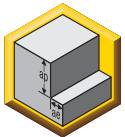




■ MaxiMet • ABDF • Wiper Facet

Material Group																		
	Side Milling (A) and Slotting (B)				short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.				
	A		B		adaptor reach									D1 – Diameter				
					K600			K600			K600							
					Cutting Speed – vc m/min			Cutting Speed – vc m/min			Cutting Speed – vc m/min							
ap	ae	ap		min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	
N	1	1,5 x D	0,3 x D	1,0 x D	500	–	2000	400	–	1200	300	–	1200	fz	0,077	0,092	0,122	0,153
	2	1,5 x D	0,3 x D	1,0 x D	500	–	1500	400	–	900	300	–	900	fz	0,069	0,083	0,110	0,138
	3	1,5 x D	0,3 x D	1,0 x D	500	–	1500	400	–	900	300	–	900	fz	0,054	0,064	0,086	0,107
	4	1,5 x D	0,3 x D	1,0 x D	400	–	750	320	–	450	240	–	450	fz	0,054	0,064	0,086	0,107
	5	1,5 x D	0,3 x D	1,0 x D	250	–	1000	200	–	600	150	–	600	fz	0,069	0,083	0,110	0,138

NOTE: Ap for spindle with ceramic bearings multiply by 0,5.

For better surface finish, reduce feed per tooth.

Above parameters are based on ideal conditions. Please adjust parameters according to system stability.

For side milling with Ap bigger than 1 x D, reduce fz by 20%!

Cylindrical shanks not recommended for full slotting.