

A high-speed photograph of a milling operation. A dark, cylindrical mill head is shown cutting into a metallic workpiece. A large volume of bright, golden-yellow metal chips is being ejected from the cutting zone, creating a dynamic and intense scene. The background is dark, making the bright chips stand out.

crazy about

milling

CRAZYMILL COOL Z4

- SQUARE
- CORNER RADIUS

NEW

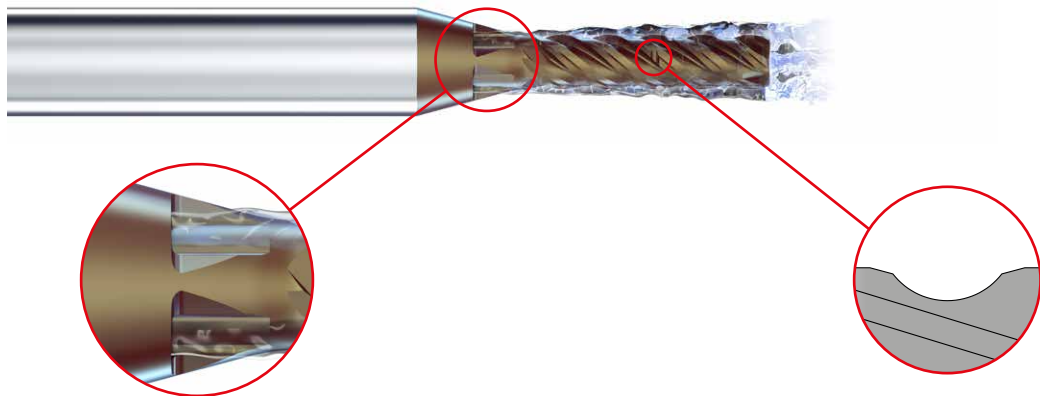
CrazyMill Cool Square / Corner radius - Z4



NEW**CRAZYMILL™**
by Mikron Tool
Cool**MILLING TOOL FOR PRE-MACHINING AND FINISHING DIFFICULT MATERIALS**

CrazyMill Cool Square / Corner radius with four flutes is an innovative end mill, developed by Mikron Tool, for machining stainless steels, titanium alloys, CrCo and super alloys.

It is available in the diameter range from 1 mm to 8 mm and a maximal milling depth of 5 x d.

**Integrated cooling**

Constant and massive cooling
of the cutting edges

New chip-splitting concept

Optimized to guarantee short
chips and a perfect evacuation

Performance features

- Highest speed and feed
- Integrated cooling
- Pre-machining and finishing
with one tool
- New chip-splitting concept

**Your advantages**

- Time and cost saving
- Excellent surface quality
- Reliable process
- Perfect chip control

NEW

Maximum performance and surface quality

SQUARE / CORNER RADIUS ENDMILL WITH INTEGRATED COOLING

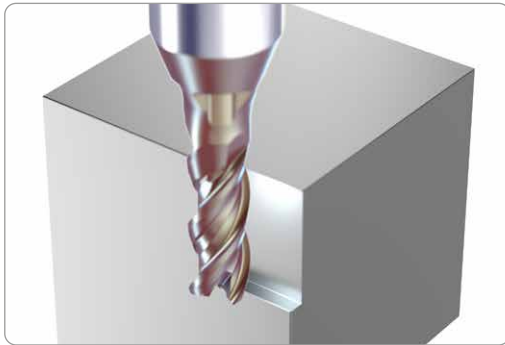
With CrazyMill Cool Square / Corner radius – Z4, Mikron Tool expands the range of milling cutters for difficult-to-machine materials. Four versions of square respectively corner radius endmills with four teeth and shank integrated cooling are available in the diameter range from 1 mm to 8 mm and a maximal milling depth of $5 \times d$.

- CrazyMill Cool Square, Type A – milling depth $2 \times d$, cutting length $2 \times d$, through shank coolant, $Z = 4$
 - CrazyMill Cool Square, Type C – milling depth $5 \times d$, cutting length $2 \times d$, through shank coolant, $Z = 4$
 - CrazyMill Cool Square, Type M – milling depth $3 \times d$, cutting length $3 \times d$, through shank coolant, $Z = 4$
 - CrazyMill Cool Square, Type N – milling depth $4 \times d$, cutting length $4 \times d$, through shank coolant, $Z = 4$
-
- CrazyMill Cool Corner radius, Type A – milling depth $2 \times d$, cutting length $2 \times d$, through shank coolant, $Z = 4$
 - CrazyMill Cool Corner radius, Type C – milling depth $5 \times d$, cutting length $2 \times d$, through shank coolant, $Z = 4$
 - CrazyMill Cool Corner radius, Type M – milling depth $3 \times d$, cutting length $3 \times d$, through shank coolant, $Z = 4$
 - CrazyMill Cool Corner radius, Type N – milling depth $4 \times d$, cutting length $4 \times d$, through shank coolant, $Z = 4$

One tool for many applications

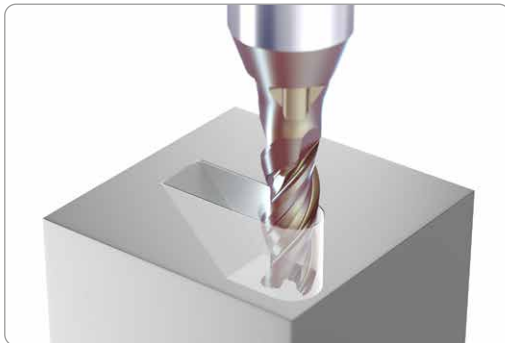
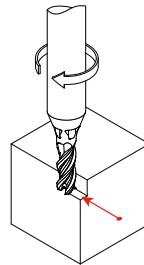
FOR DIFFICULT TO MACHINE MATERIALS

■ CrazyMill Cool Square / Corner radius - Z4 for:



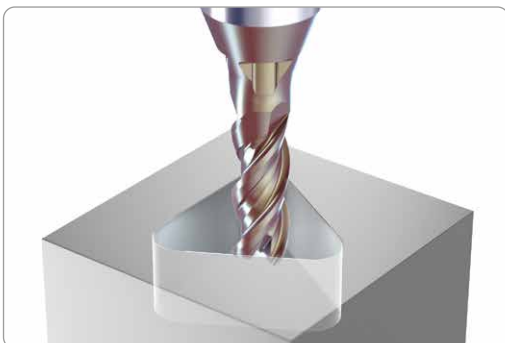
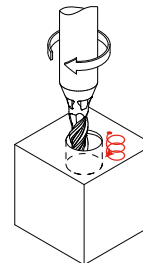
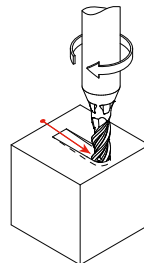
1. Side milling: Pre-machining and Finishing

$$a_p = 2 \times d / 3 \times d / 4 \times d$$

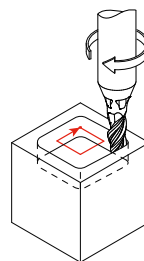


2. Linear ramp or helical interpolation milling

Angle depending on material



3. Pocket milling



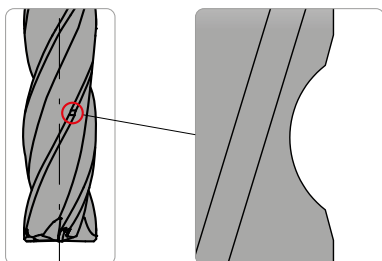
NEW

Important features

FOR BEST PERFORMANCE ON SURFACE QUALITY

■ Optimized chip-splitting for short chips and perfect surface quality

Chip-splitting design



Optimized chip-splitting geometry for short chips and a perfect chip evacuation. The result is a perfect surface quality.

Short chips



Due the chip-splitting the chips are short and easily evacuated. The result is long tool life.

Surface quality

CrazyMill Cool

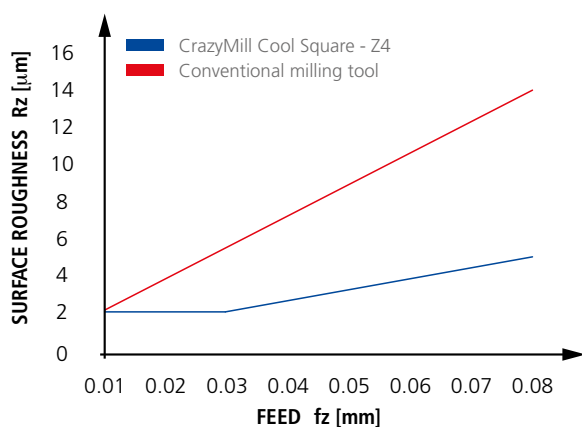


Conventional endmill



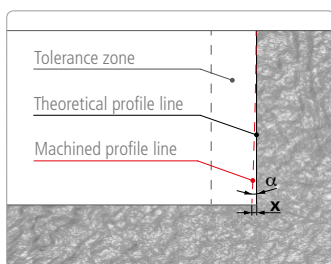
Due the new design of chip-splitting there is no visible mark as happens when using a conventional milling tool. The result is an excellent surface quality.

■ Surface roughness Rz



Material: X2CrNiMo17-12-2 / 1.4404 / AISI 316L
Diameter: 8 mm; Milling depth: 16 mm; Coolant: cutting oil;
Cutting data: $v_c = 260$ m/min; $a_p = 16$ mm; $a_e = 0.16$ mm

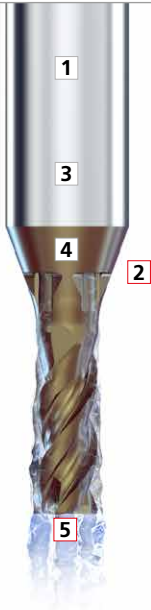
■ Perpendicularity



Perpendicularity precision	
x	0.02 mm
α	- 0.05°

Material: X2CrNiMo17-12-2 / 1.4404 / AISI 316L
Diameter: 6 mm; Milling depth: 24 mm; Coolant: cutting oil;
Cutting data: $v_c = 220$ m/min; $f_z = 0.03$ mm;
 $a_p = 24$ mm; $a_e = 0.12$ mm

Thanks to the profile of the flute and the size of the core, greater stability is achieved. The result is high perpendicularity precision, in particularly for long tool versions.

PATENTED	2 x d	5 x d	3 x d	4 x d	
	Type A	Type C	Type M	Type N	
l₁ = Effective length l₂ = Cutting length ■ Coated ■ Integ. cooling ■ l₁: 2xd, l₂: 2xd		■ Coated ■ Integ. cooling ■ l₁: 5xd, l₂: 2xd	■ Coated ■ Integ. cooling ■ l₁: 3xd, l₂: 3xd	■ Coated ■ Integ. cooling ■ l₁: 4xd, l₂: 4xd	
					
					
	page 14	page 20	page 26	page 32	

Regrinding: This product is not suitable for regrinding.

NEW

1 | SHANK

The robust solid carbide shank guarantees stable and vibration-free milling. High precision and extraordinary surface quality are reached.

2 | INTEGRATED COOLING - PATENTED

The integrated cooling channels guarantee constant and maximal cooling of the cutting edges and optimal chip removal. The result is higher cutting speed and depth a_p as well as an excellent surface quality.

3 | CARBIDE

The specially developed micro-grain carbide meets all requirements in terms of mechanical properties.

4 | COATING

The high-performance eXedur SNP coating is heat and wear resistant, prevents buildup edges and guarantees optimum chip flushing. The result is a long tool life.

5 | CUTTING GEOMETRY OF END FACE - LINEAR RAMP AND HELICAL INTERPOLATION MILLING

The frontal cutting geometry with the specially designed expanded chip collection has been optimized for linear ramp and helical interpolation milling by high ramp angles.

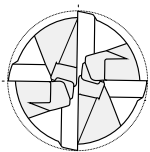
6 | LATERAL CUTTING GEOMETRY

The long and robust lateral cutting edge of versions M and N allows to obtain high tool rigidity. The result is higher machining force resistance that leads to high perpendicularity precision and high surface quality.

7 | CHIP-SPLITTING

An optimized chip-splitting guarantees short chips and highest surface quality. The chip-splitting is implemented in version M for $\varnothing d_1 \geq 4$ mm and N for $\varnothing d_1 \geq 3$ mm.

