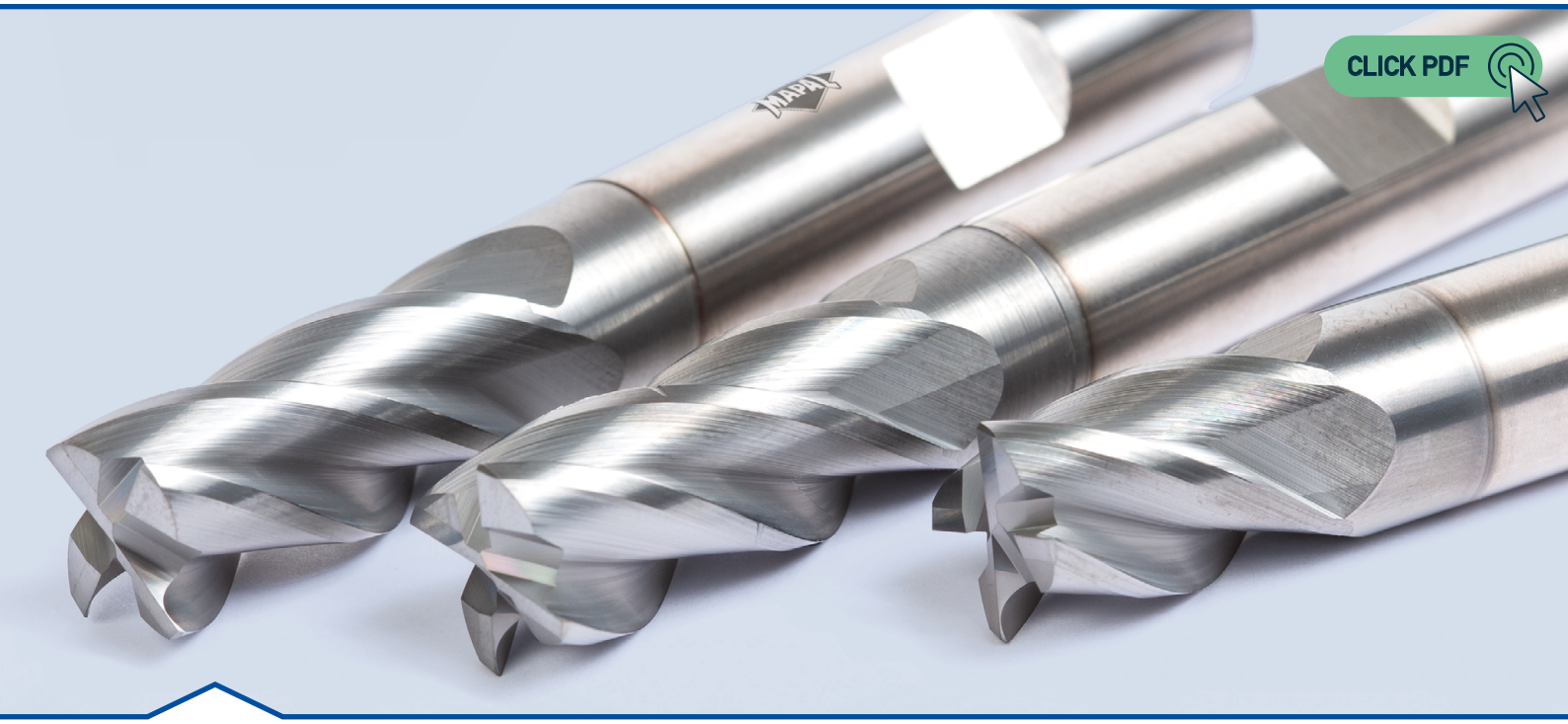


Your technology partner for cost-effective machining

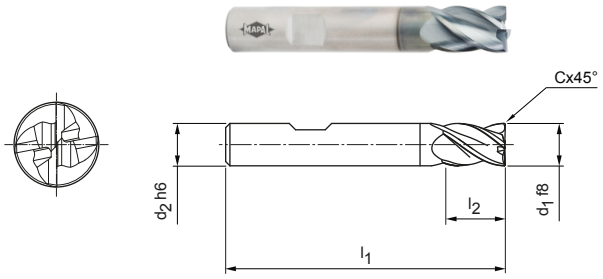
OptiMill®-Uni-HPC (3. Generation)

