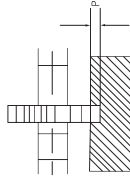


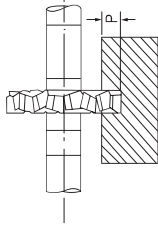
ML092
SERIES

MULTI FLUTES SIDE AND FACE MILLING CUTTERS WITH STRAIGHT TEETH

ISO	VDI 3323	Material Description	Parameter	50.0	63.0	80.0	Diameter (Ø)	100.0	125.0
P	1		Vc	25	25	25	25	25	25
			fz	0.045	0.058	0.06	0.063	0.066	
			RPM	159	126	99	80	64	
			FEED	1.29	1.61	1.43	1.30	1.26	
			Vc	20	20	20	20	20	
			fz	0.036	0.041	0.038	0.038	0.05	
	2		RPM	127	101	80	64	51	
			FEED	92	80	78	63	76	
			Vc	15	15	15	15	15	
	3-4	Non-alloy steel	fz	0.034	0.031	0.033	0.034	0.042	
			RPM	95	76	60	48	38	
			FEED	58	52	47	42	48	
	5		Vc	10	10	10	10	10	
			fz	0.031	0.029	0.03	0.03	0.036	
			RPM	64	51	40	32	25	
		FEED	36	32	29	25	28		
		Vc	20	20	20	20	20		
		fz	0.04	0.036	0.041	0.038	0.05		
6		RPM	127	101	80	64	51		
		FEED	92	80	78	63	76		
		Vc	15	15	15	15	15		
7	Low alloy steel	fz	0.034	0.031	0.033	0.034	0.042		
		RPM	95	76	60	48	38		
		FEED	58	52	47	42	48		
		Vc	10	10	10	10	10		
		fz	0.031	0.029	0.03	0.03	0.036		
		RPM	64	51	40	32	25		
8-9		FEED	36	32	29	25	28		
		Vc	20	20	20	20	20		
		fz	0.04	0.036	0.041	0.038	0.05		
10	High alloyed steel and tool steel	RPM	127	101	80	64	51		
		FEED	92	80	78	63	76		
		Vc	10	10	10	10	10		
11.1		fz	0.031	0.029	0.03	0.03	0.036		
		RPM	64	51	40	32	25		
		FEED	36	32	29	25	28		
N	21~25	Aluminum wrought alloy, Aluminum-cast alloy	Vc	100	100	100	100	100	
			fz	0.018	0.023	0.026	0.024	0.033	
			RPM	637	398	318	505	255	
			FEED	206	256	248	199	252	



MILLING DEPTH P = WIDTH OF FACES



MILLING DEPTH P = WIDTH OF FACES