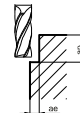
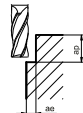


| S | Order No | Code                                               | d1 h9 | d2 h6 | L1  | L2 | Corner  | Z | Weldon Order No |
|---|----------|----------------------------------------------------|-------|-------|-----|----|---------|---|-----------------|
| * | 11100    | 98.3.0300.0510.C0003.0060.0000.0000.00.S06C1C02.01 | 3     | 6     | 51  | 6  | Ch 0.03 | 3 | 11101           |
| * | 11102    | 98.4.0300.0510.R0020.0060.0000.0000.00.S06C1B01.01 | 3     | 6     | 51  | 6  | R 0.20  | 4 | 11103           |
| * | 11104    | 98.4.0400.0580.R0020.0120.0000.0000.00.S06C1B01.01 | 4     | 6     | 58  | 12 | R 0.20  | 4 | 11105           |
| * | 11106    | 98.4.0400.0580.R0050.0120.0000.0000.00.S06C1B01.01 | 4     | 6     | 58  | 12 | R 0.50  | 4 | 11107           |
| * | 11108    | 98.4.0400.0580.R0100.0120.0000.0000.00.S06C1B01.01 | 4     | 6     | 58  | 12 | R 1.00  | 4 | 11109           |
| * | 11110    | 98.4.0600.0580.R0020.0140.0000.0000.00.S06C1B01.01 | 6     | 6     | 58  | 14 | R 0.20  | 4 | 11111           |
| * | 11112    | 98.4.0600.0580.R0050.0140.0000.0000.00.S06C1B01.01 | 6     | 6     | 58  | 14 | R 0.50  | 4 | 11113           |
| * | 11114    | 98.4.0600.0580.R0100.0140.0000.0000.00.S06C1B01.01 | 6     | 6     | 58  | 14 | R 1.00  | 4 | 11115           |
| * | 11116    | 98.4.0600.0580.R0150.0140.0000.0000.00.S06C1B01.01 | 6     | 6     | 58  | 14 | R 1.50  | 4 | 11117           |
| * | 11118    | 98.4.0800.0640.R0020.0230.0000.0000.00.S08C1B01.01 | 8     | 8     | 64  | 23 | R 0.20  | 4 | 11119           |
| * | 11120    | 98.4.0800.0640.R0050.0230.0000.0000.00.S08C1B01.01 | 8     | 8     | 64  | 23 | R 0.50  | 4 | 11121           |
| * | 11122    | 98.4.0800.0640.R0150.0230.0000.0000.00.S08C1B01.01 | 8     | 8     | 64  | 23 | R 1.50  | 4 | 11123           |
| * | 11124    | 98.4.0800.0640.R0200.0230.0000.0000.00.S08C1B01.01 | 8     | 8     | 64  | 23 | R 2.00  | 4 | 11125           |
| * | 11152    | 98.4.0800.0640.C0030.0170.0000.0000.00.S08C1B01.01 | 8     | 8     | 64  | 17 | Ch 0.30 | 4 | 11153           |
| * | 11126    | 98.4.1000.0730.R0020.0240.0000.0000.00.S10C1B01.01 | 10    | 10    | 73  | 24 | R 0.20  | 4 | 11127           |
| * | 11128    | 98.4.1000.0730.R0050.0240.0000.0000.00.S10C1B01.01 | 10    | 10    | 73  | 24 | R 0.50  | 4 | 11129           |
| * | 11130    | 98.4.1000.0730.R0100.0240.0000.0000.00.S10C1B01.01 | 10    | 10    | 73  | 24 | R 1.00  | 4 | 11131           |
| * | 11132    | 98.4.1000.0730.R0200.0240.0000.0000.00.S10C1B01.01 | 10    | 10    | 73  | 24 | R 2.00  | 4 | 11133           |
| * | 11134    | 98.4.1200.0650.R0020.0260.0000.0000.00.S12C2B01.01 | 12    | 12    | 65  | 26 | R 0.20  | 4 | 11135           |
| * | 11136    | 98.4.1200.0820.R0020.0280.0000.0000.00.S12C1B01.01 | 12    | 12    | 82  | 28 | R 0.20  | 4 | 11137           |
| * | 11138    | 98.4.1200.0820.R0050.0280.0000.0000.00.S12C1B01.01 | 12    | 12    | 82  | 28 | R 0.50  | 4 | 11139           |
| * | 11140    | 98.4.1200.0820.R0100.0280.0000.0000.00.S12C1B01.01 | 12    | 12    | 82  | 28 | R 1.00  | 4 | 11141           |
| * | 11142    | 98.4.1200.0820.R0200.0280.0000.0000.00.S12C1B01.01 | 12    | 12    | 82  | 28 | R 2.00  | 4 | 11143           |
| * | 11144    | 98.4.1200.0820.R0400.0280.0000.0000.00.S12C1B01.01 | 12    | 12    | 82  | 28 | R 4.00  | 4 | 11145           |
| * | 11146    | 98.4.1600.0930.R0020.0380.0000.0000.00.S16C1B01.01 | 16    | 16    | 93  | 38 | R 0.20  | 4 | 11147           |
| * | 11148    | 98.4.1600.0930.R0050.0380.0000.0000.00.S16C1B01.01 | 16    | 16    | 93  | 38 | R 0.50  | 4 | 11149           |
| * | 11150    | 98.4.2000.1050.R0500.0440.0000.0000.00.S20C1B01.01 | 20    | 20    | 105 | 44 | R 5.00  | 4 | 11151           |

