

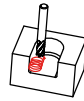
Gen-Z 156

High Performance Machining

S	Order No	Code	d1h9	d2h6	d3	l1	l2	l3	Corner
	63100	156.6.1000.0730.R0050.0220.0950.0300.00.S10C3C01.01	10	10	9,5	73	22	30	R 0.50
	63102	156.6.1000.0730.R0100.0220.0950.0300.00.S10C3C01.01	10	10	9,5	73	22	30	R 1.00
	63104	156.6.1200.0820.R0050.0260.1140.0360.00.S12C3C01.01	12	12	11,4	82	26	36	R 0.50
	63106	156.6.1200.0820.R0100.0260.1140.0360.00.S12C3C01.01	12	12	11,4	82	26	36	R 1.00
	63108	156.6.1600.0930.R0100.0340.1520.0410.00.S16C3C01.01	16	16	15,2	93	34	41	R 1.00
	63110	156.6.1600.0930.R0200.0340.1520.0410.00.S16C3C01.01	16	16	15,2	93	34	41	R 2.00
	63112	156.6.2000.1050.R0300.0420.1900.0520.00.S20C3C01.01	20	20	19	105	42	52	R 3.00

Cutting Parameters - Trochoidal

Material	Shoulder Milling ap=2xØ/ae=0,05-0,12Ø Vc (m/min)	Shoulder Milling ap=3xØ/ae=0,05-0,1Ø Vc (m/min)	Shoulder Milling ap=4xØ/ae=0,05-0,1Ø Vc (m/min)
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Steel	Unalloyed Steel	220-250	220-250	200-230
	Steel	210-240	210-240	190-220
	Tempered Steel	110-140	110-140	100-120
	Cold Work Tool Steel	80-110	75-105	70-90
	Hot Work Tool Steel	80-110	75-105	70-90
Stainless Steel	AISI 304-416-420	120-150	120-150	95-125
	AISI 316-440	100-130	90-120	80-110
	17-4 PH 15-5 PH	90-120	80-110	70-100
	Chrome-Cobalt Alloy	70-100	70-90	65-85
	Duplex F51	90-130	90-130	70-110
Cast Iron	Super Duplex F55	90-130	90-130	70-110
	Gray Cast Iron	200-235	200-235	195-215
	Alloyed Cast Iron	200-240	200-240	190-220
	Precision Cast Iron	200-245	200-245	190-225
	Titanium	Iron-Based Super Alloys	45-65	45-65
Nickel-Based Super Alloys		40-55	40-55	40-50
Titanium-Based Super Alloys		100-120	95-115	90-105

Feed Per Tooth (mm/tooth)

Ø	ap=2xØ	ap=3xØ	ap=4xØ
4	0,016-0,032		
6	0,036-0,072	0,036-0,072	0,04-0,07
8	0,048-0,096	0,048-0,086	0,05-0,08
10	0,075-0,15	0,06-0,12	0,05-0,08
12	0,09-0,18	0,072-0,144	0,06-0,09
14	0,105-0,21	0,084-0,168	0,07-0,1
16	0,12-0,24	0,07-0,1	0,07-0,1
18	0,135-0,27	0,12-0,15	0,12-0,15
20	0,15-0,3	0,12-0,24	0,13-0,16



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

● Recommended ● Acceptable ○ Not Recommended