Mill tip

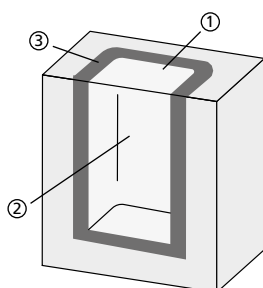


4 - Flute

NEW

Benefits and applications

PRE-MACHINING AND FINISHING CUTTER WITH INTEGRATED COOLING



COMPONENT

Pocket milling

MATERIAL

X2CrNiMo17-12-2 / 1.4404 / AISI 316L

MACHINING

- ① Helical ramp
- ② Pre-machining
- ③ Finishing
- Diameter endmill = 8 mm
- Pocket depth = 16 mm

MILLING TOOL

Mikron Tool - CrazyMill Cool Square - Z4
Type A

DATA	MIKRON TOOL
Tool type	CrazyMill Cool Square - Z4 - Carbide - Coated - Integrated cooling
Item number	2.CMC42.A1Z4.800.1
Cutting data	① Helical ramp $v_c = 160 \text{ m/min}$ $f_z = 0.03 \text{ mm}$ $a_{p, \max} = 1 \times d$ $a_e = 7.5 \text{ mm}$ $\alpha = 20^\circ$ $Q = 22.9 \text{ cm}^3/\text{min}$ $\Delta t = 4 \text{ s}$ ② Pre-machining $v_c = 180 \text{ m/min}$ $f_z = 0.048 \text{ mm}$ $a_{p, \max} = 2 \times d$ $a_e = 1.6 \text{ mm}$ $Q = 35.2 \text{ cm}^3/\text{min}$ $\Delta t = 1 \text{ min } 40 \text{ s}$ ③ Finishing $v_c = 260 \text{ m/min}$ $f_z = 0.04 \text{ mm}$ $a_{p, \max} = 2 \times d$ $a_e = 0.16 \text{ mm}$ $Q = 4.2 \text{ cm}^3/\text{min}$ $\Delta t = 9 \text{ s}$



APPLICATION DOMAINS	COMPONENTS EXAMPLES	MATERIALS GROUPS	EXAMPLES		
			Mat. no.	DIN	AISI / ASTM / UNS
Dental	Tooth crown	Group P Unalloyed and alloyed steel	1.0401	C15	1015
Medical technology	Component for endoscope		1.3505	100Cr6	52100
Automotive industry	Components for injection system		1.2436	X210CrW12	D4 / D6
Mechanical engineering	Machine components	Group M Stainless steel	1.4105	X6CrMoS17	430F
Watches	Watch housing		1.4112	X90CrMoV18	440B
Food industry	Nozzle		1.4301	X5CrNi 18-10	304
Aerospace industry	Engine parts	Group K Cast iron	0.7040	GGG40	60-40-18
Power industry	Blade	Group N Non ferrous metals	3.2315	AlMgSi1	6351
			3.2163	GD-AlSi9Cu3	A380
			2.004	Cu-OF / CW008A	C10100
			2.0321	CuZn37 CW508L	C27400
			2.102	CuSn6	C51900
			2.096	CuAl9Mn2	C63200
		Group S1 Super alloys	2.4856		INCONEL 625
			2.4665	NiCr22Fe18Mo	HASTELLOX X
		Group S2 Titanium (pure and alloyed)	3.7035	Gr.2	B348 / F67
			3.7165	TiAl6V4	B348 / F136
		Group S3 CrCo alloys	2.4964	CoCr20W15Ni	HAYNES 25

NEW

CrazyMill Cool Square / Corner radius - Z4

MILLING WITH INTEGRATED COOLING



Square


 2 x d
 page 14

 5 x d
 page 20

 3 x d
 page 26

 4 x d
 page 32


Corner radius


 2 x d
 page 15

 5 x d
 page 21

 3 x d
 page 27

 4 x d
 page 33

CrazyMill Cool is setting new standards for the milling of pockets and walls with regard to cutting speeds, feed, performance, tool life, and surface quality. The new features of this pre-machining and finishing cutter include not only the solid carbide, coating, and geometry, but especially the unique cooling system with cooling channels integrated in the shaft, which achieve constant and extensive cooling of the cutting edges, thus enabling the highest cutting speeds and maximum feed.

The milling tools have three to five integrated cooling channels depending on the shaft diameter.

Mikron Tool developed two different variants:

- **Variant square** - sharp-edged with small, defined protection phase of 45°, for a maximum machining depth of 5 x d.
- **Variant corner radius** - sharp-edged with a corner radius for a maximum machining depth of 5 x d.

Coolant type, pressure and filtration

Detailed recommendations for coolant type, pressure and filtration are on page "milling process".

Please note

You couldn't find your suitable version of the CrazyMill Cool Square / Corner radius - Z4 (diameter, length, cutting direction...)? Ask us about our customized versions!

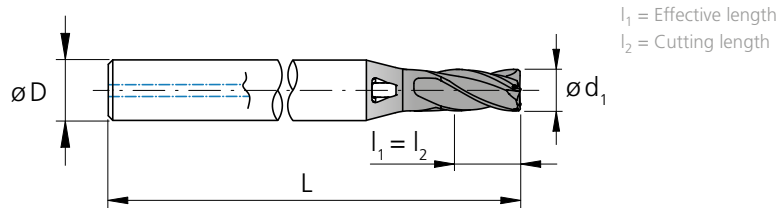
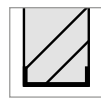
Regrinding: This product is not suitable for regrinding.

NEW

Type A - 2 x d - Square / Corner radius - Z4

MILLING WITH INTEGRATED COOLING

Square

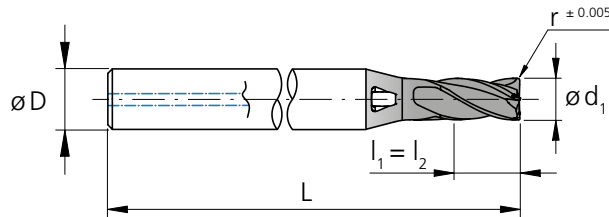


d_1 [mm]	d_1 [inch]	l_1 [mm]	l_2 [mm]	D (h6) [mm]	L [mm]	Item number	Availability
1.0		2.0	2.0	4	40	2.CMC42.A1Z4.100.1	■
1.2		2.4	2.4	4	40	2.CMC42.A1Z4.120.1	■
1.5		3.0	3.0	4	40	2.CMC42.A1Z4.150.1	■
1.587	1/16	3.1	3.1	4	40	2.CMC.SAZ4.F116	■
1.8		3.6	3.6	4	40	2.CMC42.A1Z4.180.1	■
2.0		4.0	4.0	4	40	2.CMC42.A1Z4.200.1	■
2.381	3/32	4.7	4.7	4	40	2.CMC.SAZ4.F332	■
2.5		5.0	5.0	6	50	2.CMC42.A1Z4.250.1	■
3.0		6.0	6.0	6	50	2.CMC42.A1Z4.300.1	■
3.175	1/8	6.4	6.4	6	50	2.CMC.SAZ4.F18	■
3.5		7.0	7.0	6	50	2.CMC42.A1Z4.350.1	■
3.968	5/32	7.9	7.9	6	50	2.CMC.SAZ4.F532	■
4.0		8.0	8.0	6	50	2.CMC42.A1Z4.400.1	■
4.5		9.0	9.0	8	60	2.CMC42.A1Z4.450.1	■
4.762	3/16	9.5	9.5	8	60	2.CMC.SAZ4.F316	■
5.0		10.0	10.0	8	60	2.CMC42.A1Z4.500.1	■
5.560	7/32	11.1	11.1	10	60	2.CMC.SAZ4.F732	■
6.0		12.0	12.0	10	60	2.CMC42.A1Z4.600.1	■
6.350	1/4	12.7	12.7	10	60	2.CMC.SAZ4.F14	■
8.0		16.0	16.0	12	70	2.CMC42.A1Z4.800.1	■

■ Stock item

Carbide		Z4								
						Ø d ₁	0.1 - 3.0 mm	3.1 - 6.0 mm	6.1 - 10.0 mm	
						Tolerance	- 0.014 mm - 0.028 mm	- 0.020 mm - 0.038 mm	- 0.025 mm - 0.047 mm	

Corner radius



l₁ = Effective length
l₂ = Cutting length

d ₁	d ₁	l ₁	l ₂	D (h6)	L	r	r	Item number	Availability
[mm]	[inch]	[mm]	[mm]	[mm]	[mm]	[mm]	[inch]		
1.0		2.0	2.0	4	40	0.10		2.CMC42.A2Z4.100.1	■
1.0		2.0	2.0	4	40	0.20		2.CMC42.A3Z4.100.1	■
1.2		2.4	2.4	4	40	0.10		2.CMC42.A2Z4.120.1	■
1.2		2.4	2.4	4	40	0.20		2.CMC42.A3Z4.120.1	■
1.5		3.0	3.0	4	40	0.10		2.CMC42.A2Z4.150.1	■
1.5		3.0	3.0	4	40	0.30		2.CMC42.A3Z4.150.1	■
1.587	1/16	3.1	3.1	4	40	0.127	.0050	2.CMC.RA2Z4.F116	■
1.587	1/16	3.1	3.1	4	40	0.254	.0100	2.CMC.RA3Z4.F116	■
1.8		3.6	3.6	4	40	0.10		2.CMC42.A2Z4.180.1	■
1.8		3.6	3.6	4	40	0.30		2.CMC42.A3Z4.180.1	■
2.0		4.0	4.0	4	40	0.10		2.CMC42.A2Z4.200.1	■
2.0		4.0	4.0	4	40	0.20		2.CMC42.A3Z4.200.1	■
2.0		4.0	4.0	4	40	0.50		2.CMC42.A4Z4.200.1	■
2.381	3/32	4.7	4.7	4	40	0.127	.0050	2.CMC.RA2Z4.F332	■
2.381	3/32	4.7	4.7	4	40	0.254	.0100	2.CMC.RA3Z4.F332	■
2.381	3/32	4.7	4.7	4	40	0.381	.0150	2.CMC.RA4Z4.F332	■
2.5		5.0	5.0	6	50	0.20		2.CMC42.A2Z4.250.1	■
2.5		5.0	5.0	6	50	0.50		2.CMC42.A3Z4.250.1	■
3.0		6.0	6.0	6	50	0.20		2.CMC42.A2Z4.300.1	■
3.0		6.0	6.0	6	50	0.50		2.CMC42.A3Z4.300.1	■
3.175	1/8	6.4	6.4	6	50	0.254	.0100	2.CMC.RA2Z4.F18	■
3.175	1/8	6.4	6.4	6	50	0.381	.0150	2.CMC.RA3Z4.F18	■
3.5		7.0	7.0	6	50	0.20		2.CMC42.A2Z4.350.1	■
3.5		7.0	7.0	6	50	0.50		2.CMC42.A3Z4.350.1	■
3.968	5/32	7.9	7.9	6	50	0.254	.0100	2.CMC.RA2Z4.F532	■
3.968	5/32	7.9	7.9	6	50	0.381	.0150	2.CMC.RA3Z4.F532	■
4.0		8.0	8.0	6	50	0.20		2.CMC42.A2Z4.400.1	■
4.0		8.0	8.0	6	50	0.50		2.CMC42.A3Z4.400.1	■
4.5		9.0	9.0	8	60	0.20		2.CMC42.A2Z4.450.1	■
4.5		9.0	9.0	8	60	0.50		2.CMC42.A3Z4.450.1	■
4.762	3/16	9.5	9.5	8	60	0.254	.0100	2.CMC.RA2Z4.F316	■
4.762	3/16	9.5	9.5	8	60	0.381	.0150	2.CMC.RA3Z4.F316	■
5.0		10.0	10.0	8	60	0.20		2.CMC42.A2Z4.500.1	■
5.0		10.0	10.0	8	60	0.50		2.CMC42.A3Z4.500.1	■
5.560	7/32	11.1	11.1	10	60	0.381	.0150	2.CMC.RA2Z4.F732	■
5.560	7/32	11.1	11.1	10	60	0.762	.0300	2.CMC.RA3Z4.F732	■
6.0		12.0	12.0	10	60	0.20		2.CMC42.A2Z4.600.1	■
6.0		12.0	12.0	10	60	0.50		2.CMC42.A3Z4.600.1	■
6.0		12.0	12.0	10	60	1.00		2.CMC42.A4Z4.600.1	■
6.350	1/4	12.7	12.7	10	60	0.381	.0150	2.CMC.RA2Z4.F14	■
6.350	1/4	12.7	12.7	10	60	0.762	.0300	2.CMC.RA3Z4.F14	■
6.350	1/4	12.7	12.7	10	60	1.524	.0600	2.CMC.RA4Z4.F14	■
8.0		16.0	16.0	12	70	0.20		2.CMC42.A2Z4.800.1	■
8.0		16.0	16.0	12	70	0.50		2.CMC42.A3Z4.800.1	■
8.0		16.0	16.0	12	70	1.50		2.CMC42.A4Z4.800.1	■