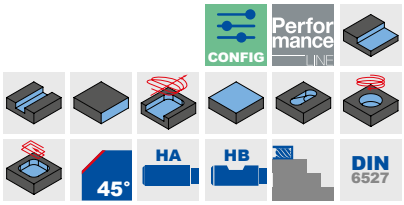
OptiMill®-Uni-HPC

Shoulder milling cutter, short design
SCM763, 3. Generation

Design:
Diameter of milling cutter: 3.00 - 20.00 mm
Cutting material: HP830
Number of cutting edges: 4
Helix angle: 36°/38°
Special feature: Unequal spacing

Application:
For maximum process reliability, dynamic stress, and automated processes.





Preferred series in stock

Dimensions					z	Specification	Order no.
d_1 f8	d_2 h6	l_1	l_2	Cx45°			
3,00	6	50	6	0,06	4	SCM763-0300Z04R-F0006HB-HP830	31578668
4,00	6	54	8	0,08	4	SCM763-0400Z04R-F0008HB-HP830	31578669
5,00	6	54	9	0,10	4	SCM763-0500Z04R-F0010HB-HP830	31578760
6,00	6	54	10	0,12	4	SCM763-0600Z04R-F0012HB-HP830	31578761
8,00	8	58	12	0,16	4	SCM763-0800Z04R-F0016HB-HP830	31578762
10,00	10	66	14	0,20	4	SCM763-1000Z04R-F0200HB-HP830	31578763
12,00	12	73	16	0,24	4	SCM763-1200Z04R-F0024HB-HP830	31578764
16,00	16	82	22	0,32	4	SCM763-1600Z04R-F0032HB-HP830	31578766
20,00	20	92	26	0,40	4	SCM763-2000Z04R-F0040HB-HP830	31578768

Available on request

14,00	14	73	16	0,28	4	SCM763-1400Z04R-F0028HB-HP830	31578765
18,00	18	82	22	0,36	4	SCM763-1800Z04R-F0036HB-HP830	31578767

Configurable features

Shank form:
Shank form: HA

Cutting edge design:
- Sharp cutting edge
- Corner chamfer 0.5% min - 7.5% max of d_1
- Corner radius 1.0% min - 37.5% max of d_1

Specification:
SCM763-1200Z04R-**[cutting edge design][shank form]**-HP830

Example:
SCM763-1200Z04R-**R0024HA**-HP830

Shank form HA

Radius 0.24 mm

Dimensions in mm.
Cutting data recommendations see pages 4/5.
Special designs and other coatings available on request.

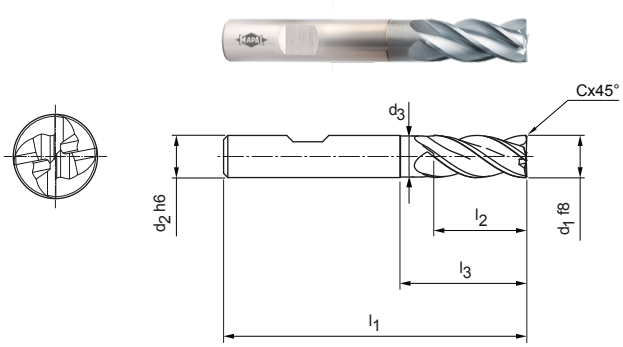
OptiMill®-Uni-HPC

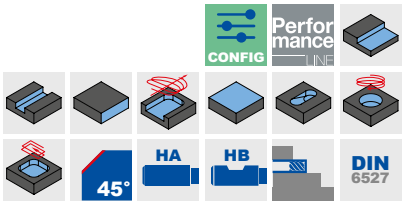
Shoulder milling cutter, long design with neck
SCM773, 3. Generation

Ausführung:

Diameter of milling cutter:	3.00 - 25.00 mm
Cutting material:	HP830
Number of cutting edges:	4
Helix angle:	36°/37°
Special feature:	Unequal spacing

Application:
For maximum process reliability, dynamic stress, and automated processes.





