

SIDE MILLING

HYP-VG7-EMS															
	Mild Steels Carbon Steels Cast Iron			Tool Steel Alloy Steel <30HRC			Stainless steel			Titanium			Inconel		
	Ap = up to Max LOC, Ae= 0.15xD			Ap = up to Max LOC, Ae= 0.15xD			Ap = up to Max LOC, Ae= 0.1xD			Ap = up to Max LOC, Ae= 0.1xD			Ap = up to Max LOC, Ae= 0.1xD		
Vc	120 m/min			120 m/min			120 m/min			100 m/min			50 m/min		
Ø	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)
10	3820	2675	0.100	3820	2675	0.100	3180	1560	0.070	3180	1560	0.070	1590	780	0.070
12	3180	2450	0.110	3180	2450	0.110	2650	1575	0.085	2650	1575	0.085	1330	700	0.075
16	2390	2010	0.120	2390	2010	0.120	1990	1395	0.100	1990	1395	0.100	990	555	0.080
20	1910	1740	0.130	1910	1740	0.130	1590	1335	0.120	1590	1335	0.120	800	505	0.090