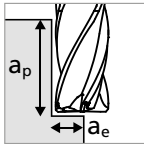
■ Stock item

NEW

Type A - Pre-machining

MILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW

Pre-machining



①

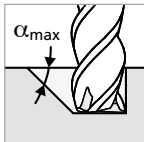
$$a_p = 1.5 \times d_1$$

$$a_e = 0.3 \times d_1$$

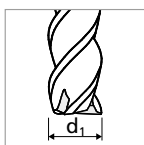
②

$$a_p = 2 \times d_1$$

$$a_e = 0.2 \times d_1$$

**Note:**

In case of linear ramp or helical interpolation milling reduce f_z by 35%



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v_c	1.0 mm f_z	
						①	②
P	Unalloyed carbon steel $R_m < 800 \text{ N/mm}^2$	1.0301	C10	AISI 1010	140	0.011	0.013
		1.0401	C15	AISI 1015			
		1.1191	C45E/CK45	AISI 1045			
		1.0044	S275JR	AISI 1020			
		1.0715	11SMn30	AISI 1215			
	Low alloyed steel $R_m > 900 \text{ N/mm}^2$	1.5752	15NiCr13	ASTM 3415 / AISI 3310	140	0.010	0.012
		1.7131	16MnCr5	AISI 5115			
		1.3505	100Cr6	AISI 52100			
		1.7225	42CrMo4	AISI 4140			
		1.2842	90MnCrV8	AISI O2			
	High alloyed tool steel $R_m < 1200 \text{ N/mm}^2$	1.2379	X153CrMoV12	AISI D2	140	0.008	0.009
		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	AISI 430 / UNS S43000	140	0.012	0.014
		1.4105	X6CrMoS17	AISI 430F			
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	140	0.011	0.013
		1.4112	X90CrMoV18	AISI 440B			
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	140	0.011	0.013
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH			
	Stainless steel austenitic	1.4301	X5CrNi18-10	AISI 304	140	0.009	0.011
		1.4435	X2CrNiMo18-14-3	AISI 316L			
		1.4441	X2CrNiMo18-15-3	AISI 316LM			
K	Cast iron	1.4539	X1NiCrMoCu25-20-5	AISI 904L			
		0.6020	GG20	ASTM 30	120	0.008	0.010
		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	160	0.013	0.015
		3.4365	AlZnMgCu1.5	ASTM 7075			
	Aluminium alloy cast	3.2163	GD-ALSi9Cu3	ASTM A380	160	0.013	0.015
		3.2381	GD-ALSi10Mg	UNS A03590			
	Copper	2.0040	Cu-OF / CW008A	UNS C10100	160	0.013	0.015
		2.0065	Cu-ETP / CW004A	UNS C11000			
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	160	0.013	0.015
		2.0360	CuZn40 CW509L	UNS C28000			
	Brass, Bronze $R_m < 400 \text{ N/mm}^2$	2.0401	CuZn39Pb3 / CW614N	UNS C38500	160	0.013	0.015
		2.1020	CuSn6	UNS C51900			
	Bronze $R_m < 600 \text{ N/mm}^2$	2.0966	CuAl10Ni5Fe4	UNS C63000	160	0.013	0.015
		2.0960	CuAl9Mn2	UNS C63200			
S₁	Super alloys	2.4856		Inconel 625	80	-	0.006
		2.4668		Inconel 718			
		2.4617	NiMo28	Hastelloy B-2			
		2.4665	NiCr22Fe18Mo	Hastelloy X			
		3.7035	Gr.2	ASTM B348 / F67			
S₂	Titanium pure	3.7065	Gr.4	ASTM B348 / F68	100	0.01	0.012
		3.7165	TiAl6V4	ASTM B348 / F136			
	Titanium alloys	9.9367	TiAl6Nb7	ASTM F1295	100	0.01	0.012
S₃	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	80	-	0.006
			CrCoMo28	ASTM F1537			
H₁	Hardened steel $< 55 \text{ HRC}$	1.2510	100MnCrMoW4	AISI O1			
H₂	Hardened steel $\geq 55 \text{ HRC}$	1.2379	X153CrMoV12	AISI D2			

v_c [m/min]
 f_z [mm]

RECOMMENDATION FOR USE

● Excellent | ● Good | ○ Acceptable | ⊗ Not recommended

P	N	S ₃	
M	S ₁	H ₁	⊗
K	S ₂	H ₂	⊗

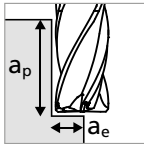
	1.5 mm 1/16"			2.0 mm 3/32"			3.0 mm 1/8"			4.0 mm 5/32"			5.0 mm 3/16" - 7/32"			6.0 mm 1/4"			8.0 mm		
	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②
	200	0.015	0.017	220	0.024	0.027	240	0.033	0.038	260	0.035	0.040	260	0.035	0.040	260	0.046	0.052	260	0.054	0.064
	200	0.013	0.015	220	0.022	0.025	240	0.031	0.035	260	0.033	0.038	260	0.033	0.038	260	0.044	0.050	260	0.052	0.060
	200	0.011	0.013	220	0.019	0.022	240	0.028	0.032	260	0.030	0.034	260	0.030	0.034	260	0.042	0.048	260	0.050	0.057
	180	0.014	0.016	180	0.021	0.024	200	0.030	0.034	220	0.033	0.038	220	0.033	0.038	220	0.040	0.045	260	0.048	0.055
	180	0.014	0.016	180	0.021	0.024	200	0.030	0.034	220	0.032	0.037	220	0.032	0.037	220	0.037	0.043	260	0.045	0.052
	180	0.014	0.016	180	0.021	0.024	200	0.030	0.034	220	0.032	0.037	220	0.032	0.037	220	0.037	0.043	260	0.045	0.052
	180	0.012	0.014	180	0.018	0.020	200	0.026	0.030	220	0.031	0.035	220	0.031	0.035	220	0.035	0.040	260	0.042	0.048
	160	0.014	0.016	200	0.019	0.022	220	0.030	0.034	240	0.042	0.048	240	0.042	0.048	240	0.044	0.050	240	0.052	0.057
	200	0.016	0.018	240	0.026	0.030	260	0.040	0.046	300	0.051	0.058	300	0.051	0.058	320	0.052	0.060	350	0.060	0.069
	220	0.016	0.018	240	0.026	0.030	260	0.040	0.046	300	0.051	0.058	300	0.051	0.058	320	0.052	0.060	350	0.060	0.069
	220	0.016	0.018	240	0.026	0.030	260	0.040	0.046	300	0.051	0.058	300	0.051	0.058	320	0.052	0.060	350	0.060	0.069
	220	0.016	0.018	240	0.026	0.030	260	0.040	0.046	300	0.051	0.058	300	0.051	0.058	320	0.052	0.060	350	0.060	0.069
	220	0.016	0.018	240	0.026	0.030	260	0.040	0.046	300	0.051	0.058	300	0.051	0.058	320	0.052	0.060	350	0.060	0.069
	100	-	0.008	100	-	0.010	100	-	0.014	120	-	0.016	120	-	0.018	120	-	0.020	120	-	0.025
	100	0.012	0.014	110	0.017	0.020	110	0.028	0.032	130	0.031	0.035	130	0.031	0.035	130	0.032	0.037	140	0.035	0.040
	100	0.012	0.014	110	0.017	0.020	110	0.028	0.032	130	0.031	0.035	130	0.031	0.035	130	0.032	0.037	140	0.035	0.040
	100	-	0.008	100	-	0.010	100	-	0.014	120	-	0.016	120	-	0.018	120	-	0.020	120	-	0.025

NEW

Type A - Finishing

MILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW

Finishing



①

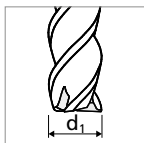
$$a_p = 2 \times d_1$$

$$a_e = 0.04 \times d_1$$

②

$$a_p = 2 \times d_1$$

$$a_e = 0.02 \times d_1$$



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm		
					v _c	① f _z	②
P	Unalloyed carbon steel R _m < 800 N/mm ²	1.0301	C10	AISI 1010	130	0.008	0.009
		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 ²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	130	0.007	0.008
		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 ²	1.2379	X153CrMoV12	AISI D2	130	0.006	0.007
		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	AISI 430 / UNS S43000	130	0.008	0.009
		1.4105	X6CrMoS17	AISI 430F			
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	130	0.008	0.009
		1.4112	X90CrMoV18	AISI 440B			
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	130	0.008	0.009
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH			
	Stainless steel austenitic	1.4301	X5CrNi18-10	AISI 304	130	0.006	0.007
		1.4435	X2CrNiMo18-14-3	AISI 316L			
		1.4441	X2CrNiMo18-15-3	AISI 316LM			
		1.4539	X1NiCrMoCu25-20-5	AISI 904L			
K	Cast iron	0.6020	GG20	ASTM 30	110	0.006	0.007
		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	0.010
		3.4365	AlZnMgCu1.5	ASTM 7075			
	Aluminium alloy cast	3.2163	GD-AISI9Cu3	ASTM A380	130	0.009	0.010
		3.2381	GD-AISI10Mg	UNS A03590			
	Copper	2.0040	Cu-OF / CW008A	UNS C10100	130	0.010	0.012
		2.0065	Cu-ETP / CW004A	UNS C11000			
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	130	0.010	0.012
		2.0360	CuZn40 CW509L	UNS C28000			
	Brass, Bronze R _m < 400 N/mm ²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	130	0.010	0.012
		2.1020	CuSn6	UNS C51900			
Bronze R _m < 600 N/mm ²	2.0966	CuAl10Ni5Fe4	UNS C63000	130	0.009	0.010	
	2.0960	CuAl9Mn2	UNS C63200				
S ₁	Super alloys	2.4856		Inconel 625	110	0.004	0.005
		2.4668		Inconel 718			
		2.4617	NiMo28	Hastelloy B-2			
		2.4665	NiCr22Fe18Mo	Hastelloy X			
S ₂	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	110	0.008	0.009
		3.7065	Gr.4	ASTM B348 / F68			
	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	110	0.008	0.009
		9.9367	TiAl6Nb7	ASTM F1295			
S ₃	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	110	0.004	0.005
			CrCoMo28	ASTM F1537			
H ₁	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1			
H ₂	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2			

v_c [m/min]
 f_z [mm]

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



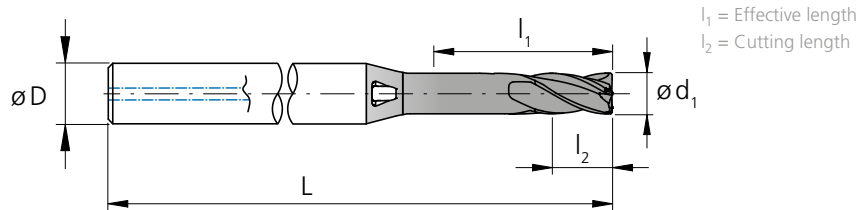
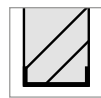
	1.5 mm 1/16"			2.0 mm 3/32"			3.0 mm 1/8"			4.0 mm 5/32"			5.0 mm 3/16" - 7/32"			6.0 mm 1/4"			8.0 mm		
	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②
	180	0.012	0.014	200	0.017	0.020	210	0.023	0.026	220	0.025	0.029	220	0.028	0.032	220	0.033	0.038	220	0.038	0.044
	180	0.011	0.013	200	0.016	0.018	210	0.022	0.025	220	0.024	0.028	220	0.026	0.030	220	0.029	0.033	220	0.034	0.040
	180	0.010	0.012	200	0.015	0.017	210	0.020	0.023	220	0.021	0.024	220	0.023	0.026	220	0.025	0.029	220	0.030	0.035
	180	0.012	0.014	200	0.017	0.020	210	0.022	0.025	220	0.024	0.028	220	0.026	0.030	220	0.029	0.033	260	0.034	0.040
	180	0.011	0.013	200	0.016	0.018	210	0.022	0.025	220	0.023	0.027	220	0.025	0.029	220	0.028	0.032	260	0.033	0.038
	180	0.011	0.013	200	0.016	0.018	210	0.022	0.025	220	0.023	0.027	220	0.025	0.029	220	0.028	0.032	260	0.033	0.038
	180	0.008	0.009	200	0.015	0.017	210	0.020	0.023	220	0.022	0.025	220	0.024	0.028	220	0.026	0.030	260	0.032	0.037
	130	0.012	0.014	150	0.014	0.016	160	0.022	0.025	170	0.025	0.029	170	0.029	0.033	170	0.031	0.036	200	0.036	0.042
	180	0.013	0.015	200	0.018	0.021	210	0.029	0.033	220	0.030	0.035	220	0.033	0.038	220	0.036	0.041	270	0.041	0.047
	180	0.013	0.015	200	0.018	0.021	210	0.029	0.033	220	0.030	0.035	220	0.033	0.038	220	0.036	0.041	270	0.041	0.047
	180	0.013	0.015	200	0.018	0.021	210	0.029	0.033	220	0.030	0.035	220	0.033	0.038	220	0.036	0.041	270	0.041	0.047
	180	0.013	0.015	200	0.018	0.021	210	0.029	0.033	220	0.030	0.035	220	0.033	0.038	220	0.036	0.041	270	0.041	0.047
	180	0.013	0.015	200	0.018	0.021	210	0.029	0.033	220	0.030	0.035	220	0.033	0.038	220	0.036	0.041	270	0.041	0.047
	120	0.005	0.006	130	0.005	0.006	130	0.008	0.009	140	0.010	0.012	140	0.011	0.013	150	0.012	0.014	160	0.017	0.020
	120	0.010	0.012	130	0.014	0.016	130	0.020	0.023	140	0.022	0.025	140	0.024	0.028	150	0.026	0.030	160	0.031	0.036
	120	0.010	0.012	130	0.014	0.016	130	0.020	0.023	140	0.022	0.025	140	0.024	0.028	150	0.026	0.030	160	0.031	0.036
	120	0.005	0.006	130	0.005	0.006	130	0.008	0.009	140	0.010	0.012	140	0.011	0.013	150	0.012	0.014	160	0.017	0.020