Preferred series in stock

Dimensions							z	Specification	Order no.
d_1 f8	d_2 h6	d_3	l_1	l_2	l_3	Cx45°			
3,00	6	2,8	57	8	11	0,06	4	SCM773-0300Z04R-F0006HB-HP830	31578775
4,00	6	3,8	57	11	13	0,08	4	SCM773-0400Z04R-F0008HB-HP830	31578776
5,00	6	4,8	57	13	15,5	0,10	4	SCM773-0500Z04R-F0010HB-HP830	31578769
6,00	6	5,8	57	13	20	0,12	4	SCM773-0600Z04R-F0012HB-HP830	31578770
8,00	8	7,8	63	21	25	0,16	4	SCM773-0800Z04R-F0016HB-HP830	31578771
10,00	10	9,8	72	22	30	0,20	4	SCM773-1000Z04R-F0020HB-HP830	31578772
12,00	12	11,8	83	26	36	0,24	4	SCM773-1200Z04R-F0024HB-HP830	31578773
14,00	14	13,8	83	26	36	0,28	4	SCM773-1400Z04R-F0028HB-HP830	31578774
16,00	16	15,8	92	36	42	0,32	4	SCM773-1600Z04R-F0032HB-HP830	31578777
20,00	20	19,8	104	41	55	0,40	4	SCM773-2000Z04R-F0040HB-HP830	31578779
25,00	25	24,5	136	68	80	0,50	4	SCM773-2500Z04R-F0050HB-HP830	31578780

Available on request

18,00	18	17,8	92	36	47	0,36	4	SCM773-1800Z04R-F0036HB-HP830	31578778

Preferred series in stock | Desing with a chip breaker

6,00	6	5,8	57	13	20	0,12	4	SCM773-0600Z04R-F0012HB-HP830	31578781
8,00	8	7,8	63	21	25	0,16	4	SCM773-0800Z04R-F0016HB-HP830	31578782
10,00	10	9,8	72	22	30	0,20	4	SCM773-1000Z04R-F0020HB-HP830	31578783
12,00	12	11,8	83	26	36	0,24	4	SCM773-1200Z04R-F0024HB-HP830	31578784
16,00	16	15,8	92	36	42	0,32	4	SCM773-1600Z04R-F0032HB-HP830	31578785
20,00	20	19,8	104	41	55	0,40	4	SCM773-2000Z04R-F0040HB-HP830	31578786
25,00	25	24,5	136	68	80	0,50	4	SCM773-2500Z04R-F0050HB-HP830	31578787

Configurable features

Shank form:
Shank form: HA

Cutting edge design:
- Sharp cutting edge
- Corner chamfer 0.5% min - 7.5% max of d_1
- Corner radius 1.0% min - 37.5% max of d_1

Specification:
SCM773-1200Z04R-**[cutting edge design][shank form]**-HP830

Example:
SCM773-1200Z04R-**R0024HA**-HP830

Shank form HA

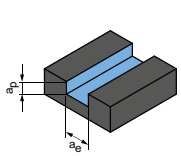
Radius 0.24 mm

Dimensions in mm.
Cutting data recommendations see pages 6/7.
Special designs and other coatings available on request.

