

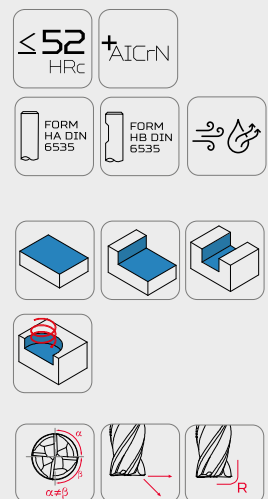
S	Order No	Code	d1 h9	d2 h6	d3	L1	L2	L3	Corner	Weldon Order No
*	12100	99.5.0500.0580.R0020.0150.0470.0200.00.S06B1C01.01	5	6	4,7	58	15	20	R 0.20	12101
*	12102	99.5.0500.0580.R0050.0150.0470.0200.00.S06B1C01.01	5	6	4,7	58	15	20	R 0.50	12103
*	12104	99.5.0600.0580.K0000.0150.0570.0200.00.S06B1C01.01	6	6	5,7	58	15	20	Ch 0.00	12105
*	12106	99.5.0600.0580.R0020.0150.0570.0200.00.S06B1C01.01	6	6	5,7	58	15	20	R 0.20	12107
*	12108	99.5.0600.0580.R0050.0150.0570.0200.00.S06B1C01.01	6	6	5,7	58	15	20	R 0.50	12109
*	12110	99.5.0600.0580.R0100.0150.0570.0200.00.S06B1C01.01	6	6	5,7	58	15	20	R 1.00	12111
*	12112	99.5.0600.0580.R0150.0150.0570.0200.00.S06B1C01.01	6	6	5,7	58	15	20	R 1.50	12113
	12114	99.5.0600.1000.R0050.0150.0570.0600.00.S06B1C01.01	6	6	5,7	100	15	60	R 0.50	12115
*	12116	99.5.0800.0640.K0000.0220.0770.0290.00.S08B1C01.01	8	8	7,7	64	22	29	Ch 0.00	12117
*	12118	99.5.0800.0640.R0030.0220.0770.0290.00.S08B1C01.01	8	8	7,7	64	22	29	R 0.30	12119
*	12120	99.5.0800.0640.R0050.0220.0770.0290.00.S08B1C01.01	8	8	7,7	64	22	29	R 0.50	12121
	12122	99.5.0800.1100.R0050.0220.0770.0650.00.S08B1C01.01	8	8	7,7	110	22	65	R 0.50	12123
*	12124	99.5.1000.0730.K0000.0270.0950.0330.00.S10B1C01.01	10	10	9,5	73	27	33	Ch 0.00	12125
*	12126	99.5.1000.0730.R0030.0270.0950.0330.00.S10B1C01.01	10	10	9,5	73	27	33	R 0.30	12127
*	12128	99.5.1000.0730.R0050.0270.0950.0330.00.S10B1C01.01	10	10	9,5	73	27	33	R 0.50	12129
*	12130	99.5.1000.0730.R0100.0270.0950.0330.00.S10B1C01.01	10	10	9,5	73	27	33	R 1.00	12131
	12132	99.5.1000.0730.R0150.0270.0950.0330.00.S10B1C01.01	10	10	9,5	73	27	33	R 1.50	12133
*	12134	99.5.1200.0820.K0000.0300.1150.0400.00.S12B1C01.01	12	12	11,5	82	30	40	Ch 0.00	12135
*	12136	99.5.1200.0820.R0030.0300.1150.0400.00.S12B1C01.01	12	12	11,5	82	30	40	R 0.30	12137
*	12138	99.5.1200.0820.R0050.0300.1150.0400.00.S12B1C01.01	12	12	11,5	82	30	40	R 0.50	12139
*	12140	99.5.1200.0820.R0075.0300.1150.0400.00.S12B1C01.01	12	12	11,5	82	30	40	R 0.75	12141
	12142	99.5.1200.1250.R0050.0300.1150.0750.00.S12B1C01.01	12	12	11,5	125	30	75	R 0.50	12143
	12144	99.5.1400.0930.K0000.0450.1380.0500.00.S14B2C01.01	14	14	13,8	93	45	50	Ch 0.00	12145
	12146	99.5.1400.0930.R0050.0450.1380.0500.00.S14B2C01.01	14	14	13,8	93	45	50	R 0.50	12147
	12148	99.5.1400.0930.R0100.0450.1380.0500.00.S14B2C01.01	14	14	13,8	93	45	50	R 1.00	12149
	12150	99.5.1600.0930.C0020.0370.1550.0450.00.S16B1C01.01	16	16	15,5	93	37	45	Ch 0.20	12151
*	12152	99.5.1600.0930.R0030.0370.1550.0450.00.S16B1C01.01	16	16	15,5	93	37	45	R 0.30	12153
*	12154	99.5.1600.0930.R0050.0370.1550.0450.00.S16B1C01.01	16	16	15,5	93	37	45	R 0.50	12155
*	12156	99.5.1600.0930.R0075.0370.1550.0450.00.S16B1C01.01	16	16	15,5	93	37	45	R 0.75	12157
*	12158	99.5.1600.1000.R0075.0500.1550.0580.00.S16B1C01.01	16	16	15,5	100	50	58	R 0.75	12159
	12160	99.5.1600.1500.R0075.0500.1550.1000.00.S16B1C01.01	16	16	15,5	150	50	100	R 0.75	12161
	12162	99.5.1800.0930.R0030.0400.1750.0500.00.S18B1C01.01	18	18	17,5	93	40	50	R 0.30	12163
	12164	99.5.1800.0930.R0075.0400.1750.0500.00.S18B1C01.01	18	18	17,5	93	40	50	R 0.75	12165
	12166	99.5.2000.1050.K0000.0400.1950.0560.00.S20B1C01.01	20	20	19,5	105	40	56	Ch 0.00	12167
*	12168	99.5.2000.1050.R0075.0400.1950.0560.00.S20B1C01.01	20	20	19,5	105	40	56	R 0.75	12169
	12170	99.5.1000.0730.R0150.0270.0950.0330.00.S10B1C01.02	10	10	9,5	73	27	33	R 1,50	12171

