

S	Order No	Code	d1h9	d2h6	d3	l1	l2	l3	Corner	Weldon Order No
*	10100	97.4.0300.0500.K0000.0060.0000.0000.00.S06B1A01.01	3	6	-	50	6	-	Ch 0.00	10101
*	10102	97.4.0300.0510.C0010.0060.0000.0000.00.S06H1A01.01	3	6	-	51	6	-	Ch 0.10	10103
	10104	97.4.0300.0510.C0010.0030.0280.0063.00.S06H1A01.01	3	6	2,8	51	3	6,3	Ch 0.10	10105
*	10106	97.4.0300.0580.R0015.0060.0280.0150.00.S06H1A01.01	3	6	2,8	58	6	15	R 0.15	10107
*	10108	97.4.0300.0580.R0015.0100.0280.0130.00.S06H1A01.01	3	6	2,8	58	10	13	R 0.15	10109
*	10110	97.4.0400.0500.K0000.0120.0380.0200.00.S06B1A01.01	4	6	3,8	50	12	20	Ch 0.00	10111
*	10112	97.4.0400.0580.R0015.0090.0380.0120.00.S06H1A01.01	4	6	3,8	58	9	12	R 0.15	10113
*	10114	97.4.0400.0580.R0015.0090.0380.0180.00.S06H1A01.01	4	6	3,8	58	9	18	R 0.15	10115
*	10116	97.4.0400.0580.R0015.0120.0380.0190.00.S06H1A01.01	4	6	3,8	58	12	19	R 0.15	10117
*	10118	97.4.0500.0500.K0000.0120.0480.0180.00.S06B1A01.01	5	6	4,8	50	12	18	Ch 0.00	10119
*	10120	97.4.0500.0580.R0015.0130.0480.0180.00.S06B1A01.01	5	6	4,8	58	13	18	R 0.15	10121
*	10122	97.4.0600.0500.K0000.0150.0000.0000.00.S06B1A01.01	6	6	-	50	15	0	Ch 0.00	10123
*	10124	97.4.0600.0580.R0015.0160.0570.0230.00.S06B1A01.01	6	6	5,7	58	16	23	R 0.15	10125
	10126	97.4.0700.0640.C0020.0200.0670.0270.00.S08B1A01.01	7	8	6,7	64	20	27	Ch 0.20	10127
*	10128	97.4.0800.0640.K0000.0200.0000.0000.00.S08B1A01.01	8	8	-	64	20	-	Ch 0.00	10129
*	10130	97.4.0800.0640.C0020.0200.0770.0270.00.S08B1A01.01	8	8	7,7	64	20	27	Ch 0.20	10131
*	10132	97.4.1000.0730.K0000.0260.0000.0000.00.S10B1A01.01	10	10	-	73	26	-	Ch 0.00	10133
*	10134	97.4.1000.0730.C0020.0260.0950.0320.00.S10B1A01.01	10	10	9,5	73	26	32	Ch 0.20	10135
*	10136	97.4.1200.0820.C0030.0280.1150.0380.00.S12B1A01.01	12	12	11,5	82	28	38	Ch 0.30	10137
*	10138	97.4.1400.0820.C0030.0300.1370.0420.00.S14B1A01.01	14	14	13,7	82	30	42	Ch 0.30	10139
*	10140	97.4.1600.0930.C0030.0360.1550.0440.00.S16B1A01.01	16	16	15,5	93	36	44	Ch 0.30	10141
	10142	97.4.1600.0930.C0050.0340.0000.0000.00.S16B1A01.01	16	16	-	93	34	-	Ch 0.50	10143
	10144	97.4.1800.0930.C0030.0350.1750.0440.00.S18B1A01.01	18	18	17,5	93	35	44	Ch 0.30	10145
*	10146	97.4.2000.1050.C0030.0380.1950.0540.00.S20B1A01.01	20	20	19,5	105	38	54	Ch 0.30	10147
	10148	97.4.2000.1050.K0000.0380.1950.0540.00.S20B1A01.01	20	20	19,5	105	38	54	Ch 0.00	10149
	10150	97.4.1200.0820.C0010.0280.1170.0360.00.S12B1A02.01	12	12	11,7	82	28	36	Ch 0.10	10151
	10152	97.4.1200.0820.C0010.0280.1170.0360.00.S12C1A02.01	12	12	11,7	82	28	36	Ch 0.10	10153
*	10154	97.4.0500.0580.C0010.0150.0480.0180.00.S06C1A02.01	5	6	4,8	58	15	18	Ch 0.10	10155
*	10156	97.4.0600.0580.R0015.0160.0570.0230.00.S06H1A02.01	6	6	5,7	58	16	23	R 0.15	10157
*	10158	97.4.0800.0640.C0015.0200.0770.0270.00.S08C1A02.01	8	8	7,7	64	20	27	Ch 0.15	10159

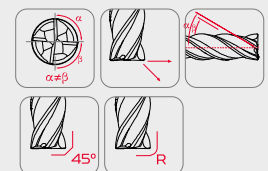
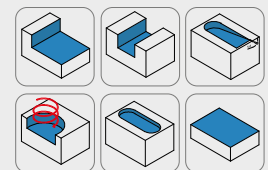
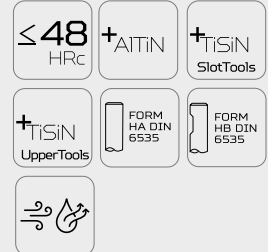
Cutting Parameters

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)
Unalloyed Steel	150-190	190-220	220-250	250-300
Steel	140-180	180-210	210-240	240-280
Tempered Steel	80-110	100-130	130-160	160-200
Cold Work Tool Steel	80-100	90-120	110-140	130-150
Hot Work Tool Steel	70-100	80-110	100-130	120-140
AlSi 304 - 416 - 420		50-70	70-90	80-100
AlSi 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
Super Duplex F55		60-80	65-85	70-90
Gray Cast Iron	90-130	130-180	180-220	220-260
Alloyed Cast Iron	90-130	130-180	180-220	220-260
Precision Cast Iron	80-120	120-160	160-195	180-220

Feed Per Tooth (mm/tooth)

ϕ	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	0.004	0.006	0.008	0.010	0.012	0.016	0.020	0.030	0.042
4	0.007	0.009	0.013	0.016	0.020	0.025	0.030	0.038	0.049
5	0.010	0.013	0.017	0.020	0.025	0.031	0.036	0.046	0.058
6	0.014	0.018	0.022	0.026	0.030	0.037	0.044	0.050	0.062
8	0.020	0.025	0.029	0.034	0.040	0.048	0.056	0.064	0.073
10	0.026	0.030	0.038	0.042	0.050	0.059	0.067	0.076	0.088
12	0.035	0.042	0.053	0.060	0.070	0.080	0.092	0.102	0.115
16	0.042	0.060	0.082	0.100	0.110	0.120	0.130	0.138	0.150
20	0.05	0.065	0.085	0.100	0.110	0.120	0.130	0.138	0.150

Z4



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

● Recommended ● Acceptable ○ Not Recommended