Cutting data recommendations for shoulder milling cutters

Feed and cutting speed

Groove milling



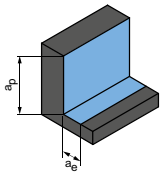
OptiMill-Uni-HPC | SCM763

MMG*			Workpiece material	Strength/ hardness [N/mm²] [HRC]	Cooling			v_c [m/ min]	f_z [mm] Diameter of milling cutter [mm]							
					MQL/Air	Dry	Coolant		3.00	4.00	6.00	8.00	10.00	12.00	16.00	20.00
P	P1	P1.1	Structural, free-cutting, case hardened and heat-treated steels, non-alloy	< 700	✓	✓	✓	**200**	0.019	0.025	0.036	0.046	0.055	0.064	0.078	0.089
		P1.2	Structural, free-cutting, case hardened and heat-treated steels, non-alloy	< 1,200	✓	✓	✓	**165**	0.018	0.024	0.034	0.043	0.052	0.059	0.073	0.083
	P2	P2.1	Nitrided, case hardened and heat-treated steels, alloy	< 900	✓	✓	✓	**180**	0.019	0.025	0.036	0.046	0.055	0.064	0.078	0.089
		P2.2	Nitrided, case hardened and heat-treated steels, alloy	< 1,400	✓		✓	**125**	0.016	0.021	0.030	0.039	0.046	0.053	0.065	0.074
	P3	P3.1	Tool, bearing, spring and high-speed steels**	< 800	✓	✓	✓	**120**	0.019	0.024	0.035	0.045	0.054	0.062	0.075	0.086
		P3.2	Tool, bearing, spring and high-speed steels**	< 1,000	✓		✓	**110**	0.018	0.023	0.033	0.042	0.051	0.058	0.071	0.081
		P3.3	Tool, bearing, spring and high-speed steels**	< 1,500	✓		✓	**100**	0.017	0.022	0.031	0.040	0.048	0.055	0.067	0.077
	P4	P4.1	Stainless steels, ferritic and martensitic		✓		✓	**80**	0.013	0.017	0.024	0.031	0.037	0.042	0.052	0.059
	P5	P5.1	Cast steel				✓	**120**	0.019	0.024	0.035	0.045	0.054	0.062	0.075	0.086
	P6	P6.1	Stainless cast steel, ferritic and martensitic				✓	**80**	0.009	0.012	0.017	0.022	0.026	0.030	0.036	0.041
M	M1	M1.1	Stainless steels, austenitic	< 700	✓		✓	55	0.011	0.014	0.020	0.026	0.031	0.036	0.043	0.050
		M1.2	Stainless steels, ferritic/austenitic (duplex)	< 1,000			✓	50	0.009	0.012	0.017	0.021	0.026	0.029	0.036	0.041
	M2	M2.1	Stainless/heat-resistant cast steel, austenitic	< 700	✓		✓	60	0.012	0.015	0.022	0.028	0.034	0.039	0.047	0.054
	M3	M3.1	Stainless cast steel, ferritic/austenitic (duplex)	< 1,000			✓	55	0.009	0.012	0.017	0.022	0.027	0.031	0.037	0.043
K	K1	K1.1	Cast iron with lamellar graphite (grey cast iron), GJL	< 300	✓	✓	✓	**215**	0.031	0.040	0.058	0.074	0.088	0.102	0.124	0.142
	K2	K2.1	Cast iron with spheroidal graphite, GJS	< 500	✓	✓	✓	**200**	0.026	0.034	0.049	0.063	0.075	0.086	0.106	0.121
		K2.2	Cast iron with spheroidal graphite, GJS	≤ 800	✓	✓	✓	**160**	0.022	0.028	0.040	0.052	0.062	0.071	0.087	0.099
		K2.3	Cast iron with spheroidal graphite, GJS	> 800	✓	✓	✓	**90**	0.012	0.016	0.023	0.030	0.035	0.041	0.050	0.057
	K3	K3.1	Cast iron with spheroidal graphite, GJV; malleable cast iron, GJM	< 500	✓	✓	✓	**145**	0.022	0.028	0.040	0.052	0.062	0.071	0.087	0.099
		K3.2	Cast iron with spheroidal graphite, GJV; malleable cast iron, GJM	> 500	✓	✓	✓	**135**	0.019	0.024	0.035	0.044	0.053	0.061	0.075	0.085
H	H1	H1.1	Hardened steel / cast steel	< 44	✓	✓	✓	100	0.016	0.021	0.030	0.038	0.046	0.053	0.065	0.057
		H1.2	Hardened steel / cast steel	< 55	✓	✓	✓									

* MAPAL machining groups

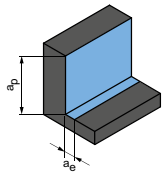
** If the alloy parts Cr, Mo, Ni, V, W in total > 8%, then select the next highest MAPAL machining group.

