

DUO-LOCK™ • MAXIMET • 3 FLUTES BALL NOSE • APPLICATION DATA

Material Group														Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.					
	Side Milling (A) and Slotting (B)			short			medium			long									
	A		B	adaptor reach									D1 – Diameter						
	K600		K600	K600			K600			K600									
	Cutting Speed – vc m/min		Cutting Speed – vc m/min	Cutting Speed – vc m/min			Cutting Speed – vc m/min			Cutting Speed – vc m/min									
ap	ae	ap	min		max	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0
N	1	1,0 x D	0,5 x D	1,0 x D	500	-	2000	400	-	1600	300	-	1200	fz	0,075	0,090	0,120	0,150	
	2	1,0 x D	0,5 x D	1,0 x D	500	-	1500	400	-	1200	300	-	900	fz	0,068	0,081	0,108	0,135	
	3	1,0 x D	0,5 x D	1,0 x D	500	-	1500	400	-	1200	300	-	900	fz	0,053	0,063	0,084	0,105	
	4	1,0 x D	0,5 x D	1,0 x D	400	-	750	320	-	600	240	-	450	fz	0,053	0,063	0,084	0,105	
	5	1,0 x D	0,5 x D	1,0 x D	250	-	1000	200	-	800	150	-	600	fz	0,068	0,081	0,108	0,135	
	6	1,0 x D	0,5 x D	1,0 x D	100	-	750	80	-	600	60	-	450	fz	0,075	0,090	0,120	0,150	
	7	1,0 x D	0,5 x D	1,0 x D	100	-	750	80	-	600	60	-	450	fz	0,053	0,063	0,084	0,105	

NOTE: These guidelines may require variations to achieve optimum results.

Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.

Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.

Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on diameters greater than 12mm.

For better surface finish, reduce feed per tooth.