Cutting Parameters				
Material	Trochoidal ap=150 / ae=0.20 - 0.100	Slotting ap=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=10	ap=1500	ae=0.350	ae=0.300	ae=0.250	ae=0.200	ae=0.150	ae=0.100
3	0,012	0,015	0,016	0,020	0,022	0,025	0,026	0,030
4	0,020	0,024	0,020	0,023	0,026	0,030	0,032	0,036
5	0,023	0,026	0,023	0,027	0,031	0,036	0,040	0,045
6	0,026	0,030	0,034	0,038	0,043	0,049	0,050	0,060
8	0,033	0,038	0,036	0,042	0,048	0,054	0,060	0,075
10	0,044	0,049	0,045	0,053	0,063	0,070	0,072	0,084
12	0,045	0,051	0,047	0,053	0,064	0,072	0,080	0,088
16	0,056	0,062	0,058	0,064	0,069	0,075	0,090	0,100
20	0,065	0,073	0,066	0,074	0,080	0,092	0,102	0,110
20	0,046	0,054	0,070	0,076	0,084	0,090	0,096	0,111

Steel	Unalloyed Steel	170-200	130-160	150-180	170-200
	Steel	170-200	130-160	150-180	170-200
	Tempered Steel	160-190	120-150	140-170	160-190
	Cold Work Tool Steel	100-130	80-100	90-110	100-130
Stainless Steel	Hot Work Tool Steel	90-110	70-90	80-100	90-110
	AISI 304 - 416 - 420	110-130	90-110	100-120	110-130
	AISI 316 - 440	110-130	90-110	100-120	110-130
	17-4 PH 15-5 PH	90-110	70-90	80-100	90-110
Cast Iron	Chrome-Cobalt Alloy	80-100	60-80	70-90	80-100
	Duplex F51	70-90	50-70	60-80	70-90
	Super Duplex F55	70-90	50-70	60-80	70-90
	Gray Cast Iron	150-180	120-150	140-160	150-180
Hardened Steel	Alloyed Cast Iron	140-160	110-140	130-150	140-160
	Precision Cast Iron	130-150	110-130	120-140	130-150
	S4 HRC	120-150	80-120	110-130	120-150
	HRSA Hastelloy	60-80	40-60	50-70	60-80
HRSA	HRSA Inconel 625	60-80	40-60	50-70	60-80
	HRSA Inconel 718	60-80	40-60	50-70	60-80
	HRSA Nimonic	60-80	40-60	50-70	60-80
	Titanium	80-100	60-80	70-90	80-100
Titanium	Titanium Alloys	80-100	60-80	70-90	80-100



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

● Recommended ○ Acceptable ○ Not Recommended