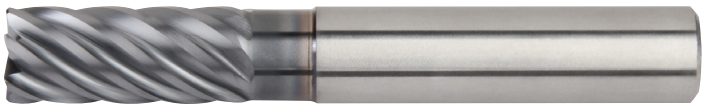
Application Data • VariMill III™ ER • Series 77NE • Semi-Finishing • Metric



Material Group		Side Milling (A)		WS15PE			Recommended feed per tooth (fz = mm/th) for side milling (A).				
		A		Cutting Speed — vc m/min				D1 — Diameter			
		ap	ae	min		max	mm	10,0	12,0	16,0	18,0	20,0
P	4	1,5 x D	0,3 x D	90	–	150	fz	0,054	0,062	0,077	0,083	0,088
	5	1,5 x D	0,3 x D	60	–	100	fz	0,048	0,056	0,070	0,076	0,081
M	1	1,5 x D	0,3 x D	90	–	115	fz	0,061	0,070	0,087	0,095	0,101
	2	1,5 x D	0,3 x D	60	–	80	fz	0,048	0,056	0,070	0,076	0,081
	3	1,5 x D	0,3 x D	60	–	70	fz	0,040	0,047	0,057	0,061	0,065
S	1	1,5 x D	0,3 x D	50	–	90	fz	0,061	0,070	0,087	0,095	0,101
	2	1,5 x D	0,3 x D	25	–	40	fz	0,032	0,037	0,046	0,050	0,054
	3	1,5 x D	0,3 x D	60	–	80	fz	0,048	0,056	0,070	0,076	0,081
	4	1,5 x D	0,3 x D	50	–	60	fz	0,045	0,052	0,064	0,069	0,074
H	1	1,5 x D	0,3 x D	80	–	140	fz	0,054	0,062	0,077	0,083	0,088
	2	1,5 x D	0,3 x D	70	–	120	fz	0,040	0,047	0,057	0,061	0,065

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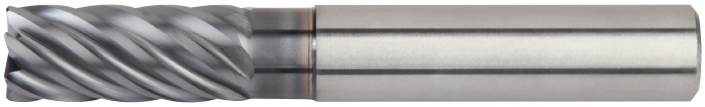

Material Group		Side Milling (A)		WS15PE			Recommended feed per tooth (fz = mm/th) for side milling (A).				
		A		Cutting Speed — vc m/min				D1 — Diameter			
		ap	ae	min		max	mm	10,0	12,0	16,0	18,0	20,0
P	4	Ap1 max	0,06 x D	180	–	300	fz	0,065	0,075	0,092	0,099	0,106
	5	Ap1 max	0,06 x D	120	–	200	fz	0,058	0,067	0,084	0,091	0,097
M	1	Ap1 max	0,06 x D	180	–	230	fz	0,073	0,084	0,105	0,113	0,121
	2	Ap1 max	0,06 x D	120	–	160	fz	0,058	0,067	0,084	0,091	0,097
	3	Ap1 max	0,06 x D	120	–	140	fz	0,048	0,056	0,068	0,073	0,078
S	1	Ap1 max	0,06 x D	100	–	180	fz	0,073	0,084	0,105	0,113	0,121
	2	Ap1 max	0,06 x D	50	–	80	fz	0,038	0,045	0,056	0,060	0,065
	3	Ap1 max	0,06 x D	120	–	160	fz	0,058	0,067	0,084	0,091	0,097
	4	Ap1 max	0,06 x D	100	–	120	fz	0,053	0,062	0,077	0,083	0,089
H	1	Ap1 max	0,06 x D	160	–	280	fz	0,065	0,075	0,092	0,099	0,106
	2	Ap1 max	0,06 x D	140	–	240	fz	0,048	0,056	0,068	0,073	0,078

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.

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