Roughing

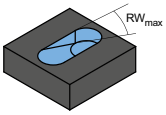


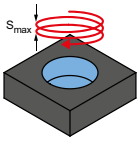
a_p = 1.5xD
a_e = 0.25xD

Finishing



a_p = 1xD
a_e = 0.1xD





v_c [m/min]	f_z [mm] Diameter of milling cutter [mm]								v_c [m/min]	f_z [mm] Diameter of milling cutter [mm]								Ramps	Helix milling			
	3.00	4.00	6.00	8.00	10.00	12.00	16.00	20.00		3.00	4.00	6.00	8.00	10.00	12.00	16.00	20.00	$RW_{max.}$	$S_{max.}$	G=1,5	$S_{max.}$ at G=1,8	G=1,8
355	0.026	0.034	0.049	0.063	0.075	0.086	0.106	0.121	**480**	0.032	0.042	0.060	0.077	0.092	0.106	0.129	0.148	10°	0.5xD	20°	1.5xD	30°
290	0.024	0.032	0.046	0.059	0.070	0.081	0.099	0.113	**395**	0.030	0.039	0.056	0.072	0.086	0.099	0.121	0.138	6°	0.4xD	15°	1.25xD	25°
325	0.026	0.034	0.049	0.063	0.075	0.086	0.106	0.121	**435**	0.032	0.042	0.060	0.077	0.092	0.106	0.129	0.148	8°	0.5xD	20°	1.5xD	30°
225	0.022	0.029	0.041	0.052	0.063	0.072	0.088	0.101	**305**	0.027	0.035	0.050	0.064	0.077	0.088	0.108	0.123	6°	0.25xD	10°	1.5xD	30°
210	0.025	0.033	0.048	0.061	0.073	0.084	0.102	0.117	**285**	0.031	0.040	0.058	0.074	0.089	0.102	0.125	0.143	6°	0.5xD	20°	1.5xD	30°
195	0.024	0.031	0.045	0.058	0.069	0.079	0.097	0.111	**260**	0.029	0.038	0.055	0.071	0.084	0.097	0.119	0.136	4°	0.5xD	20°	1.5xD	30°
180	0.023	0.030	0.043	0.054	0.065	0.075	0.092	0.105	**240**	0.028	0.036	0.052	0.067	0.080	0.092	0.112	0.128	2°	0.25xD	10°	0.75xD	20°
145	0.017	0.023	0.033	0.042	0.050	0.058	0.070	0.081	**195**	0.021	0.028	0.040	0.051	0.061	0.071	0.086	0.099	2°	0.03xD	1°	0.06xD	1.5°
215	0.025	0.033	0.048	0.061	0.073	0.084	0.102	0.117	**295**	0.031	0.040	0.058	0.074	0.089	0.102	0.125	0.143	4°	0.25xD	10°	0.75xD	20°
145	0.012	0.016	0.023	0.029	0.035	0.040	0.049	0.056	**195**	0.015	0.020	0.028	0.036	0.043	0.049	0.060	0.069	2°	0.03xD	1°	0.06xD	1.5°
110	0.022	0.028	0.040	0.052	0.062	0.071	0.087	0.099	160	0.034	0.045	0.064	0.082	0.098	0.113	0.137	0.157	2°	0.03xD	1°	0.06xD	1.5°
105	0.018	0.023	0.034	0.043	0.051	0.059	0.072	0.082	150	0.028	0.037	0.053	0.068	0.081	0.093	0.114	0.130	2°	0.03xD	1°	0.06xD	1.5°
120	0.023	0.031	0.044	0.056	0.067	0.077	0.094	0.108	180	0.037	0.048	0.069	0.089	0.106	0.122	0.149	0.171	2°	0.03xD	1°	0.06xD	1.5°
110	0.019	0.024	0.035	0.044	0.053	0.061	0.075	0.085	160	0.029	0.038	0.055	0.070	0.084	0.096	0.118	0.135	2°	0.03xD	1°	0.06xD	1.5°
440	0.062	0.080	0.116	0.148	0.177	0.203	0.248	0.284	**650**	0.098	0.127	0.183	0.234	0.280	0.322	0.393	0.449	15°	0.8xD	30°	2xD	40°
405	0.052	0.068	0.098	0.126	0.150	0.173	0.211	0.241	**595**	0.083	0.108	0.155	0.199	0.238	0.273	0.334	0.382	15°	0.8xD	30°	2xD	40°
330	0.043	0.056	0.081	0.103	0.124	0.142	0.174	0.199	**485**	0.068	0.089	0.128	0.164	0.196	0.225	0.275	0.314	10°	0.5xD	20°	1.5xD	30°
185	0.025	0.032	0.046	0.059	0.071	0.081	0.099	0.114	**270**	0.039	0.051	0.073	0.093	0.112	0.129	0.157	0.180	8°	0.25xD	8°	0.7xD	15°
295	0.043	0.056	0.081	0.103	0.124	0.142	0.174	0.199	**430**	0.068	0.089	0.128	0.164	0.196	0.225	0.275	0.314	10°	0.4xD	15°	0.75xD	20°
275	0.037	0.048	0.069	0.089	0.106	0.122	0.149	0.170	**405**	0.059	0.076	0.110	0.140	0.168	0.193	0.236	0.269	10°	0.4xD	15°	0.75xD	20°
200	0.025	0.032	0.046	0.059	0.071	0.081	0.099	0.114	295	0.051	0.066	0.095	0.121	0.145	0.167	0.204	0.234	6°	0.25xD	10°	1.5xD	30°

