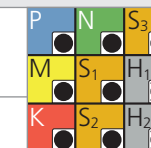


**NEW**

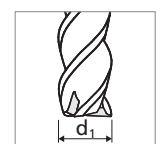
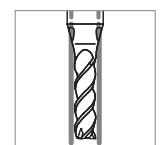
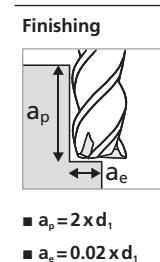
# Type C - Side milling - Finishing

$v_c$  [m/min]  
 $f_z$  [mm]

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



## MILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm		1.5 mm 1/16"		2.0 mm 3/32"		3.0 mm 1/8"		Ød1 4.0 mm 5/32"		5.0 mm 3/16" - 7/32"		6.0 mm 1/4"		8.0 mm	
					$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$
P	Unalloyed carbon steel Rm < 800 N/mm <sup>2</sup>	1.0301	C10	AISI 1010	130	0.008	180	0.012	200	0.017	210	0.023	220	0.025	220	0.028	220	0.033	220	0.042
		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 <sup>2</sup>	1.5752	15NiCr13	ASTM 3415 / AISI 3310	130	0.007	180	0.011	200	0.016	210	0.022	220	0.024	220	0.026	220	0.029	220	0.038
		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 <sup>2</sup>	1.2379	X153CrMoV12	AISI D2	130	0.006	180	0.010	200	0.015	210	0.020	220	0.021	220	0.023	220	0.025	220	0.034	
	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
1.4105			X6CrMoS17	AISI 430F																
Stainless steel martensitic		1.4034	X46Cr13	AISI 420C	130	0.008	180	0.011	200	0.016	210	0.022	220	0.023	220	0.025	220	0.028	220	0.037
		1.4112	X90CrMoV18	AISI 440B																
Stainless steel martensitic - PH		1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	130	0.008	180	0.011	200	0.016	210	0.022	220	0.023	220	0.025	220	0.028	220	0.037
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																
Stainless steel austenitic		1.4301	X5CrNi18-10	AISI 304	130	0.006	180	0.008	200	0.015	210	0.020	220	0.022	220	0.024	220	0.026	220	0.035
		1.4435	X2CrNiMo18-14-3	AISI 316L																
	1.4441	X2CrNiMo18-15-3	AISI 316LM																	
K	Cast iron	0.6020	GG20	ASTM 30	110	0.006	130	0.012	150	0.014	160	0.022	170	0.025	170	0.029	170	0.031	200	0.040
		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	130	0.009	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	220	0.045
		3.4365	AlZnMgCu1.5	ASTM 7075																
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380	130	0.009	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	220	0.045
		3.2381	GD-AlSi10Mg	UNS A03590																
	Copper	2.0040	Cu-OF / CW008A	UNS C10100	130	0.010	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	220	0.045
		2.0065	Cu-ETP / CW004A	UNS C11000																
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	130	0.010	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	220	0.045
		2.0360	CuZn40 CW509L	UNS C28000																
	Brass, Bronze Rm < 400 N/mm <sup>2</sup>	2.0401	CuZn39Pb3 / CW614N	UNS C38500	130	0.010	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	220	0.045
		2.1020	CuSn6	UNS C51900																
Bronze Rm < 600 N/mm <sup>2</sup>	2.0966	CuAl10Ni5Fe4	UNS C63000	130	0.009	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	220	0.045	
	2.0960	CuAl9Mn2	UNS C63200																	
S1	Super alloys	2.4856		Inconel 625	110	0.004	120	0.005	130	0.005	130	0.008	140	0.010	140	0.011	150	0.012	150	0.021
		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	110	0.008	120	0.010	130	0.014	130	0.020	140	0.022	140	0.024	150	0.026	150	0.035
		3.7065	Gr.4	ASTM B348 / F68																
S2	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	110	0.008	120	0.010	130	0.014	130	0.020	140	0.022	140	0.024	150	0.026	150	0.035
		9.9367	TiAl6Nb7	ASTM F1295																
S3	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	110	0.004	120	0.005	130	0.005	130	0.008	140	0.010	140	0.011	150	0.012	150	0.021
			CrCoMo28	ASTM F1537																
H1	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1																
		1.2379	X153CrMoV12	AISI D2																