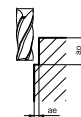
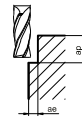
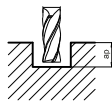
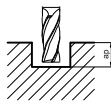


S	Order No	Code	d1h9	d2h6	d3	l1	l2	l3	Corner
	17100	111P.4.0600.0800.R0050.0160.0590.0217.00.S06C1C01.01	6	6	5,9	80	16	21,7	R 0.50
	17102	111P.4.0600.0800.R0100.0160.0590.0217.00.S06C1C01.01	6	6	5,9	80	16	21,7	R 1.00
	17104	111P.4.0800.0800.R0050.0200.0780.0255.00.S08C1C01.01	8	8	7,8	80	20	25,5	R 0.50
	17106	111P.4.0800.0800.R0100.0200.0780.0255.00.S08C1C01.01	8	8	7,8	80	20	25,5	R 1.00
	17108	111P.4.1000.1000.R0050.0220.0980.0315.00.S10C1C01.01	10	10	9,8	100	22	31,5	R 0.50
	17110	111P.4.1000.1000.R0100.0220.0980.0315.00.S10C1C01.01	10	10	9,8	100	22	31,5	R 1.00
	17112	111P.4.1200.1000.R0050.0280.1170.0392.00.S12C1C01.01	12	12	11,7	100	28	39,2	R 0.50
	17114	111P.4.1200.1000.R0100.0280.1170.0392.00.S12C1C01.01	12	12	11,7	100	28	39,2	R 1.00

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	100-130	120 -160	150-180	170-220
	Steel	100-130	120 -150	150-180	170-220
	Tempered Steel	90-120	110 -150	130-170	150-200
	Cold Work Tool Steel	80 -110	100-140	120 -150	140-180
	Hot Work Tool Steel	80-110	100-140	120 -150	140-180
Stainless Steel	AISI 304 - 416 - 420		50-70	70-90	80-100
	AISI 316 - 440		45-70	55-80	60-90
	17-4 PH 15-5 PH		45-70	55-80	60-90
	Cobalt-Chrome Alloys		30-50	35-55	40-70
	Duplex F51		60-80	65-85	70-90
HRSA	Super Duplex F55		60-80	65-85	70-90
	HRSA Hastelloy	35-60	30-50	40-60	50-70
	HRSA Inconel 625	35-60	30-50	40-60	50-70
	HRSA Inconel 718	35-60	30-50	40-60	50-70
	HRSA Nimonic	35-60	30-50	40-60	50-70
Titanium	Titanium	50-70	60-80	70-90	80-90
	Titanium alloys	50-70	60-80	70-90	80-90
Hardened Steel	>54 HRC		50-70	55-75	60-85

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	0,007	0,008	0,009	0,01	0,012	0,0125	0,013	0,014	0,016
4	0,009	0,01	0,01	0,02	0,025	0,026	0,028	0,029	0,03
5	0,01	0,011	0,02	0,03	0,035	0,036	0,038	0,04	0,045
6	0,02	0,028	0,03	0,045	0,05	0,057	0,059	0,061	0,065
8	0,03	0,04	0,045	0,05	0,06	0,068	0,07	0,073	0,078
10	0,04	0,045	0,05	0,06	0,07	0,075	0,078	0,08	0,082
12	0,05	0,06	0,065	0,07	0,08	0,09	0,1	0,11	0,13
16	0,08	0,095	0,1	0,12	0,13	0,14	0,145	0,15	0,16
20	0,09	0,12	0,15	0,17	0,175	0,18	0,185	0,19	0,22

ULTR Δ -BITEPLUS **111**
High Performance

Z4



≤55 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