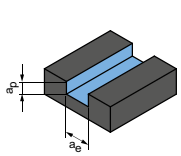
Circular pocket calculation example:
For a circular pocket of 21.6 mm at G=1.8 (cutter diameter 12 mm)

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

Cutting data recommendations for shoulder milling cutters

Feed and cutting speed

Groove milling



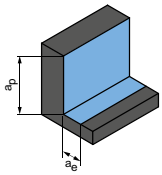
OptiMill-Uni-HPC | SCM773

MMG*			Workpiece material	Strength/ hardness [N/mm²] [HRC]	Cooling			v_c [m/ min]	f_z [mm] Diameter of milling cutter [mm]							
					MQL/Air	Dry	Coolant		3.00	4.00	6.00	8.00	10.00	12.00	16.00	20.00
P	P1	P1.1	Structural, free-cutting, case hardened and heat-treated steels, non-alloy	< 700	✓	✓	✓	**200**	0.019	0.025	0.036	0.046	0.055	0.064	0.078	0.089
		P1.2	Structural, free-cutting, case hardened and heat-treated steels, non-alloy	< 1,200	✓	✓	✓	**165**	0.018	0.024	0.034	0.043	0.052	0.059	0.073	0.083
	P2	P2.1	Nitrided, case hardened and heat-treated steels, alloy	< 900	✓	✓	✓	**180**	0.019	0.025	0.036	0.046	0.055	0.064	0.078	0.089
		P2.2	Nitrided, case hardened and heat-treated steels, alloy	< 1,400	✓		✓	**125**	0.016	0.021	0.030	0.039	0.046	0.053	0.065	0.074
	P3	P3.1	Tool, bearing, spring and high-speed steels**	< 800	✓	✓	✓	**120**	0.019	0.024	0.035	0.045	0.054	0.062	0.075	0.086
		P3.2	Tool, bearing, spring and high-speed steels**	< 1,000	✓		✓	**110**	0.018	0.023	0.033	0.042	0.051	0.058	0.071	0.081
		P3.3	Tool, bearing, spring and high-speed steels**	< 1,500	✓		✓	**100**	0.017	0.022	0.031	0.040	0.048	0.055	0.067	0.077
	P4	P4.1	Stainless steels, ferritic and martensitic		✓		✓	**80**	0.013	0.017	0.024	0.031	0.037	0.042	0.052	0.059
	P5	P5.1	Cast steel				✓	**120**	0.019	0.024	0.035	0.045	0.054	0.062	0.075	0.086
	P6	P6.1	Stainless cast steel, ferritic and martensitic				✓	**80**	0.009	0.012	0.017	0.022	0.026	0.030	0.036	0.041
M	M1	M1.1	Stainless steels, austenitic	< 700	✓		✓	55	0.011	0.014	0.020	0.026	0.031	0.036	0.043	0.050
		M1.2	Stainless steels, ferritic/austenitic (duplex)	< 1,000			✓	50	0.009	0.012	0.017	0.021	0.026	0.029	0.036	0.041
	M2	M2.1	Stainless/heat-resistant cast steel, austenitic	< 700	✓		✓	60	0.012	0.015	0.022	0.028	0.034	0.039	0.047	0.054
	M3	M3.1	Stainless cast steel, ferritic/austenitic (duplex)	< 1,000			✓	55	0.009	0.012	0.017	0.022	0.027	0.031	0.037	0.043
K	K1	K1.1	Cast iron with lamellar graphite (grey cast iron), GJL	< 300	✓	✓	✓	**215**	0.031	0.040	0.058	0.074	0.088	0.102	0.124	0.142
	K2	K2.1	Cast iron with spheroidal graphite, GJS	< 500	✓	✓	✓	**200**	0.026	0.034	0.049	0.063	0.075	0.086	0.106	0.121
		K2.2	Cast iron with spheroidal graphite, GJS	≤ 800	✓	✓	✓	**160**	0.022	0.028	0.040	0.052	0.062	0.071	0.087	0.099
		K2.3	Cast iron with spheroidal graphite, GJS	> 800	✓	✓	✓	**90**	0.012	0.016	0.023	0.030	0.035	0.041	0.050	0.057
	K3	K3.1	Cast iron with spheroidal graphite, GJV; malleable cast iron, GJM	< 500	✓	✓	✓	**145**	0.022	0.028	0.040	0.052	0.062	0.071	0.087	0.099
		K3.2	Cast iron with spheroidal graphite, GJV; malleable cast iron, GJM	> 500	✓	✓	✓	**135**	0.019	0.024	0.035	0.044	0.053	0.061	0.075	0.085
H	H1	H1.1	Hardened steel / cast steel	< 44	✓	✓	✓	100	0.016	0.021	0.030	0.038	0.046	0.053	0.065	0.057
		H1.2	Hardened steel / cast steel	< 55	✓	✓	✓									

* MAPAL machining groups

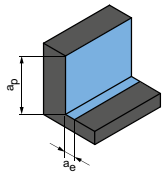
** If the alloy parts Cr, Mo, Ni, V, W in total > 8%, then select the next highest MAPAL machining group.