NEW

Type C - 5 x d - Square / Corner radius - Z4

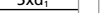
MILLING WITH INTEGRATED COOLING

Square

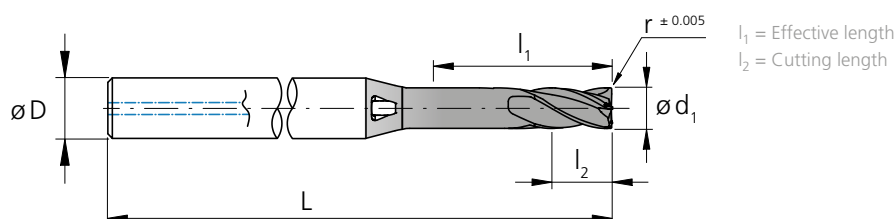


d ₁	d ₁	l ₁	l ₂	D	L	Item number	Availability
[mm]	[inch]	[mm]	[mm]	(h6) [mm]	[mm]		
1.0		5.0	2.0	4	40	2.CMC42.C1Z4.100.1	■
1.2		6.0	2.4	4	40	2.CMC42.C1Z4.120.1	■
1.5		7.5	3.0	4	40	2.CMC42.C1Z4.150.1	■
1.587	1/16	7.9	3.1	4	45	2.CMC.SCZ4.F116	■
1.8		9.0	3.6	4	45	2.CMC42.C1Z4.180.1	■
2.0		10.0	4.0	4	44	2.CMC42.C1Z4.200.1	■
2.381	3/32	11.9	4.7	4	44	2.CMC.SCZ4.F332	■
2.5		12.5	5.0	6	55	2.CMC42.C1Z4.250.1	■
3.0		15.0	6.0	6	55	2.CMC42.C1Z4.300.1	■
3.175	1/8	15.9	6.4	6	60	2.CMC.SCZ4.F18	■
3.5		17.5	7.0	6	60	2.CMC42.C1Z4.350.1	■
3.968	5/32	19.8	7.9	6	60	2.CMC.SCZ4.F532	■
4.0		20.0	8.0	6	60	2.CMC42.C1Z4.400.1	■
4.5		22.5	9.0	8	70	2.CMC42.C1Z4.450.1	■
4.762	3/16	23.8	9.5	8	70	2.CMC.SCZ4.F316	■
5.0		25.0	10.0	8	70	2.CMC42.C1Z4.500.1	■
5.560	7/32	27.8	11.1	10	70	2.CMC.SCZ4.F732	■
6.0		30.0	12.0	10	70	2.CMC42.C1Z4.600.1	■
6.350	1/4	31.7	12.7	10	70	2.CMC.SCZ4.F14	■
8.0		40.0	16.0	12	90	2.CMC42.C1Z4.800.1	■

■ Stock item

Carbide		Z4										$\varnothing d_1$	0.1 - 3.0 mm	3.1 - 6.0 mm	6.1 - 10.0 mm
												Tolerance	- 0.014 mm - 0.028 mm	- 0.020 mm - 0.038 mm	- 0.025 mm - 0.047 mm

Corner radius



d ₁	d ₁	l ₁	l ₂	D (h6)	L	r	r	Item number	Availability
[mm]	[inch]	[mm]	[mm]	[mm]	[mm]	[mm]	[inch]		
1.0		5.0	2.0	4	40	0.10		2.CMC42.C2Z4.100.1	■
1.0		5.0	2.0	4	40	0.20		2.CMC42.C3Z4.100.1	■
1.2		6.0	2.4	4	40	0.10		2.CMC42.C2Z4.120.1	■
1.2		6.0	2.4	4	40	0.20		2.CMC42.C3Z4.120.1	■
1.5		7.5	3.0	4	40	0.10		2.CMC42.C2Z4.150.1	■
1.5		7.5	3.0	4	40	0.30		2.CMC42.C3Z4.150.1	■
1.587	1/16	7.9	3.1	4	45	0.127	.0050	2.CMC.RC2Z4.F116	■
1.587	1/16	7.9	3.1	4	45	0.254	.0100	2.CMC.RC3Z4.F116	■
1.8		9.0	3.6	4	45	0.10		2.CMC42.C2Z4.180.1	■
1.8		9.0	3.6	4	45	0.30		2.CMC42.C3Z4.180.1	■
2.0		10.0	4.0	4	44	0.10		2.CMC42.C2Z4.200.1	■
2.0		10.0	4.0	4	44	0.20		2.CMC42.C3Z4.200.1	■
2.0		10.0	4.0	4	44	0.50		2.CMC42.C4Z4.200.1	■
2.381	3/32	11.9	4.7	4	44	0.127	.0050	2.CMC.RC2Z4.F332	■
2.381	3/32	11.9	4.7	4	44	0.254	.0100	2.CMC.RC3Z4.F332	■
2.381	3/32	11.9	4.7	4	44	0.381	.0150	2.CMC.RC4Z4.F332	■
2.5		12.5	5.0	6	55	0.20		2.CMC42.C2Z4.250.1	■
2.5		12.5	5.0	6	55	0.50		2.CMC42.C3Z4.250.1	■
3.0		15.0	6.0	6	55	0.20		2.CMC42.C2Z4.300.1	■
3.0		15.0	6.0	6	55	0.50		2.CMC42.C3Z4.300.1	■
3.175	1/8	15.9	6.4	6	60	0.254	.0100	2.CMC.RC2Z4.F18	■
3.175	1/8	15.9	6.4	6	60	0.381	.0150	2.CMC.RC3Z4.F18	■
3.5		17.5	7.0	6	60	0.20		2.CMC42.C2Z4.350.1	■
3.5		17.5	7.0	6	60	0.50		2.CMC42.C3Z4.350.1	■
3.968	5/32	19.8	7.9	6	60	0.254	.0100	2.CMC.RC2Z4.F532	■
3.968	5/32	19.8	7.9	6	60	0.381	.0150	2.CMC.RC3Z4.F532	■
4.0		20.0	8.0	6	60	0.20		2.CMC42.C2Z4.400.1	■
4.0		20.0	8.0	6	60	0.50		2.CMC42.C3Z4.400.1	■
4.5		22.5	9.0	8	70	0.20		2.CMC42.C2Z4.450.1	■
4.5		22.5	9.0	8	70	0.50		2.CMC42.C3Z4.450.1	■
4.762	3/16	23.8	9.5	8	70	0.254	.0100	2.CMC.RC2Z4.F316	■
4.762	3/16	23.8	9.5	8	70	0.381	.0150	2.CMC.RC3Z4.F316	■
5.0		25.0	10.0	8	70	0.20		2.CMC42.C2Z4.500.1	■
5.0		25.0	10.0	8	70	0.50		2.CMC42.C3Z4.500.1	■
5.560	7/32	27.8	11.1	10	70	0.381	.0150	2.CMC.RC2Z4.F732	■
5.560	7/32	27.8	11.1	10	70	0.762	.0300	2.CMC.RC3Z4.F732	■
6.0		30.0	12.0	10	70	0.20		2.CMC42.C2Z4.600.1	■
6.0		30.0	12.0	10	70	0.50		2.CMC42.C3Z4.600.1	■
6.0		30.0	12.0	10	70	1.00		2.CMC42.C4Z4.600.1	■
6.350	1/4	31.7	12.7	10	70	0.381	.0150	2.CMC.RC2Z4.F14	■
6.350	1/4	31.7	12.7	10	70	0.762	.0300	2.CMC.RC3Z4.F14	■
6.350	1/4	31.7	12.7	10	70	1.524	.0600	2.CMC.RC4Z4.F14	■
8.0		40.0	16.0	12	90	0.20		2.CMC42.C2Z4.800.1	■
8.0		40.0	16.0	12	90	0.50		2.CMC42.C3Z4.800.1	■
8.0		40.0	16.0	12	90	1.50		2.CMC42.C4Z4.800.1	■

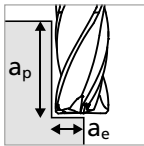
- Stock item

NEW

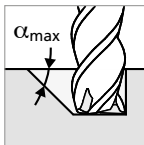
Type C - Pre-machining

MILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW

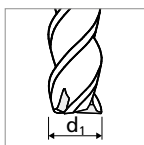
Pre-machining



- $a_p = 2 \times d_1$
- $a_e = 0.1 \times d_1$

**Note:**

In case of linear ramp or helical interpolation milling reduce f_z by 35%



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm	
					v_c	f_z
P	Unalloyed carbon steel $R_m < 800 \text{ N/mm}^2$	1.0301	C10	AISI 1010	120	0.017
		1.0401	C15	AISI 1015		
		1.1191	C45E/CK45	AISI 1045		
		1.0044	S275JR	AISI 1020		
		1.0715	11SMn30	AISI 1215		
	Low alloyed steel $R_m > 900 \text{ N/mm}^2$	1.5752	15NiCr13	ASTM 3415 / AISI 3310	120	0.016
		1.7131	16MnCr5	AISI 5115		
		1.3505	100Cr6	AISI 52100		
		1.7225	42CrMo4	AISI 4140		
		1.2842	90MnCrV8	AISI O2		
	High alloyed tool steel $R_m < 1200 \text{ N/mm}^2$	1.2379	X153CrMoV12	AISI D2	120	0.012
		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	AISI 430 / UNS S43000	120	0.018
		1.4105	X6CrMoS17	AISI 430F		
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	120	0.017
		1.4112	X90CrMoV18	AISI 440B		
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	120	0.017
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH		
	Stainless steel austenitic	1.4301	X5CrNi18-10	AISI 304	120	0.013
		1.4435	X2CrNiMo18-14-3	AISI 316L		
		1.4441	X2CrNiMo18-15-3	AISI 316LM		
K	Cast iron	1.4539	X1NiCrMoCu25-20-5	AISI 904L	100	0.012
		0.6020	GG20	ASTM 30		
		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	170	0.020
		3.4365	AlZnMgCu1.5	ASTM 7075		
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380	170	0.020
		3.2381	GD-AlSi10Mg	UNS A03590		
	Copper	2.0040	Cu-OF / CW008A	UNS C10100	170	0.022
		2.0065	Cu-ETP / CW004A	UNS C11000		
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	170	0.022
		2.0360	CuZn40 CW509L	UNS C28000		
	Brass, Bronze $R_m < 400 \text{ N/mm}^2$	2.0401	CuZn39Pb3 / CW614N	UNS C38500	170	0.022
		2.1020	CuSn6	UNS C51900		
S₁	Super alloys	2.0966	CuAl10Ni5Fe4	UNS C63000	170	0.020
		2.0960	CuAl9Mn2	UNS C63200		
		2.4856		Inconel 625	100	0.008
		2.4668		Inconel 718		
		2.4617	NiMo28	Hastelloy B-2		
		2.4665	NiCr22Fe18Mo	Hastelloy X		
	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	100	0.018
		3.7065	Gr.4	ASTM B348 / F68		
	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	100	0.018
		9.9367	TiAl6Nb7	ASTM F1295		
S₃	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	100	0.008
			CrCoMo28	ASTM F1537		
H₁	Hardened steel $< 55 \text{ HRC}$	1.2510	100MnCrMoW4	AISI O1		
H₂	Hardened steel $\geq 55 \text{ HRC}$	1.2379	X153CrMoV12	AISI D2		

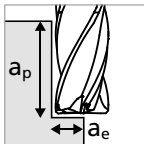
v_c [m/min]
 f_z [mm]

