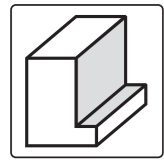
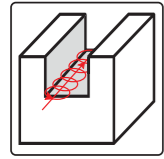


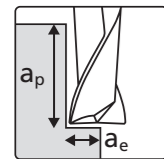
Type A - 1.5 x d - Side Milling / Trochoidal Slot Milling



$a_p = 1 \times d_1$  [mm]  
 $a_e = 0.3 \times d_1$  [mm]



$a_p = 1 \times d_1$  [mm]  
 $a_e = 0.1 \times d_1$  [mm]



Materials group	Material	Material number	DIN	AISI/ASTM/UNS	$\varnothing d_1$ 0.3 - 0.4		$\varnothing d_1$ 0.5 - 0.8		$\varnothing d_1$ 1.0 - 1.2		$\varnothing d_1$ 1.5 - 1.8		$\varnothing d_1$ 2.0 - 2.5		$\varnothing d_1$ 3.0		$\varnothing d_1$ 4.0 - 6.0	
					$v_c$ up to [m/min]	$f_z$ [mm/tooth · rev]	$v_c$ up to [m/min]	$f_z$ [mm/tooth · rev]	$v_c$ up to [m/min]	$f_z$ [mm/tooth · rev]	$v_c$ up to [m/min]	$f_z$ [mm/tooth · rev]	$v_c$ up to [m/min]	$f_z$ [mm/tooth · rev]	$v_c$ up to [m/min]	$f_z$ [mm/tooth · rev]	$v_c$ up to [m/min]	$f_z$ [mm/tooth · rev]
P	Unalloyed carbon steel $R_m < 800$ N/mm <sup>2</sup>	1.0301	C10	AISI 1010	60	0.005	100	0.010	140	0.015	200	0.024	220	0.034	240	0.048	280	0.050
		1.0401	C15	AISI 1015														
		1.1191	C45E/CK45	AISI 1045														
		1.0044	S275JR	AISI 1020														
		1.0715	11SMn30	AISI 1215														
	Low alloyed steel $R_m > 900$ N/mm <sup>2</sup>	1.5752	15NiCr13	ASTM 3415 / AISI 3310	60	0.004	100	0.009	140	0.014	200	0.022	220	0.032	240	0.046	280	0.048
		1.7131	16MnCr5	AISI 5115														
		1.3505	100Cr6	AISI 52100														
		1.7225	42CrMo4	AISI 4140														
		1.2842	90MnCrV8	AISI O2														
High alloyed tool steel $R_m < 1200$ N/mm <sup>2</sup>	1.2379	X153CrMoV12	AISI D2	60	0.004	100	0.008	140	0.011	200	0.020	220	0.030	240	0.042	280	0.044	
	1.2436	X210CrW12	AISI D4/D6															
	1.3343	H56-5-2C	AISI M2 / UNS T11302															
	1.3355	HS18-0-1	AISI T1 / UNS T12001															
	1.2379	X153CrMoV12	AISI D2															
M	Stainless steel ferritic	1.4016	X6Cr17	AISI 430 / UNS S43000	60	0.005	100	0.010	140	0.016	200	0.024	220	0.034	240	0.046	280	0.048
		1.4105	X6CrMoS17	AISI 430F														
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	60	0.004	100	0.009	140	0.015	200	0.022	220	0.032	240	0.044	280	0.046
		1.4112	X90CrMoV18	AISI 440B														
	Stainless steel martensitic - PH	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	60	0.004	100	0.009	140	0.015	200	0.022	220	0.032	240	0.044	280	0.046
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH														
	Stainless steel austenitic	1.4301	X5CrNi 18-10	AISI 304	60	0.004	100	0.008	140	0.012	200	0.016	220	0.030	240	0.042	280	0.044
		1.4435	X2CrNiMo 18-14-3	AISI 316L														
1.4441		X2CrNiMo 18-14-3	AISI 316LM															
1.4539	X1NiCrMoCu 25-20-5	AISI 904L																
K	Cast iron	0.6020	GG20	ASTM 30	60	0.003	100	0.006	120	0.011	140	0.024	160	0.028	180	0.042	200	0.052
		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	60	0.006	100	0.012	140	0.018	200	0.026	220	0.036	240	0.058	280	0.060
		3.4365	AlZnMgCu1.5	ASTM 7075														
	Aluminium alloy cast	3.2163	GD-ALSi9Cu3	ASTM A380	60	0.006	100	0.012	140	0.018	200	0.026	220	0.036	240	0.058	280	0.060
		3.2381	GD-ALSi10Mg	UNS A03590														
	Copper	2.004	Cu-OF / CW008A	UNS C10100	60	0.006	100	0.014	140	0.020	200	0.026	220	0.036	240	0.058	280	0.060
		2.0065	Cu-ETP / CW004A	UNS C11000														
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	60	0.006	100	0.014	140	0.020	200	0.026	220	0.036	240	0.058	280	0.060
		2.036	CuZn40 CW509L	UNS C28000														
	Brass, Bronze $R_m < 400$ N/mm <sup>2</sup>	2.0401	CuZn39Pb3 / CW614N	UNS C38500	60	0.006	100	0.014	140	0.020	200	0.026	220	0.036	240	0.058	280	0.060
		2.102	CuSn6	UNS C51900														
Bronze $R_m < 600$ N/mm <sup>2</sup>	2.0966	CuAl10Ni5Fe4	UNS C63000	60	0.006	100	0.012	140	0.018	200	0.026	220	0.036	240	0.058	280	0.060	
	2.096	CuAl9Mn2	UNS C63200															
S <sub>1</sub>	Super alloys	2.4856		Inconel 625	60	0.003	100	0.004	120	0.007	130	0.009	140	0.010	150	0.015	170	0.020
		2.4668		Inconel 718														
		2.4617	NiMo28	Hastelloy B-2														
		2.4665	NiCr22Fe18Mo	Hastelloy X														
S <sub>2</sub>	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	60	0.004	100	0.008	120	0.016	130	0.020	140	0.028	150	0.042	170	0.044
		3.7065	Gr.4	ASTM B348 / F68														
		3.7165	TiAl6V4	ASTM B348 / F136														
Titanium alloys	9.9367	TiAl6Nb7	ASTM F1295	60	0.004	100	0.008	120	0.016	130	0.020	140	0.028	150	0.042	170	0.044	
	2.4964	CoCr20W15Ni	Haynes 25															
S <sub>3</sub>	Cr-Co alloys			ASTM F1537	60	0.003	100	0.004	140	0.007	180	0.009	200	0.010	220	0.015	240	0.020
H <sub>1</sub>	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1	60	0.004	80	0.007	100	0.010	140	0.014	180	0.020	200	0.035	240	0.040
H <sub>2</sub>	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2														

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