Roughing

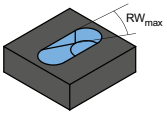


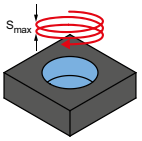
a_p = 1.5xD
a_e = 0.25xD

Finishing



a_p = 1xD
a_e = 0.1xD





v_c [m/min]	f_z [mm] Diameter of milling cutter [mm]								v_c [m/min]	f_z [mm] Diameter of milling cutter [mm]								Ramps	Helix milling			
	3.00	4.00	6.00	8.00	10.00	12.00	16.00	20.00		3.00	4.00	6.00	8.00	10.00	12.00	16.00	20.00	$RW_{max.}$	$S_{max.}$	G=1,5	$S_{max.}$ at G=1,8	G=1,8
355	0.026	0.034	0.049	0.063	0.075	0.086	0.106	0.121	**480**	0.032	0.042	0.060	0.077	0.092	0.106	0.129	0.148	10°	0.5xD	20°	1.5xD	30°
290	0.024	0.032	0.046	0.059	0.070	0.081	0.099	0.113	**395**	0.030	0.039	0.056	0.072	0.086	0.099	0.121	0.138	6°	0.4xD	15°	1.25xD	25°
325	0.026	0.034	0.049	0.063	0.075	0.086	0.106	0.121	**435**	0.032	0.042	0.060	0.077	0.092	0.106	0.129	0.148	8°	0.5xD	20°	1.5xD	30°
225	0.022	0.029	0.041	0.052	0.063	0.072	0.088	0.101	**305**	0.027	0.035	0.050	0.064	0.077	0.088	0.108	0.123	6°	0.25xD	10°	1.5xD	30°
210	0.025	0.033	0.048	0.061	0.073	0.084	0.102	0.117	**285**	0.031	0.040	0.058	0.074	0.089	0.102	0.125	0.143	6°	0.5xD	20°	1.5xD	30°
195	0.024	0.031	0.045	0.058	0.069	0.079	0.097	0.111	**260**	0.029	0.038	0.055	0.071	0.084	0.097	0.119	0.136	4°	0.5xD	20°	1.5xD	30°
180	0.023	0.030	0.043	0.054	0.065	0.075	0.092	0.105	**240**	0.028	0.036	0.052	0.067	0.080	0.092	0.112	0.128	2°	0.25xD	10°	0.75xD	20°
145	0.017	0.023	0.033	0.042	0.050	0.058	0.070	0.081	**195**	0.021	0.028	0.040	0.051	0.061	0.071	0.086	0.099	2°	0.03xD	1°	0.06xD	1.5°
215	0.025	0.033	0.048	0.061	0.073	0.084	0.102	0.117	**295**	0.031	0.040	0.058	0.074	0.089	0.102	0.125	0.143	4°	0.25xD	10°	0.75xD	20°
145	0.012	0.016	0.023	0.029	0.035	0.040	0.049	0.056	**195**	0.015	0.020	0.028	0.036	0.043	0.049	0.060	0.069	2°	0.03xD	1°	0.06xD	1.5°
