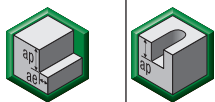



## Application Data • VariMill II™ ER • Series 57NE • Metric

Material Group															
	Side Milling (A) and Slotting (B)			WS15PE		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	10,0	12,0	16,0	18,0	20,0	25,0			
P	5	1,5 x D	0,5 x D	1 x D	60	–	100	fz	0,048	0,056	0,070	0,076	0,081	0,091	
	6	1,5 x D	0,5 x D	0,75 x D	50	–	75	fz	0,040	0,047	0,057	0,061	0,065	0,071	
M	1	1,5 x D	0,5 x D	1 x D	90	–	115	fz	0,061	0,070	0,087	0,095	0,101	0,114	
	2	1,5 x D	0,5 x D	1 x D	60	–	80	fz	0,048	0,056	0,070	0,076	0,081	0,091	
	3	1,5 x D	0,5 x D	1 x D	60	–	70	fz	0,040	0,047	0,057	0,061	0,065	0,071	
S	1	1,5 x D	0,3 x D	0,3 x D	50	–	90	fz	0,061	0,070	0,087	0,095	0,101	0,114	
	2	1,5 x D	0,3 x D	0,3 x D	25	–	50	fz	0,032	0,037	0,046	0,050	0,054	0,061	
	3	1,5 x D	0,3 x D	1 x D	40	–	90	fz	0,048	0,056	0,070	0,076	0,081	0,091	
	4	1,5 x D	0,5 x D	1 x D	50	–	60	fz	0,045	0,052	0,064	0,069	0,074	0,084	
H	1	1,5 x D	0,5 x D	0,75 x D	80	–	140	fz	0,054	0,062	0,077	0,083	0,088	0,098	
	2	1,5 x D	0,2 x D	0,5 x D	70	–	120	fz	0,040	0,047	0,057	0,061	0,065	0,071	

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.  
 Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.  
 Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on >12mm diameters.

 = ALL-STAR PORTFOLIO PRODUCT. ALL-STAR PRODUCTS ARE PROVEN SOLUTIONS THAT ARE ALWAYS AVAILABLE.