## Cutting Parameters

| Material | Slotting<br>ap=1.0 - 0.50 | Shoulder Milling<br>ap=1.50 / ae=0.35 - 0.200 | Finish Milling<br>ap=1.50 / ae=0.20 - 0.100 |
|----------|---------------------------|-----------------------------------------------|---------------------------------------------|
|          | Vc (m/min)                | Vc (m/min)                                    | Vc (m/min)                                  |



|                 |                      |       |       |        |
|-----------------|----------------------|-------|-------|--------|
| 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  |
|                 | Chrome-Cobalt Alloy  | 30-50 | 35-55 | 40-70  |
|                 | Cr - Co Alloys       | 60-80 | 65-85 | 70-90  |
|                 | Duplex F51           | 60-80 | 65-85 | 70-90  |
|                 | Super Duplex F55     | 30-50 | 40-60 | 50-70  |
|                 | 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            | HRSA Nimonic         | 60-80 | 70-90 | 80-90  |
|                 | Titanium             | 60-80 | 70-90 | 80-90  |

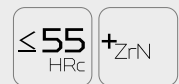
## Feed Per Tooth (mm/tooth)

|    | 0 | ap=10 | ap=0.500 | ae=0.350 | ae=0.300 | ae=0.250 | ae=0.200 | ae=0.150 | ae=0.100 |
|----|---|-------|----------|----------|----------|----------|----------|----------|----------|
| 3  |   | 0.006 | 0.007    | 0.007    | 0.007    | 0.007    | 0.008    | 0.008    | 0.010    |
| 4  |   | 0.008 | 0.010    | 0.009    | 0.009    | 0.010    | 0.010    | 0.011    | 0.014    |
| 5  |   | 0.011 | 0.014    | 0.012    | 0.013    | 0.013    | 0.014    | 0.015    | 0.019    |
| 6  |   | 0.014 | 0.017    | 0.015    | 0.016    | 0.017    | 0.018    | 0.020    | 0.024    |
| 8  |   | 0.020 | 0.024    | 0.022    | 0.023    | 0.024    | 0.025    | 0.028    | 0.034    |
| 10 |   | 0.027 | 0.029    | 0.030    | 0.031    | 0.032    | 0.034    | 0.038    | 0.046    |
| 12 |   | 0.035 | 0.040    | 0.040    | 0.041    | 0.043    | 0.045    | 0.050    | 0.061    |
| 16 |   | 0.055 | 0.065    | 0.061    | 0.063    | 0.066    | 0.069    | 0.077    | 0.094    |
| 20 |   | 0.075 | 0.090    | 0.083    | 0.086    | 0.090    | 0.094    | 0.105    | 0.128    |

Z3



Z4



+ZrN



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

● Recommended ○ Acceptable ○ Not Recommended