RECOMMENDATION FOR USE

● Excellent | ● Good | ○ Acceptable | ☒ Not recommended

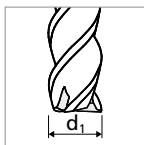
P	N	S ₃	
M	S ₁	H ₁	
K	S ₂	H ₂	

	1.5 mm 1/16"		2.0 mm 3/32"		3.0 mm 1/8"		Ød ₁ 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
	140	0.026	160	0.038	180	0.048	200	0.050	200	0.052	220	0.056	220	0.068
	140	0.025	160	0.036	180	0.044	200	0.048	200	0.050	220	0.054	220	0.066
	140	0.022	160	0.035	180	0.042	200	0.043	200	0.045	220	0.048	220	0.058
	140	0.026	160	0.038	180	0.046	200	0.048	200	0.050	220	0.055	260	0.062
	140	0.025	160	0.036	180	0.044	200	0.046	200	0.048	220	0.052	260	0.060
	140	0.025	160	0.036	180	0.044	200	0.046	200	0.048	220	0.052	260	0.060
	140	0.016	160	0.034	180	0.042	200	0.044	200	0.046	220	0.049	260	0.058
	120	0.026	140	0.032	160	0.043	180	0.054	180	0.056	200	0.058	200	0.070
	190	0.029	210	0.040	230	0.060	250	0.062	250	0.064	270	0.068	270	0.084
	190	0.029	210	0.040	230	0.060	250	0.062	250	0.064	270	0.068	270	0.084
	190	0.029	210	0.040	230	0.060	250	0.062	250	0.064	270	0.068	270	0.084
	190	0.029	210	0.040	230	0.060	250	0.062	250	0.064	270	0.068	270	0.084
	190	0.029	210	0.040	230	0.060	250	0.062	250	0.064	270	0.068	270	0.084
	190	0.029	210	0.040	230	0.060	250	0.062	250	0.064	270	0.068	270	0.084
	100	0.010	120	0.012	120	0.016	140	0.018	140	0.020	160	0.022	160	0.024
	100	0.022	120	0.032	120	0.042	140	0.044	140	0.046	160	0.048	160	0.054
	100	0.022	120	0.032	120	0.042	140	0.044	140	0.046	160	0.048	160	0.054
	100	0.010	120	0.012	120	0.016	140	0.018	140	0.020	160	0.022	160	0.024

NEW**Type C - Finishing****MILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW****Finishing**

$$a_p = 2 \times d_1$$

$$a_e = 0.02 \times d_1$$



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm		
					v_c	f_z	
P	Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C10	AISI 1010	130	0.008	
		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/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	130	0.007	
		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/mm²	1.2379	X153CrMoV12	AISI D2	130	0.006	
		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	AISI 430 / UNS S43000	130	0.008	
		1.4105	X6CrMoS17	AISI 430F			
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	130	0.008	
		1.4112	X90CrMoV18	AISI 440B			
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	130	0.008	
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH			
	Stainless steel austenitic	1.4301	X5CrNi18-10	AISI 304	130	0.006	
		1.4435	X2CrNiMo18-14-3	AISI 316L			
		1.4441	X2CrNiMo18-15-3	AISI 316LM			
1.4539		X1NiCrMoCu25-20-5	AISI 904L				
K	Cast iron	0.6020	GG20	ASTM 30	110	0.006	
		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	
		3.4365	AlZnMgCu1.5	ASTM 7075			
	Aluminium alloy cast	3.2163	GD-AISI9Cu3	ASTM A380	130	0.009	
		3.2381	GD-AISI10Mg	UNS A03590			
	Copper	2.0040	Cu-OF / CW008A	UNS C10100	130	0.010	
		2.0065	Cu-ETP / CW004A	UNS C11000			
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	130	0.010	
		2.0360	CuZn40 CW509L	UNS C28000			
	Brass, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	130	0.010	
		2.1020	CuSn6	UNS C51900			
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	130	0.009		
	2.0960	CuAl9Mn2	UNS C63200				
S ₁	Super alloys	2.4856		Inconel 625	110	0.004	
		2.4668		Inconel 718			
		2.4617	NiMo28	Hastelloy B-2			
		2.4665	NiCr22Fe18Mo	Hastelloy X			
S ₂	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	110	0.008	
		3.7065	Gr.4	ASTM B348 / F68			
	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	110	0.008	
	9.9367	TiAl6Nb7	ASTM F1295				
S ₃	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	110	0.004	
			CrCoMo28	ASTM F1537			
H ₁	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1			
H ₂	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2			

v_c [m/min]
 f_z [mm]

RECOMMENDATION FOR USE

● Excellent | ● Good | ○ Acceptable | ⊗ Not recommended

P	N	S ₃	
M	S ₁	H ₁	
K	S ₂	H ₂	

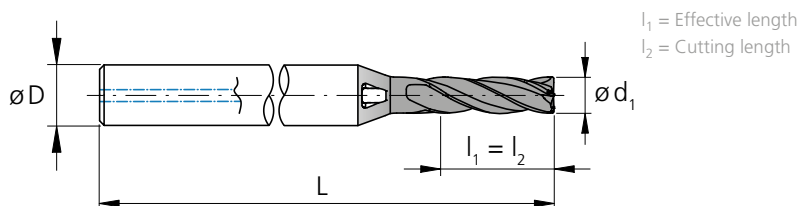
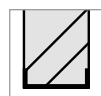
	1.5 mm 1/16"		2.0 mm 3/32"		3.0 mm 1/8"		Ød ₁ 4.0 mm 5/32"		5.0 mm 3/16" - 7/32"		6.0 mm 1/4"		8.0 mm	
	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z
	180	0.012	200	0.017	210	0.023	220	0.025	220	0.028	220	0.033	220	0.042
	180	0.011	200	0.016	210	0.022	220	0.024	220	0.026	220	0.029	220	0.038
	180	0.010	200	0.015	210	0.020	220	0.021	220	0.023	220	0.025	220	0.034
	180	0.012	200	0.017	210	0.022	220	0.024	220	0.026	220	0.029	260	0.036
	180	0.011	200	0.016	210	0.022	220	0.023	220	0.025	220	0.028	260	0.037
	180	0.011	200	0.016	210	0.022	220	0.023	220	0.025	220	0.028	260	0.037
	180	0.008	200	0.015	210	0.020	220	0.022	220	0.024	220	0.026	260	0.035
	130	0.012	150	0.014	160	0.022	170	0.025	170	0.029	170	0.031	200	0.040
	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045
	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045
	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045
	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045
	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045
	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045
	120	0.005	130	0.005	130	0.008	140	0.010	140	0.011	150	0.012	160	0.021
	120	0.010	130	0.014	130	0.020	140	0.022	140	0.024	150	0.026	160	0.035
	120	0.010	130	0.014	130	0.020	140	0.022	140	0.024	150	0.026	160	0.035
	120	0.005	130	0.005	130	0.008	140	0.010	140	0.011	150	0.012	160	0.021

NEW

Type M - 3 x d - Square / Corner radius - Z4

MILLING WITH INTEGRATED COOLING

Square

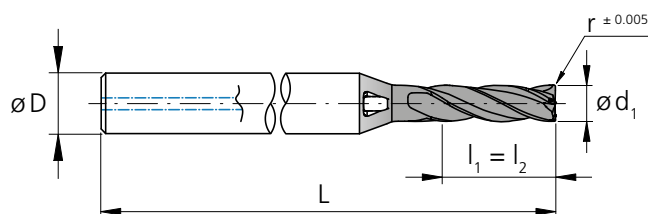


d_1	d_1	l_1	l_2	D	L	Item number	Availability
[mm]	[inch]	[mm]	[mm]	(h6) [mm]	[mm]		
1.0		3.0	3.0	4	40	2.CMC42.M1Z4.100.1	■
1.2		3.6	3.6	4	40	2.CMC42.M1Z4.120.1	■
1.5		4.5	4.5	4	40	2.CMC42.M1Z4.150.1	■
1.587	1/16	4.7	4.7	4	40	2.CMC.SMZ4.F116	■
1.8		5.4	5.4	4	40	2.CMC42.M1Z4.180.1	■
2.0		6.0	6.0	4	40	2.CMC42.M1Z4.200.1	■
2.381	3/32	7.1	7.1	4	40	2.CMC.SMZ4.F332	■
2.5		7.5	7.5	6	50	2.CMC42.M1Z4.250.1	■
3.0		9.0	9.0	6	50	2.CMC42.M1Z4.300.1	■
3.175	1/8	9.5	9.5	6	55	2.CMC.SMZ4.F18	■
3.5		10.5	10.5	6	55	2.CMC42.M1Z4.350.1	■
3.968	5/32	11.9	11.9	6	55	2.CMC.SMZ4.F532	■
4.0		12.0	12.0	6	55	2.CMC42.M1Z4.400.1	■
4.5		13.5	13.5	8	65	2.CMC42.M1Z4.450.1	■
4.762	3/16	14.3	14.3	8	65	2.CMC.SMZ4.F316	■
5.0		15.0	15.0	8	65	2.CMC42.M1Z4.500.1	■
5.560	7/32	16.7	16.7	10	65	2.CMC.SMZ4.F732	■
6.0		18.0	18.0	10	65	2.CMC42.M1Z4.600.1	■
6.350	1/4	19.0	19.0	10	65	2.CMC.SMZ4.F14	■
8.0		24.0	24.0	12	80	2.CMC42.M1Z4.800.1	■

■ Stock item

Carbide		Z4																																																																																											
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Corner radius



l_1 = Effective length

 $l_2 =$ Cutting length

d ₁	d ₁	l ₁	l ₂	D (h6)	L	r	r	Item number	Availability
[mm]	[inch]	[mm]	[mm]	[mm]	[mm]	[mm]	[inch]		
1.0		3.0	3.0	4	40	0.10		2.CMC42.M2Z4.100.1	■
1.0		3.0	3.0	4	40	0.20		2.CMC42.M3Z4.100.1	■
1.2		3.6	3.6	4	40	0.10		2.CMC42.M2Z4.120.1	■
1.2		3.6	3.6	4	40	0.20		2.CMC42.M3Z4.120.1	■
1.5		4.5	4.5	4	40	0.10		2.CMC42.M2Z4.150.1	■
1.5		4.5	4.5	4	40	0.30		2.CMC42.M3Z4.150.1	■
1.587	1/16	4.7	4.7	4	40	0.127	.0050	2.CMC.RM2Z4.F116	■
1.587	1/16	4.7	4.7	4	40	0.254	.0100	2.CMC.RM3Z4.F116	■
1.8		5.4	5.4	4	40	0.10		2.CMC42.M2Z4.180.1	■
1.8		5.4	5.4	4	40	0.30		2.CMC42.M3Z4.180.1	■
2.0		6.0	6.0	4	40	0.10		2.CMC42.M2Z4.200.1	■
2.0		6.0	6.0	4	40	0.20		2.CMC42.M3Z4.200.1	■
2.0		6.0	6.0	4	40	0.50		2.CMC42.M4Z4.200.1	■
2.381	3/32	7.1	7.1	4	40	0.127	.0050	2.CMC.RM2Z4.F332	■
2.381	3/32	7.1	7.1	4	40	0.254	.0100	2.CMC.RM3Z4.F332	■
2.381	3/32	7.1	7.1	4	40	0.381	.0150	2.CMC.RM4Z4.F332	■
2.5		7.5	7.5	6	50	0.20		2.CMC42.M2Z4.250.1	■
2.5		7.5	7.5	6	50	0.50		2.CMC42.M3Z4.250.1	■
3.0		9.0	9.0	6	50	0.20		2.CMC42.M2Z4.300.1	■
3.0		9.0	9.0	6	50	0.50		2.CMC42.M3Z4.300.1	■
3.175	1/8	9.5	9.5	6	55	0.254	.0100	2.CMC.RM2Z4.F18	■
3.175	1/8	9.5	9.5	6	55	0.381	.0150	2.CMC.RM3Z4.F18	■
3.5		10.5	10.5	6	55	0.20		2.CMC42.M2Z4.350.1	■
3.5		10.5	10.5	6	55	0.50		2.CMC42.M3Z4.350.1	■
3.968	5/32	11.9	11.9	6	55	0.254	.0100	2.CMC.RM2Z4.F532	■
3.968	5/32	11.9	11.9	6	55	0.381	.0150	2.CMC.RM3Z4.F532	■
4.0		12.0	12.0	6	55	0.20		2.CMC42.M2Z4.400.1	■
4.0		12.0	12.0	6	55	0.50		2.CMC42.M3Z4.400.1	■
4.5		13.5	13.5	8	65	0.20		2.CMC42.M2Z4.450.1	■
4.5		13.5	13.5	8	65	0.50		2.CMC42.M3Z4.450.1	■
4.762	3/16	14.3	14.3	8	65	0.254	.0100	2.CMC.RM2Z4.F316	■
4.762	3/16	14.3	14.3	8	65	0.381	.0150	2.CMC.RM3Z4.F316	■
5.0		15.0	15.0	8	65	0.20		2.CMC42.M2Z4.500.1	■
5.0		15.0	15.0	8	65	0.50		2.CMC42.M3Z4.500.1	■
5.560	7/32	16.7	16.7	10	65	0.381	.0150	2.CMC.RM2Z4.F732	■
5.560	7/32	16.7	16.7	10	65	0.762	.0300	2.CMC.RM3Z4.F732	■
6.0		18.0	18.0	10	65	0.20		2.CMC42.M2Z4.600.1	■
6.0		18.0	18.0	10	65	0.50		2.CMC42.M3Z4.600.1	■
6.0		18.0	18.0	10	65	1.00		2.CMC42.M4Z4.600.1	■
6.350	1/4	19.0	19.0	10	65	0.381	.0150	2.CMC.RM2Z4.F14	■
6.350	1/4	19.0	19.0	10	65	0.762	.0300	2.CMC.RM3Z4.F14	■
6.350	1/4	19.0	19.0	10	65	1.524	.0600	2.CMC.RM4Z4.F14	■
8.0		24.0	24.0	12	80	0.20		2.CMC42.M2Z4.800.1	■
8.0		24.0	24.0	12	80	0.50		2.CMC42.M3Z4.800.1	■
8.0		24.0	24.0	12	80	1.50		2.CMC42.M4Z4.800.1	■

