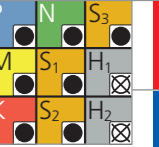


NEW

Type C - Plunge - Slot milling

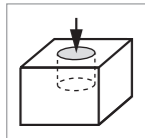
V_c [m/min] | [SFM] a_p [mm] | [inch]
f_{z,p} [mm] | [IPT] f_{z,s} [mm] | [IPT]

RECOMMENDATION FOR USE
● Excellent | ● Good | ○ Acceptable | ☒ Not recommended



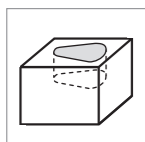
MILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW

Plunge milling



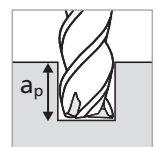
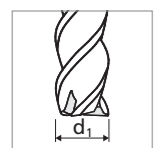
■ f_{z,p}: for plunge milling

Slot milling



■ f_{z,p}: for plunge milling

■ f_{z,s}: for slot milling



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm .039"				1/16" 1.5 mm .059"				3/32" 2.0 mm .079"				1/8" 3.0 mm .118"				Ød _i 5/32" 4.0 mm .157"				3/16" - 7/32" 5.0 mm .197"				1/4" 6.0 mm - 8.0 mm .236" - .315"			
					v _c	f _{z,p}	f _{z,s}	a _p	v _c	f _{z,p}	f _{z,s}	a _p	v _c	f _{z,p}	f _{z,s}	a _p	v _c	f _{z,p}	f _{z,s}	a _p	v _c	f _{z,p}	f _{z,s}	a _p	v _c	f _{z,p}	f _{z,s}	a _p	v _c	f _{z,p}	f _{z,s}	a _p
P	Unalloyed carbon steel Rm < 800 N/mm ²	1.0301	C10	AISI 1010																												
		1.0401	C15	AISI 1015																												
		1.1191	C45E/CK45	AISI 1045																												
		1.0044	S275JR	AISI 1020																												
		1.0715	11SMn30	AISI 1215																												
	Low alloyed steel Rm > 900 N/mm ²	1.5752	15NiCr13	ASTM 3415 / AISI 3310																												
		1.7131	16MnCr5	AISI 5115																												
		1.3505	100Cr6	AISI 52100																												
		1.7225	42CrMo4	AISI 4140																												
		1.2842	90MnCrV8	AISI O2																												
	High alloyed tool steel Rm < 1200 N/mm ²	1.2379	X153CrMoV12	AISI D2																												
		1.2436	X210CrW12	AISI D4/D6																												
		1.3343	HS6-5-2C	AISI M2 / UNS T11302																												
		1.3355	HS18-0-1	AISI T1 / UNS T12001																												
		M	Stainless steel ferritic	1.4016	X6Cr17	AISI 430 / UNS S43000																										
1.4105	X6CrMoS17			AISI 430F																												
1.4034	X46Cr13			AISI 420C																												
Stainless steel martensitic	1.4112		X90CrMoV18	AISI 440B																												
	1.4542		X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH																												
	1.4545		X5CrNiCuNb15-5	ASTM 15-5 PH																												
Stainless steel austenitic	1.4301		X5CrNi18-10	AISI 304																												
	1.4435		X2CrNiMo18-14-3	AISI 316L																												
	1.4441		X2CrNiMo18-15-3	AISI 316LM																												
K	Cast iron	0.6020	GG20	ASTM 30																												
		0.6030	GG30	ASTM 40B																												
		0.7040	GGG40	ASTM 60-40-18																												
		0.7060	GGG60	ASTM 80-60-03																												
N	Aluminium alloy wrought	3.2315	AlMgSi1	ASTM 6351																												
		3.4365	AlZnMgCu1.5	ASTM 7075																												
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380																												
		3.2381	GD-AlSi10Mg	UNS A03590																												
	Copper	2.0040	Cu-OF / CW008A	UNS C10100																												
		2.0065	Cu-ETP / CW004A	UNS C11000																												
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400																												
		2.0360	CuZn40 CW509L	UNS C28000																												
	Brass, Bronze Rm < 400 N/mm ²	2.0401	CuZn39Pb3 / CW614N	UNS C38500																												
		2.1020	CuSn6	UNS C51900																												
Bronze Rm < 600 N/mm ²	2.0966	CuAl10Ni5Fe4	UNS C63000																													
	2.0960	CuAl9Mn2	UNS C63200																													
S₁	Super alloys	2.4856		Inconel 625																												
		2.4668		Inconel 718																												
		2.4617	NiMo28	Hastelloy B-2																												
		2.4665	NiCr22Fe18Mo	Hastelloy X																												
S₂	Titanium pure	3.7035	Gr.2	ASTM B348 / F67																												
		3.7065	Gr.4	ASTM B348 / F68																												
S₃	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136																												
		9.9367	TiAl6Nb7	ASTM F1295																												
H₁	Hardened steel < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25																												
			CrCoMo28	ASTM F1537																												
H₂	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2																												