.0720.R0080.0210.0950.0260.12.S10K1C03.01	10	10	9,5	72	21	26	12	R 0.80	14127
*	14128	101.4.1000.0720.R0100.0210.0950.0260.12.S10K1C03.01	10	10	9,5	72	21	26	12	R 1.00	14129
*	14130	101.4.1000.0720.R0150.0210.0950.0260.12.S10K1C03.01	10	10	9,5	72	21	26	12	R 1.50	14131
*	14132	101.4.1000.0720.R0200.0210.0950.0260.12.S10K1C03.01	10	10	9,5	72	21	26	12	R 2.00	14133
*	14134	101.4.1000.0720.R0300.0210.0950.0260.12.S10K1C03.01	10	10	9,5	72	21	26	12	R 3.00	14135
*	14136	101.4.1200.0830.R0030.0290.1150.0380.16.S12K1C03.01	12	12	11,5	83	29	38	16	R 0.30	14137
*	14138	101.4.1200.0830.R0050.0290.1150.0380.16.S12K1C03.01	12	12	11,5	83	29	38	16	R 0.50	14139
*	14140	101.4.1200.0830.R0100.0290.1150.0380.16.S12K1C03.01	12	12	11,5	83	29	38	16	R 1.00	14141
*	14142	101.4.1200.0830.R0150.0290.1150.0380.16.S12K1C03.01	12	12	11,5	83	29	38	16	R 1.50	14143
*	14144	101.4.1200.0830.R0200.0290.1150.0380.16.S12K1C03.01	12	12	11,5	83	29	38	16	R 2.00	14145
*	14146	101.4.1200.0830.R0300.0290.1150.0380.16.S12K1C03.01	12	12	11,5	83	29	38	16	R 3.00	14147
*	14148	101.4.1400.0820.R0000.0260.1350.0350.13.S14K1C03.01	14	14	13,5	82	26	35	13	Ch 0.00	14149
*	14150	101.4.1400.0820.R0030.0260.1350.0350.13.S14K1C03.01	14	14	13,5	82	26	35	13	R 0.30	14151
*	14152	101.4.1600.0920.R0030.0360.1550.0430.21.S16K1C03.01	16	16	15,5	92	36	43	21	R 0.30	14153
*	14154	101.4.1600.0920.R0050.0360.1550.0430.21.S16K1C03.01	16	16	15,5	92	36	43	21	R 0.50	14155
*	14156	101.4.1600.0920.R0100.0360.1550.0430.21.S16K1C03.01	16	16	15,5	92	36	43	21	R 1.00	14157
*	14158	101.4.1600.0920.R0150.0360.1550.0430.21.S16K1C03.01	16	16	15,5	92	36	43	21	R 1.50	14159
*	14160	101.4.2000.1040.R0030.0380.1950.0530.19.S20K1C03.01	20	20	19,5	104	38	53	19	R 0.30	14161

Cutting Parameters

Material	Slotting ap=1.00 Vc (m/min)	Shoulder Milling ap=1.50 / ae=0.35 - 0.200 Vc (m/min)	Son Yüzeze Frezeleme ap=1.50 / ae=0.20 - 0.100 Vc (m/min)
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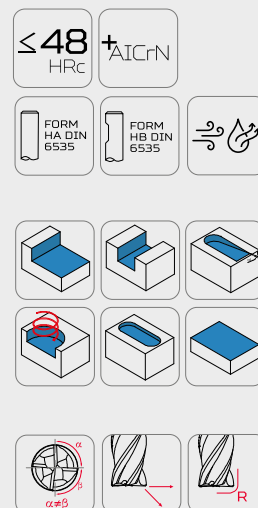


Steel	Unalloyed Steel	100-130	130-160	150-180
	Steel	100-130	130-160	150-180
	Tempered Steel	80-110	110-140	130-160
	Cold Work Tool Steel	70-100	90-120	110-135
	Hot Work Tool Steel	65-95	80-110	100-125
Stainless Steel	AISI 304 - 416 - 420	20-50	30-60	50-90
	AISI 316 - 440	20-50	30-60	50-90
	17-4 PH 15-5 PH	20-40	30-50	40-70
	Chrome-Cobalt Alloy	20-40	30-50	40-70
Cast Iron	Gray Cast Iron	70-100	100-130	120-150
	Alloyed Cast Iron	70-100	90-120	110-145
Hardened Steel	Precision Cast Iron	50-80	70-100	90-115
	< 54 HRC	25-35	35-40	35-45
HRSA	HRSA Hastelloy	30-50	40-60	50-70
	HRSA Inconel 625	30-50	40-60	50-70
	HRSA Inconel 718	30-50	40-60	50-70
	HRSA Nimonic	30-50	40-60	50-70
Titanium	Titanium	30-50	70-90	80-90
	Titanium Alloys	30-50	70-90	80-90

Feed Per Tooth (mm/tooth)

	ap=10	ap=1.500	ae=0.350	ae=0.300	ae=0.250	ae=0.200	ae=0.150	ae=0.100
0								
3	0.003	0.004	0.010	0.012	0.013	0.015	0.016	0.017
4	0.005	0.005	0.012	0.015	0.019	0.020	0.022	0.026
5	0.006	0.007	0.015	0.018	0.022	0.027	0.030	0.035
6	0.007	0.009	0.017	0.020	0.023	0.028	0.031	0.036
8	0.011	0.014	0.019	0.022	0.025	0.029	0.032	0.037
10	0.014	0.018	0.030	0.032	0.036	0.039	0.041	0.046
12	0.020	0.025	0.034	0.038	0.041	0.045	0.047	0.051
14	0.025	0.031	0.040	0.045	0.050	0.056	0.061	0.066
16	0.031	0.038	0.050	0.056	0.062	0.068	0.073	0.078
20	0.046	0.054	0.070	0.076	0.084	0.090	0.096	0.111

Z4



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.