110	0.018	0.024	0.034	0.044	0.053	0.060	0.074	0.084	160	0.029	0.038	0.054	0.069	0.083	0.095	0.117	0.133	2°	0.03xD	1°	0.06xD	1.5°
105	0.015	0.020	0.028	0.036	0.044	0.050	0.061	0.070	150	0.024	0.031	0.045	0.057	0.069	0.079	0.097	0.110	2°	0.03xD	1°	0.06xD	1.5°
120	0.020	0.026	0.037	0.048	0.057	0.066	0.080	0.092	180	0.031	0.041	0.059	0.075	0.090	0.104	0.127	0.145	2°	0.03xD	1°	0.06xD	1.5°
110	0.016	0.020	0.029	0.038	0.045	0.052	0.063	0.072	160	0.025	0.032	0.047	0.059	0.071	0.082	0.100	0.114	2°	0.03xD	1°	0.06xD	1.5°
440	0.052	0.068	0.098	0.125	0.150	0.172	0.211	0.241	**650**	0.083	0.108	0.155	0.198	0.237	0.273	0.333	0.381	15°	0.8xD	30°	2xD	40°
405	0.044	0.058	0.083	0.106	0.128	0.147	0.179	0.205	**595**	0.070	0.092	0.132	0.168	0.202	0.232	0.283	0.324	15°	0.8xD	30°	2xD	40°
330	0.037	0.048	0.069	0.088	0.105	0.121	0.147	0.169	**485**	0.058	0.076	0.109	0.139	0.166	0.191	0.233	0.267	10°	0.5xD	20°	1.5xD	30°
185	0.021	0.027	0.039	0.050	0.060	0.069	0.084	0.096	**270**	0.033	0.043	0.062	0.079	0.095	0.109	0.133	0.152	8°	0.25xD	8°	0.7xD	15°
295	0.037	0.048	0.069	0.088	0.105	0.121	0.147	0.169	**430**	0.058	0.076	0.109	0.139	0.166	0.191	0.233	0.267	10°	0.4xD	15°	0.75xD	20°
275	0.031	0.041	0.059	0.075	0.090	0.103	0.126	0.145	**405**	0.050	0.065	0.093	0.119	0.142	0.164	0.200	0.228	10°	0.4xD	15°	0.75xD	20°
200	0.021	0.027	0.039	0.050	0.060	0.069	0.084	0.096	295	0.043	0.056	0.081	0.103	0.123	0.142	0.173	0.198	6°	0.25xD	10°	1.5xD	30°

Circular pocket calculation example:
For a circular pocket of 21.6 mm at G=1.8 (cutter diameter 12 mm)

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

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