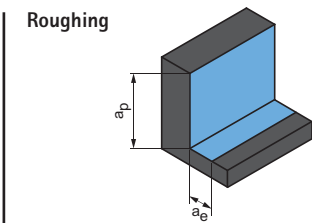


Cutting data recommendations for shoulder milling cutters

Feed and cutting speed



OptiMill-Graphite-MT | SCM105, 106

MMG*		Workpiece material		Strength/hardness [N/mm ²] [HRC]	Cooling			a _p [mm]	a _e [mm]	v _c [m/min]	f _z [mm]							
					MQL/Air	Dry	KSS				Diameter of milling cutter [mm]							
											3.00	4.00	5.00	6.00	8.00	10.00	12.00	
N	N3	N3.1	Graphite, > 8 μm		✓		✓		1xD	0.4xD	500–600	0.200	0.250	0.280	0.300	0.350	0.380	0.400
		N3.2	Graphite, ≤ 8 μm		✓		✓		1xD	0.4xD	400–500	0.200	0.250	0.280	0.300	0.350	0.380	0.400

* MAPAL machining groups

The specified machining values are guide values.
The optimum data for the respective machining task should be determined during the test or machining.