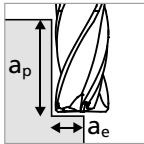
- Stock item

NEW

Type M - Pre-machining

MILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW

Pre-machining



①

$$a_p = 1.5 \times d_1$$

$$a_e = 0.2 \times d_1$$

②

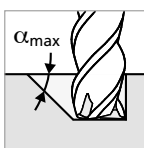
$$a_p = 3 \times d_1$$

$$a_e = 0.1 \times d_1$$

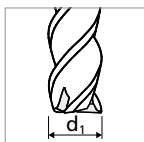
③

$$a_p = 3 \times d_1$$

$$a_e = 0.05 \times d_1$$

**Note:**

In case of linear ramp or helical interpolation milling reduce f_z by 35%



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm			
					v _c	①	②	③
						f _z		
P	Unalloyed carbon steel R _m < 800 N/mm ²	1.0301	C 10	AISI 1010	140	0.011	0.015	0.020
		1.0401	C 15	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 ²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	140	0.010	0.013	0.018
		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 ²	1.2379	X153CrMoV12	AISI D2	140	0.008	0.011	0.015
		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	AISI 430 / UNS S43000	140	0.012	0.016	0.022
		1.4105	X6CrMoS17	AISI 430F				
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	140	0.011	0.015	0.020
		1.4112	X90CrMoV18	AISI 440B				
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	140	0.011	0.015	0.020
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH				
	Stainless steel austenitic	1.4301	X5CrNi18-10	AISI 304	140	0.009	0.012	0.017
		1.4435	X2CrNiMo18-14-3	AISI 316L				
		1.4441	X2CrNiMo18-15-3	AISI 316LM				
1.4539		X1NiCrMoCu25-20-5	AISI 904L					
K	Cast iron	0.6020	GG20	ASTM 30	120	0.010	0.016	0.022
		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	160	0.013	0.017	0.024
		3.4365	AlZnMgCu1.5	ASTM 7075				
	Aluminium alloy cast	3.2163	GD-AISI9Cu3	ASTM A380	160	0.013	0.017	0.024
		3.2381	GD-AISI10Mg	UNS A03590				
	Copper	2.0040	Cu-OF / CW008A	UNS C10100	160	0.013	0.017	0.024
		2.0065	Cu-ETP / CW004A	UNS C11000				
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	160	0.013	0.017	0.024
		2.0360	CuZn40 CW509L	UNS C28000				
	Brass, Bronze R _m < 400 N/mm ²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	160	0.013	0.017	0.024
		2.1020	CuSn6	UNS C51900				
Bronze R _m < 600 N/mm ²	2.0966	CuAl10Ni5Fe4	UNS C63000	160	0.013	0.017	0.024	
	2.0960	CuAl9Mn2	UNS C63200					
S ₁	Super alloys	2.4856		Inconel 625	80	0.006	0.008	0.011
		2.4668		Inconel 718				
		2.4617	NiMo28	Hastelloy B-2				
		2.4665	NiCr22Fe18Mo	Hastelloy X				
S ₂	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	120	0.010	0.013	0.018
		3.7065	Gr.4	ASTM B348 / F68				
	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	120	0.010	0.013	0.018
S ₃	CrCo alloys	9.9367	TiAl6Nb7	ASTM F1295	80	0.006	0.008	0.011
		2.4964	CoCr20W15Ni	Haynes 25				
H ₁ H ₂	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1				
	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2				

v_c [m/min]
 f_z [mm]

RECOMMENDATION FOR USE

● Excellent | ● Good | ○ Acceptable | ⊗ Not recommended

P	N	S ₃	
M	S ₁	H ₁	
K	S ₂	H ₂	

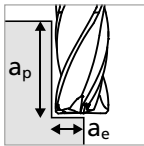
	Ød _i																											
	1.5 mm 1/16"				2.0 mm 3/32"				3.0 mm 1/8"				4.0 mm 5/32"				5.0 mm 3/16" - 7/32"				6.0 mm 1/4"				8.0 mm			
	v _c	①	②	③	v _c	①	②	③	v _c	①	②	③	v _c	①	②	③	v _c	①	②	③	v _c	①	②	③	v _c	①	②	③
	f _z				f _z				f _z				f _z				f _z				f _z				f _z			
	200	0.015	0.02	0.028	220	0.024	0.032	0.044	240	0.033	0.044	0.061	260	0.034	0.045	0.062	260	0.035	0.047	0.064	260	0.046	0.061	0.084	260	0.054	0.072	0.100
	200	0.013	0.017	0.024	220	0.022	0.029	0.040	240	0.031	0.041	0.057	260	0.032	0.043	0.059	260	0.033	0.044	0.061	260	0.044	0.059	0.081	260	0.052	0.069	0.095
	200	0.011	0.015	0.020	220	0.019	0.025	0.035	240	0.028	0.037	0.051	260	0.029	0.039	0.053	260	0.030	0.040	0.055	260	0.042	0.056	0.077	260	0.050	0.067	0.092
	180	0.015	0.020	0.028	180	0.021	0.028	0.039	200	0.030	0.040	0.055	220	0.032	0.043	0.059	220	0.033	0.044	0.061	220	0.040	0.053	0.073	260	0.048	0.064	0.088
	180	0.014	0.019	0.026	180	0.020	0.027	0.037	200	0.028	0.037	0.051	220	0.031	0.041	0.057	220	0.032	0.043	0.059	220	0.037	0.049	0.068	260	0.045	0.060	0.083
	180	0.014	0.019	0.026	180	0.020	0.027	0.037	200	0.028	0.037	0.051	220	0.031	0.041	0.057	220	0.032	0.043	0.059	220	0.037	0.049	0.068	260	0.045	0.060	0.083
	180	0.012	0.016	0.022	180	0.018	0.024	0.034	200	0.026	0.035	0.048	220	0.030	0.040	0.055	220	0.031	0.041	0.057	220	0.035	0.047	0.064	260	0.042	0.056	0.077
	160	0.014	0.019	0.026	200	0.024	0.032	0.044	220	0.032	0.043	0.059	240	0.038	0.051	0.070	240	0.042	0.056	0.077	240	0.044	0.059	0.081	240	0.052	0.069	0.095
	200	0.016	0.021	0.029	240	0.026	0.035	0.048	260	0.040	0.053	0.073	300	0.048	0.064	0.088	300	0.051	0.068	0.094	320	0.052	0.069	0.095	350	0.060	0.080	0.110
	220	0.016	0.021	0.029	240	0.026	0.035	0.048	260	0.040	0.053	0.073	300	0.048	0.064	0.088	300	0.051	0.068	0.094	320	0.052	0.069	0.095	350	0.060	0.080	0.110
	220	0.016	0.021	0.029	240	0.026	0.035	0.048	260	0.040	0.053	0.073	300	0.048	0.064	0.088	300	0.051	0.068	0.094	320	0.052	0.069	0.095	350	0.060	0.080	0.110
	220	0.016	0.021	0.029	240	0.026	0.035	0.048	260	0.040	0.053	0.073	300	0.048	0.064	0.088	300	0.051	0.068	0.094	320	0.052	0.069	0.095	350	0.060	0.080	0.110
	220	0.016	0.021	0.029	240	0.026	0.035	0.048	260	0.040	0.053	0.073	300	0.048	0.064	0.088	300	0.051	0.068	0.094	320	0.052	0.069	0.095	350	0.060	0.080	0.110
	100	0.008	0.011	0.015	100	0.010	0.013	0.018	100	0.014	0.019	0.026	120	0.016	0.021	0.029	120	0.018	0.024	0.033	120	0.020	0.027	0.037	120	0.025	0.033	0.046
	120	0.012	0.016	0.022	130	0.017	0.023	0.031	130	0.028	0.037	0.051	150	0.030	0.040	0.055	150	0.031	0.041	0.057	150	0.032	0.043	0.059	170	0.035	0.047	0.064
	120	0.012	0.016	0.022	130	0.017	0.023	0.031	130	0.028	0.037	0.051	150	0.030	0.04	0.055	150	0.031	0.041	0.057	150	0.032	0.043	0.059	170	0.035	0.047	0.064
	100	0.008	0.011	0.015	100	0.010	0.013	0.018	100	0.014	0.019	0.026	120	0.016	0.021	0.029	120	0.018	0.024	0.033	120	0.020	0.027	0.037	120	0.025	0.033	0.046

NEW

Type M - Finishing

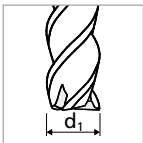
MILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW

Finishing



$$a_p = 3 \times d_1$$

$$a_e = 0.02 \times d_1$$



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm		
					v_c	f_z	
P	Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C 10	AISI 1010	130	0.009	
		1.0401	C 15	AISI 1015			
		1.1191	C45E/CK45	AISI 1045			
		1.0044	S275JR	AISI 1020			
		1.0715	11SMn30	AISI 1215			
	Low alloyed steel Rm > 900 N/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	130	0.008	
		1.7131	16MnCr5	AISI 5115			
		1.3505	100Cr6	AISI 1			
		1.7225	42CrMo4	AISI 4140			
		1.2842	90MnCrV8	AISI O2			
	High alloyed tool steel Rm < 1200 N/mm²	1.2379	X153CrMoV12	AISI D2	130	0.007	
		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	AISI 430 / UNS S43000	130	0.009	
		1.4105	X6CrMoS17	AISI 430F			
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	130	0.009	
		1.4112	X90CrMoV18	AISI 440B			
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	130	0.009	
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH			
	Stainless steel austenitic	1.4301	X5CrNi18-10	AISI 304	130	0.007	
		1.4435	X2CrNiMo18-14-3	AISI 316L			
		1.4441	X2CrNiMo18-15-3	AISI 316LM			
1.4539		X1NiCrMoCu25-20-5	AISI 904L				
K	Cast iron	0.6020	GG20	ASTM 30	110	0.007	
		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	0.010	
		3.4365	AlZnMgCu1.5	ASTM 7075			
	Aluminium alloy cast	3.2163	GD-AISI9Cu3	ASTM A380	130	0.010	
		3.2381	GD-AISI10Mg	UNS A03590			
	Copper	2.0040	Cu-OF / CW008A	UNS C10100	130	0.012	
		2.0065	Cu-ETP / CW004A	UNS C11000			
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	130	0.012	
		2.0360	CuZn40 CW509L	UNS C28000			
	Brass, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	130	0.012	
		2.1020	CuSn6	UNS C51900			
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	130	0.010		
	2.0960	CuAl9Mn2	UNS C63200				
S ₁	Super alloys	2.4856		Inconel 625	110	0.005	
		2.4668		Inconel 718			
		2.4617	NiMo28	Hastelloy B-2			
		2.4665	NiCr22Fe18Mo	Hastelloy X			
S ₂	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	110	0.009	
		3.7065	Gr.4	ASTM B348 / F68			
	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	110	0.009	
9.9367		TiAl6Nb7	ASTM F1295				
S ₃	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	110	0.005	
			CrCoMo28	ASTM F1537			
H ₁	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1			
H ₂	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2			

v_c [m/min]
 f_z [mm]

