

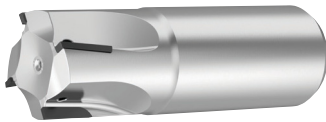





PCD END MILL • ALSB • APPLICATION DATA

Material Group												
	Side Milling (A) and Slotting (B)				KD1410			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.				
	A		B		Cutting Speed – vc m/min			D1 – Diameter				
	ap	ae	ap	min	–	max	mm	25	32	32	50	
N	1	L10	0,25 x D	0,5*L10	200	–	3000	Fz	0,180	0,200	0,200	0,220
	2	L10	0,25 x D	0,5*L10	200	–	3000	Fz	0,180	0,200	0,200	0,220
	3	L10	0,25 x D	0,5*L10	180	–	1400	Fz	0,160	0,180	0,180	0,200
	4	L10	0,25 x D	0,5*L10	200	–	800	Fz	0,140	0,160	0,160	0,180
	5	L10	0,25 x D	0,5*L10	200	–	1000	Fz	0,120	0,120	0,120	0,140
	6	L10	0,25 x D	0,5*L10	150	–	800	Fz	0,100	0,100	0,100	0,120
	7	L10	0,25 x D	0,5*L10	250	–	500	Fz	0,100	0,100	0,100	0,120

PCD HELICAL END MILL • ALSR • APPLICATION DATA

Material Group											
	Side Milling (A) and Slotting (B)				KD1410			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.			
	A		B		Cutting Speed – vc m/min			D1 – Diameter			
	ap	ae	ap	min	–	max	mm	25	32	32	–
N	1	1,25 x D	0,2 x D	0,25 x D	200	–	3000	Fz	0,180	0,200	0,200
	2	1,25 x D	0,2 x D	0,25 x D	200	–	3000	Fz	0,180	0,200	0,200
	3	1,25 x D	0,2 x D	0,25 x D	180	–	1400	Fz	0,160	0,180	0,180
	4	1,25 x D	0,2 x D	0,25 x D	200	–	800	Fz	0,140	0,160	0,160
	5	1,25 x D	0,2 x D	0,25 x D	200	–	1000	Fz	0,120	0,120	0,120
	6	1,25 x D	0,2 x D	0,25 x D	150	–	800	Fz	0,100	0,100	0,100
	7	1,25 x D	0,2 x D	0,25 x D	250	–	500	Fz	0,100	0,100	0,100