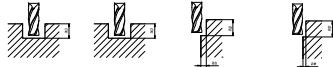


S	Order No	Code	d1h9	d2h6	d3	L1	L2	L3	Corner	Weldon Order No
*	16100	111.4.0300.0580.R0020.0090.0290.0120.00.S06C1C01.01	3	6	2,9	58	9	12	R 0.20	16101
*	16102	111.4.0400.0580.R0020.0120.0390.0150.00.S06C1C01.01	4	6	3,9	58	12	15	R 0.20	16103
*	16104	111.4.0400.0580.R0050.0120.0390.0150.00.S06C1C01.01	4	6	3,9	58	12	15	R 0.50	16105
*	16106	111.4.0500.0580.R0020.0150.0490.0180.00.S06C1C01.01	5	6	4,9	58	15	18	R 0.20	16107
*	16108	111.4.0600.0580.R0020.0160.0590.0210.00.S06C1C01.01	6	6	5,9	58	16	21	R 0.20	16109
*	16110	111.4.0600.0580.R0050.0160.0590.0210.00.S06C1C01.01	6	6	5,9	58	16	21	R 0.50	16111
*	16112	111.4.0600.0580.R0100.0170.0570.0270.00.S06C1C01.01	6	6	5,7	58	17	27	R 1.00	16113
*	16114	111.4.0800.0640.R0020.0200.0780.0250.00.S08C1C01.01	8	8	7,8	64	20	25	R 0.20	16115
*	16116	111.4.0800.0640.R0030.0200.0780.0250.00.S08C1C01.01	8	8	7,8	64	20	25	R 0.30	16117
*	16118	111.4.0800.0640.R0050.0200.0780.0250.00.S08C1C01.01	8	8	7,8	64	20	25	R 0.50	16119
*	16120	111.4.0800.0640.R0100.0200.0780.0250.00.S08C1C01.01	8	8	7,8	64	20	25	R 1.00	16121
*	16122	111.4.0800.0640.R0200.0200.0780.0250.00.S08C1C01.01	8	8	7,8	64	20	25	R 2.00	16123
*	16124	111.4.0800.0640.R0300.0200.0780.0250.00.S08C1C01.01	8	8	7,8	64	20	25	R 3.00	16125
*	16126	111.4.1000.0730.R0020.0220.0980.0310.00.S10C1C01.01	10	10	9,8	73	22	31	R 0.20	16127
*	16128	111.4.1000.0730.R0050.0220.0980.0310.00.S10C1C01.01	10	10	9,8	73	22	31	R 0.50	16129
*	16130	111.4.1000.0730.R0080.0220.0980.0310.00.S10C1C01.01	10	10	9,8	73	22	31	R 0.80	16131
*	16132	111.4.1000.0730.R0100.0220.0980.0310.00.S10C1C01.01	10	10	9,8	73	22	31	R 1.00	16133
*	16134	111.4.1000.0730.R0200.0220.0980.0310.00.S10C1C01.01	10	10	9,8	73	22	31	R 2.00	16135
*	16136	111.4.1000.0730.R0300.0220.0980.0310.00.S10C1C01.01	10	10	9,8	73	22	31	R 3.00	16137
*	16138	111.4.1200.0820.R0020.0280.1170.0390.00.S12C1C01.01	12	12	11,7	82	28	39	R 0.20	16139
*	16140	111.4.1200.0820.R0050.0280.1170.0390.00.S12C1C01.01	12	12	11,7	82	28	39	R 0.50	16141
*	16142	111.4.1200.0820.R0080.0280.1170.0390.00.S12C1C01.01	12	12	11,7	82	28	39	R 0.80	16143
*	16144	111.4.1200.0820.R0100.0280.1170.0390.00.S12C1C01.01	12	12	11,7	82	28	39	R 1.00	16145
*	16146	111.4.1200.0820.R0150.0280.1170.0390.00.S12C1C01.01	12	12	11,7	82	28	39	R 1.50	16147
*	16148	111.4.1200.0820.R0300.0280.1170.0390.00.S12C1C01.01	12	12	11,7	82	28	39	R 3.00	16149
*	16150	111.4.1600.0930.R0020.0360.1570.0470.00.S16C1C01.01	16	16	15,7	93	36	47	R 0.20	16151
*	16152	111.4.1600.0930.R0030.0360.1570.0470.00.S16C1C01.01	16	16	15,7	93	36	47	R 0.30	16153
*	16154	111.4.1600.0930.R0050.0360.1570.0470.00.S16C1C01.01	16	16	15,7	93	36	47	R 0.50	16155
*	16156	111.4.1600.0930.R0200.0360.1570.0470.00.S16C1C01.01	16	16	15,7	93	32	46	R 2.00	16157
*	16158	111.4.1600.0930.R0400.0320.1570.0460.00.S16C1C01.01	16	16	15,7	93	36	47	R 4.00	16159
*	16160	111.4.1600.0930.R0075.0360.1570.0470.00.S16C1C01.01	16	16	15,7	93	36	47	R 0.75	16161
*	16162	111.4.1600.0930.R0100.0360.1570.0470.00.S16C1C01.01	16	16	15,7	93	36	47	R 1.00	16163
*	16164	111.4.1600.0930.R0150.0360.1570.0470.00.S16C1C01.01	16	16	15,7	93	36	47	R 1.50	16165
*	16166	111.4.2000.1050.R0050.0380.1970.0570.00.S20C1C01.01	20	20	19,7	105	38	57	R 0.50	16167
*	16168	111.4.2000.1050.R0100.0380.1970.0570.00.S20C1C01.01	20	20	19,7	105	38	57	R 1.00	16169

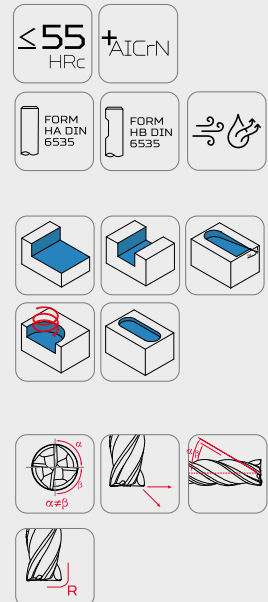
Cutting Parameters				
Material	Slotting ap=15-10	Slotting ap=10-0.50	Shoulder Milling ap=150 / ae=0.35-0.200	Finish Milling ap=150 / ae=0.20-0.100
	Vc (m/min)	Vc (m/min)	Vc (m/min)	Vc (m/min)



Feed Per Tooth (mm/tooth)										
0	ap=150	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	

	Material			
	Unalloyed Steel	Steel	Tempered Steel	Cold Work Tool Steel
Steel	Hot Work Tool Steel	AISI 304 - 416 - 420	AISI 316 - 440	17-4 PH 15-5 PH
	Cobalt-Chrome Alloys	Duplex F51	Super Duplex F55	HRSA Hastelloy
	HRSA Inconel 625	HRSA Inconel 718	HRSA Nimonic	Titanium
	Titanium Alloys	< 54 HRC		
Stainless Steel				
HRSA				
Hardened Steel				
Titanium				

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.