RECOMMENDATION FOR USE

● Excellent | ● Good | ○ Acceptable | ⊗ Not recommended

P	N	S ₃	
M	S ₁	H ₁	
K	S ₂	H ₂	

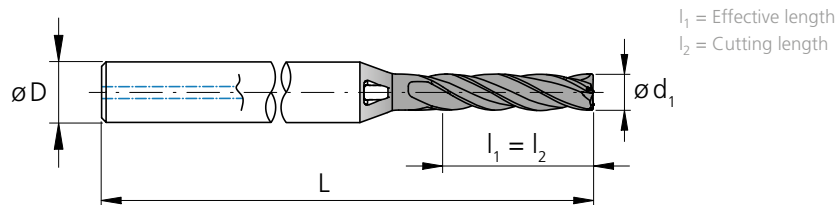
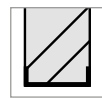
	1.5 mm 1/16"		2.0 mm 3/32"		3.0 mm 1/8"		Ød ₁ 4.0 mm 5/32"		5.0 mm 3/16" - 7/32"		6.0 mm 1/4"		8.0 mm	
	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z
	180	0.014	200	0.020	210	0.026	220	0.029	220	0.032	220	0.038	220	0.044
	180	0.013	200	0.018	210	0.025	220	0.028	220	0.030	220	0.033	220	0.040
	180	0.012	200	0.017	210	0.023	220	0.024	220	0.026	220	0.029	220	0.035
	180	0.014	200	0.020	210	0.025	220	0.028	220	0.030	220	0.033	260	0.040
	180	0.013	200	0.018	210	0.025	220	0.027	220	0.029	220	0.032	260	0.038
	180	0.013	200	0.018	210	0.025	220	0.027	220	0.029	220	0.032	260	0.038
	180	0.009	200	0.017	210	0.023	220	0.025	220	0.028	220	0.030	260	0.037
	130	0.014	150	0.016	160	0.025	170	0.029	170	0.033	170	0.036	200	0.042
	180	0.015	200	0.021	210	0.033	220	0.035	220	0.038	220	0.041	270	0.047
	180	0.015	200	0.021	210	0.033	220	0.035	220	0.038	220	0.041	270	0.047
	180	0.015	200	0.021	210	0.033	220	0.035	220	0.038	220	0.041	270	0.047
	180	0.015	200	0.021	210	0.033	220	0.035	220	0.038	220	0.041	270	0.047
	180	0.015	200	0.021	210	0.033	220	0.035	220	0.038	220	0.041	270	0.047
	180	0.015	200	0.021	210	0.033	220	0.035	220	0.038	220	0.041	270	0.047
	120	0.006	130	0.006	130	0.009	140	0.012	140	0.013	150	0.014	160	0.020
	120	0.012	130	0.016	130	0.023	140	0.025	140	0.028	150	0.030	160	0.036
	120	0.012	130	0.016	130	0.023	140	0.025	140	0.028	150	0.030	160	0.036
	120	0.006	130	0.006	130	0.009	140	0.012	140	0.013	150	0.014	160	0.020

NEW

Type N - 4 x d - Square / Corner radius - Z4

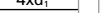
MILLING WITH INTEGRATED COOLING

Square

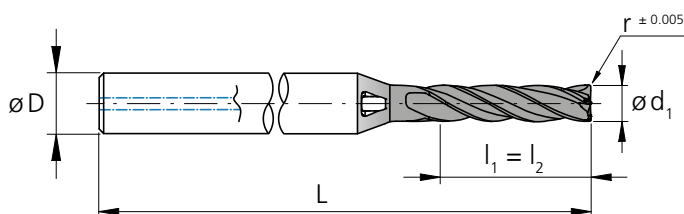


d ₁	d ₁	l ₁	l ₂	D	L	Item number	Availability
[mm]	[inch]	[mm]	[mm]	(h6) [mm]	[mm]		
1.0		4.0	4.0	4	40	2.CMC42.N1Z4.100.1	■
1.2		4.8	4.8	4	40	2.CMC42.N1Z4.120.1	■
1.5		6.0	6.0	4	40	2.CMC42.N1Z4.150.1	■
1.587	1/16	6.3	6.3	4	45	2.CMC.SNZ4.F116	■
1.8		7.2	7.2	4	45	2.CMC42.N1Z4.180.1	■
2.0		8.0	8.0	4	44	2.CMC42.N1Z4.200.1	■
2.381	3/32	9.5	9.5	4	44	2.CMC.SNZ4.F332	■
2.5		10.0	10.0	6	55	2.CMC42.N1Z4.250.1	■
3.0		12.0	12.0	6	55	2.CMC42.N1Z4.300.1	■
3.175	1/8	12.7	12.7	6	60	2.CMC.SNZ4.F18	■
3.5		14.0	14.0	6	60	2.CMC42.N1Z4.350.1	■
3.968	5/32	15.9	15.9	6	60	2.CMC.SNZ4.F532	■
4.0		16.0	16.0	6	60	2.CMC42.N1Z4.400.1	■
4.5		18.0	18.0	8	70	2.CMC42.N1Z4.450.1	■
4.762	3/16	19.0	19.0	8	70	2.CMC.SNZ4.F316	■
5.0		20.0	20.0	8	70	2.CMC42.N1Z4.500.1	■
5.560	7/32	22.2	22.2	10	70	2.CMC.SNZ4.F732	■
6.0		24.0	24.0	10	70	2.CMC42.N1Z4.600.1	■
6.350	1/4	25.4	25.4	10	70	2.CMC.SNZ4.F14	■
8.0		32.0	32.0	12	90	2.CMC42.N1Z4.800.1	■

■ Stock item

Carbide		Z4									$\varnothing d_1$	0.1 - 3.0 mm	3.1 - 6.0 mm	6.1 - 10.0 mm
											Tolerance	- 0.014 mm - 0.028 mm	- 0.020 mm - 0.038 mm	- 0.025 mm - 0.047 mm

Corner radius

 $l_1 = \text{Effective length}$ $l_2 =$ Cutting length

d ₁	d ₁	l ₁	l ₂	D (h6)	L	r	r	Item number	Availability
[mm]	[inch]	[mm]	[mm]	[mm]	[mm]	[mm]	[inch]		
1.0		4.0	4.0	4	40	0.10		2.CMC42.N2Z4.100.1	■
1.0		4.0	4.0	4	40	0.20		2.CMC42.N3Z4.100.1	■
1.2		4.8	4.8	4	40	0.10		2.CMC42.N2Z4.120.1	■
1.2		4.8	4.8	4	40	0.20		2.CMC42.N3Z4.120.1	■
1.5		6.0	6.0	4	40	0.10		2.CMC42.N2Z4.150.1	■
1.5		6.0	6.0	4	40	0.30		2.CMC42.N3Z4.150.1	■
1.587	1/16	6.3	6.3	4	45	0.127	.0050	2.CMC.RN2Z4.F116	■
1.587	1/16	6.3	6.3	4	45	0.254	.0100	2.CMC.RN3Z4.F116	■
1.8		7.2	7.2	4	45	0.10		2.CMC42.N2Z4.180.1	■
1.8		7.2	7.2	4	45	0.30		2.CMC42.N3Z4.180.1	■
2.0		8.0	8.0	4	44	0.10		2.CMC42.N2Z4.200.1	■
2.0		8.0	8.0	4	44	0.20		2.CMC42.N3Z4.200.1	■
2.0		8.0	8.0	4	44	0.50		2.CMC42.N4Z4.200.1	■
2.381	3/32	9.5	9.5	4	44	0.127	.0050	2.CMC.RN2Z4.F332	■
2.381	3/32	9.5	9.5	4	44	0.254	.0100	2.CMC.RN3Z4.F332	■
2.381	3/32	9.5	9.5	4	44	0.381	.0150	2.CMC.RN4Z4.F332	■
2.5		10.0	10.0	6	55	0.20		2.CMC42.N2Z4.250.1	■
2.5		10.0	10.0	6	55	0.50		2.CMC42.N3Z4.250.1	■
3.0		12.0	12.0	6	55	0.20		2.CMC42.N2Z4.300.1	■
3.0		12.0	12.0	6	55	0.50		2.CMC42.N3Z4.300.1	■
3.175	1/8	12.7	12.7	6	60	0.254	.0100	2.CMC.RN2Z4.F18	■
3.175	1/8	12.7	12.7	6	60	0.381	.0150	2.CMC.RN3Z4.F18	■
3.5		14.0	14.0	6	60	0.20		2.CMC42.N2Z4.350.1	■
3.5		14.0	14.0	6	60	0.50		2.CMC42.N3Z4.350.1	■
3.968	5/32	15.9	15.9	6	60	0.254	.0100	2.CMC.RN2Z4.F532	■
3.968	5/32	15.9	15.9	6	60	0.381	.0150	2.CMC.RN3Z4.F532	■
4.0		16.0	16.0	6	60	0.20		2.CMC42.N2Z4.400.1	■
4.0		16.0	16.0	6	60	0.50		2.CMC42.N3Z4.400.1	■
4.5		18.0	18.0	8	70	0.20		2.CMC42.N2Z4.450.1	■
4.5		18.0	18.0	8	70	0.50		2.CMC42.N3Z4.450.1	■
4.762	3/16	19.0	19.0	8	70	0.254	.0100	2.CMC.RN2Z4.F316	■
4.762	3/16	19.0	19.0	8	70	0.381	.0150	2.CMC.RN3Z4.F316	■
5.0		20.0	20.0	8	70	0.20		2.CMC42.N2Z4.500.1	■
5.0		20.0	20.0	8	70	0.50		2.CMC42.N3Z4.500.1	■
5.560	7/32	22.2	22.2	10	70	0.381	.0150	2.CMC.RN2Z4.F732	■
5.560	7/32	22.2	22.2	10	70	0.762	.0300	2.CMC.RN3Z4.F732	■
6.0		24.0	24.0	10	70	0.20		2.CMC42.N2Z4.600.1	■
6.0		24.0	24.0	10	70	0.50		2.CMC42.N3Z4.600.1	■
6.0		24.0	24.0	10	70	1.00		2.CMC42.N4Z4.600.1	■
6.350	1/4	25.4	25.4	10	70	0.381	.0150	2.CMC.RN2Z4.F14	■
6.350	1/4	25.4	25.4	10	70	0.762	.0300	2.CMC.RN3Z4.F14	■
6.350	1/4	25.4	25.4	10	70	1.524	.0600	2.CMC.RN4Z4.F14	■
8.0		32.0	32.0	12	90	0.20		2.CMC42.N2Z4.800.1	■
8.0		32.0	32.0	12	90	0.50		2.CMC42.N3Z4.800.1	■
8.0		32.0	32.0	12	90	1.50		2.CMC42.N4Z4.800.1	■

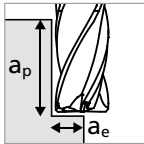
- Stock item

NEW

Type N - Pre-machining

MILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW

Pre-machining

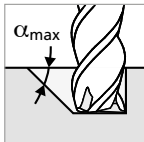


①

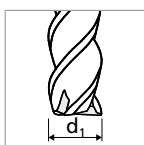
- $a_p = 2 \times d_1$
- $a_e = 0.1 \times d_1$

②

- $a_p = 4 \times d_1$
- $a_e = 0.05 \times d_1$

**Note:**

In case of linear ramp or helical interpolation milling reduce f_z by 35%



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm		
					v_c	① f_z	②
P	Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C10	AISI 1010	140	0.011	0.008
		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/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	140	0.010	0.007
		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/mm²	1.2379	X153CrMoV12	AISI D2	140	0.008	0.006
		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	AISI 430 / UNS S43000	140	0.012	0.008
		1.4105	X6CrMoS17	AISI 430F			
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	140	0.011	0.008
		1.4112	X90CrMoV18	AISI 440B			
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	140	0.011	0.008
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH			
	Stainless steel austenitic	1.4301	X5CrNi18-10	AISI 304	140	0.009	0.006
		1.4435	X2CrNiMo18-14-3	AISI 316L			
		1.4441	X2CrNiMo18-15-3	AISI 316LM			
		1.4539	X1NiCrMoCu25-20-5	AISI 904L			
K	Cast iron	0.6020	GG20	ASTM 30	120	0.010	0.006
		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	160	0.013	0.009
		3.4365	AlZnMgCu1.5	ASTM 7075			
	Aluminium alloy cast	3.2163	GD-AISI9Cu3	ASTM A380	160	0.013	0.009
		3.2381	GD-AISI10Mg	UNS A03590			
	Copper	2.0040	Cu-OF / CW008A	UNS C10100	160	0.013	0.010
		2.0065	Cu-ETP / CW004A	UNS C11000			
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	160	0.013	0.010
		2.0360	CuZn40 CW509L	UNS C28000			
	Brass, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	160	0.013	0.010
		2.1020	CuSn6	UNS C51900			
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	160	0.013	0.009	
	2.0960	CuAl9Mn2	UNS C63200				
S ₁	Super alloys	2.4856		Inconel 625	100	0.006	0.004
		2.4668		Inconel 718			
		2.4617	NiMo28	Hastelloy B-2			
		2.4665	NiCr22Fe18Mo	Hastelloy X			
S ₂	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	120	0.010	0.008
		3.7065	Gr.4	ASTM B348 / F68			
	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	120	0.010	0.008
	9.9367	TiAl6Nb7	ASTM F1295				
S ₃	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	100	0.006	0.004
			CrCoMo28	ASTM F1537			
H ₁	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1			
H ₂	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2			

v_c [m/min]
 f_z [mm]

RECOMMENDATION FOR USE

● Excellent | ● Good | ○ Acceptable | ⊗ Not recommended

P	N	S ₃	
M	S ₁	H ₁	⊗
K	S ₂	H ₂	⊗

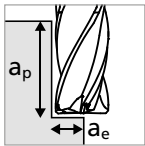
	1.5 mm 1/16"			2.0 mm 3/32"			3.0 mm 1/8"			4.0 mm 5/32"			5.0 mm 3/16" - 7/32"			6.0 mm 1/4"			8.0 mm		
	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②	v_c	① f_z	②
	200	0.015	0.012	220	0.024	0.017	240	0.033	0.020	260	0.034	0.025	260	0.035	0.028	260	0.046	0.029	260	0.054	0.033
	200	0.013	0.011	220	0.022	0.016	240	0.031	0.019	260	0.032	0.024	260	0.033	0.026	260	0.044	0.028	260	0.052	0.031
	200	0.011	0.010	220	0.019	0.015	240	0.028	0.018	260	0.029	0.022	260	0.030	0.024	260	0.042	0.026	260	0.050	0.029
	180	0.015	0.012	180	0.021	0.017	200	0.030	0.020	220	0.032	0.024	220	0.033	0.026	220	0.040	0.028	260	0.048	0.031
	180	0.014	0.011	180	0.020	0.016	200	0.028	0.018	220	0.031	0.023	220	0.032	0.025	220	0.037	0.027	260	0.045	0.030
	180	0.014	0.011	180	0.020	0.016	200	0.028	0.018	220	0.031	0.023	220	0.032	0.025	220	0.037	0.027	260	0.045	0.030
	180	0.012	0.008	180	0.018	0.015	200	0.026	0.017	220	0.030	0.022	220	0.031	0.024	220	0.035	0.026	260	0.042	0.029
	160	0.014	0.012	200	0.024	0.014	220	0.032	0.021	240	0.038	0.026	240	0.042	0.029	240	0.044	0.030	240	0.052	0.034
	200	0.016	0.013	240	0.026	0.018	260	0.040	0.029	300	0.048	0.028	300	0.051	0.030	320	0.052	0.032	350	0.060	0.036
	220	0.016	0.013	240	0.026	0.018	260	0.040	0.029	300	0.048	0.028	300	0.051	0.030	320	0.052	0.032	350	0.060	0.036
	220	0.016	0.013	240	0.026	0.018	260	0.040	0.029	300	0.048	0.028	300	0.051	0.030	320	0.052	0.032	350	0.060	0.036
	220	0.016	0.013	240	0.026	0.018	260	0.040	0.029	300	0.048	0.028	300	0.051	0.030	320	0.052	0.032	350	0.060	0.036
	220	0.016	0.013	240	0.026	0.018	260	0.040	0.029	300	0.048	0.028	300	0.051	0.030	320	0.052	0.032	350	0.060	0.036
	100	0.008	0.005	100	0.010	0.005	100	0.014	0.008	120	0.016	0.010	120	0.018	0.011	120	0.020	0.012	120	0.025	0.013
	120	0.012	0.010	130	0.017	0.014	130	0.028	0.017	150	0.030	0.021	150	0.031	0.023	150	0.032	0.025	170	0.035	0.027
	120	0.012	0.010	130	0.017	0.014	130	0.028	0.017	150	0.030	0.021	150	0.031	0.023	150	0.032	0.025	170	0.035	0.027
	100	0.008	0.005	100	0.010	0.005	100	0.014	0.008	120	0.016	0.010	120	0.018	0.011	120	0.020	0.012	120	0.025	0.013

NEW

Type N - Finishing

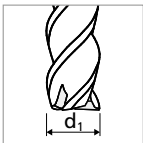
MILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW

Finishing



$$a_p = 4 \times d_1$$

$$a_e = 0.02 \times d_1$$



	Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm		
						v_c	f_z	
P	Unalloyed carbon steel $R_m < 800 \text{ N/mm}^2$	1.0301	C10	AISI 1010	130	0.009		
		1.0401	C15	AISI 1015				
		1.1191	C45E/CK45	AISI 1045				
		1.0044	S275JR	AISI 1020				
		1.0715	11SMn30	AISI 1215				
	Low alloyed steel $R_m > 900 \text{ N/mm}^2$	1.5752	15NiCr13	ASTM 3415 / AISI 3310	130	0.008		
		1.7131	16MnCr5	AISI 5115				
		1.3505	100Cr6	AISI 52100				
		1.7225	42CrMo4	AISI 4140				
		1.2842	90MnCrV8	AISI O2				
	High alloyed tool steel $R_m < 1200 \text{ N/mm}^2$	1.2379	X153CrMoV12	AISI D2	130	0.007		
		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	AISI 430 / UNS S43000	130	0.009		
		1.4105	X6CrMoS17	AISI 430F				
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	130	0.009		
		1.4112	X90CrMoV18	AISI 440B				
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	130	0.009		
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH				
	Stainless steel austenitic	1.4301	X5CrNi18-10	AISI 304	130	0.007		
		1.4435	X2CrNiMo18-14-3	AISI 316L				
		1.4441	X2CrNiMo18-15-3	AISI 316LM				
K	Cast iron	0.6020	GG20	ASTM 30	110	0.007		
		0.6030	GG30	ASTM 40B				
		0.7040	GGG40	ASTM 60-40-18				
		0.7060	GGG60	ASTM 80-60-03				
		0.7060	GGG60	ASTM 80-60-03				
N	Aluminium alloy wrought	3.2315	AlMgSi1	ASTM 6351	130	0.010		
		3.4365	AlZnMgCu1.5	ASTM 7075				
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380	130	0.010		
		3.2381	GD-AlSi10Mg	UNS A03590				
	Copper	2.0040	Cu-OF / CW008A	UNS C10100	130	0.012		
		2.0065	Cu-ETP / CW004A	UNS C11000				
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	130	0.012		
		2.0360	CuZn40 CW509L	UNS C28000				
	Brass, Bronze $R_m < 400 \text{ N/mm}^2$	2.0401	CuZn39Pb3 / CW614N	UNS C38500	130	0.012		
		2.1020	CuSn6	UNS C51900				
	Bronze $R_m < 600 \text{ N/mm}^2$	2.0966	CuAl10Ni5Fe4	UNS C63000	130	0.010		
		2.0960	CuAl9Mn2	UNS C63200				
S ₁	Super alloys	2.4856		Inconel 625	110	0.005		
		2.4668		Inconel 718				
		2.4617	NiMo28	Hastelloy B-2				
		2.4665	NiCr22Fe18Mo	Hastelloy X				
S ₂	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	110	0.009		
		3.7065	Gr.4	ASTM B348 / F68				
	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	110	0.009		
S ₃	CrCo alloys	9.9367	TiAl6Nb7	ASTM F1295				
		2.4964	CoCr20W15Ni	Haynes 25	110	0.005		
H ₁	Hardened steel $\geq 55 \text{ HRC}$		CrCoMo28	ASTM F1537				
H ₂	Hardened steel $\geq 55 \text{ HRC}$	1.2510	100MnCrMoW4	AISI O1				
		1.2379	X153CrMoV12	AISI D2				

v_c [m/min]
 f_z [mm]

RECOMMENDATION FOR USE

● Excellent | ● Good | ○ Acceptable | ⊗ Not recommended

P	N	S ₃	
M	S ₁	H ₁	
K	S ₂	H ₂	

	1.5 mm 1/16"		2.0 mm 3/32"		3.0 mm 1/8"		Ød ₁ 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
	180	0.014	200	0.020	210	0.026	220	0.029	220	0.032	220	0.038	220	0.044
	180	0.013	200	0.018	210	0.025	220	0.028	220	0.030	220	0.033	220	0.040
	180	0.012	200	0.017	210	0.023	220	0.024	220	0.026	220	0.029	220	0.035
	180	0.014	200	0.020	210	0.025	220	0.028	220	0.030	220	0.033	260	0.040
	180	0.013	200	0.018	210	0.025	220	0.027	220	0.029	220	0.032	260	0.038
	180	0.013	200	0.018	210	0.025	220	0.027	220	0.029	220	0.032	260	0.038
	180	0.009	200	0.017	210	0.023	220	0.025	220	0.028	220	0.030	260	0.037
	130	0.014	150	0.016	160	0.025	170	0.029	170	0.033	170	0.036	200	0.042
	180	0.015	200	0.021	210	0.033	220	0.035	220	0.038	220	0.041	270	0.047
	180	0.015	200	0.021	210	0.033	220	0.035	220	0.038	220	0.041	270	0.047
	180	0.015	200	0.021	210	0.033	220	0.035	220	0.038	220	0.041	270	0.047
	180	0.015	200	0.021	210	0.033	220	0.035	220	0.038	220	0.041	270	0.047
	180	0.015	200	0.021	210	0.033	220	0.035	220	0.038	220	0.041	270	0.047
	180	0.015	200	0.021	210	0.033	220	0.035	220	0.038	220	0.041	270	0.047
	120	0.006	130	0.006	130	0.009	140	0.012	140	0.013	150	0.014	160	0.020
	120	0.012	130	0.016	130	0.023	140	0.025	140	0.028	150	0.030	160	0.036
	120	0.012	130	0.016	130	0.023	140	0.025	140	0.028	150	0.030	160	0.036
	120	0.006	130	0.006	130	0.009	140	0.012	140	0.013	150	0.014	160	0.020

NEW

Process CrazyMill Cool Square / Corner radius - Z4

ACCURATE AND EFFICIENT MILLING

Coolant type, pressure and filtration

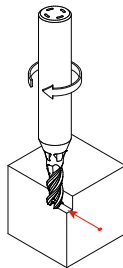
Coolant: for best results, Mikron Tool recommends the use of cutting oil as coolant. Alternatively, water base coolant with EP-Additives (Extreme-Pressure-Additives) can be used as well.

Filter: the large cooling channels permit the use of a standard filter with filter quality of ≤ 0.05 mm.

Coolant pressure: at least 15 bar coolant pressure is required to achieve reliable milling. High pressure is generally better for the cooling and flushing effect.

Revolution	[rpm]	$\leq 10'000$	$> 10'000$
Minimal pressure	[bar]	15	30

Climb milling and conventional milling

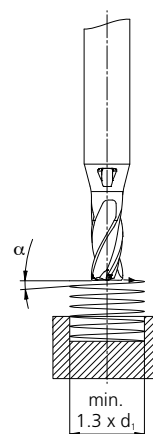


Mikron tool recommends climb milling for the machining of side and pocket milling. The chip thickness here is greater at the beginning and decreases continuously; the cutting forces remain low. With conventional milling, however, high cutting forces would push the milling tool away from the part. Thus surface quality decreases.

MILLING PROCESS

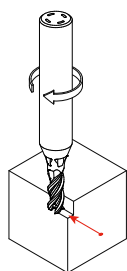
Maximum ramp angles in linear ramping or helical interpolation

	Material	α - Linear ramp	α - Helical interpolation
P	Unalloyed carbon steel	45°	47°
	Low alloyed steel	45°	47°
	High alloyed tool steel	27°	28°
M	Stainless steel ferritic	45°	47°
	Stainless steel martensitic	27°	28°
	Stainless steel martensitic - PH	27°	28°
	Stainless steel austenitic	45°	47°
K	Cast iron	45°	47°
N	Aluminium alloy wrought	45°	47°
	Aluminium alloy cast	45°	47°
	Copper	45°	47°
	Brass lead free	45°	47°
	Brass, Bronze Rm < 400 N/mm²	45°	47°
	Bronze Rm < 600 N/mm²	45°	47°
S ₁	Super alloys	14°	15°
S ₂	Titanium pure and titanium alloys	14°	15°
S ₃	CrCo alloys	27°	28°



Note: In case of linear ramping or helical interpolation refer to cutting data for pre-machining with a reduction by 35% of f_z

Pre-machining

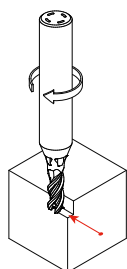


Recommended cutting parameters

v_c and f_z = as specified in the cutting data table

Strategy	Type A	Type C	Type M	Type N
①	$a_p = 1.5 \times d$ $a_e = 0.3 \times d$	$a_p = 2 \times d$ $a_e = 0.1 \times d$	$a_p = 1.5 \times d$ $a_e = 0.2 \times d$	$a_p = 2 \times d$ $a_e = 0.1 \times d$
②	$a_p = 2 \times d$ $a_e = 0.2 \times d$	-	$a_p = 3 \times d$ $a_e = 0.1 \times d$	$a_p = 4 \times d$ $a_e = 0.05 \times d$
③	-	-	$a_p = 3 \times d$ $a_e = 0.05 \times d$	-

Finishing



Recommended cutting parameters

v_c and f_z = as specified in the cutting data table

Strategy	Type A	Type C	Type M	Type N
①	$a_p = 2 \times d$ $a_e = 0.04 \times d$	$a_p = 2 \times d$ $a_e = 0.02 \times d$	$a_p = 3 \times d$ $a_e = 0.02 \times d$	$a_p = 4 \times d$ $a_e = 0.02 \times d$
②	$a_p = 2 \times d$ $a_e = 0.02 \times d$	-	-	-

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