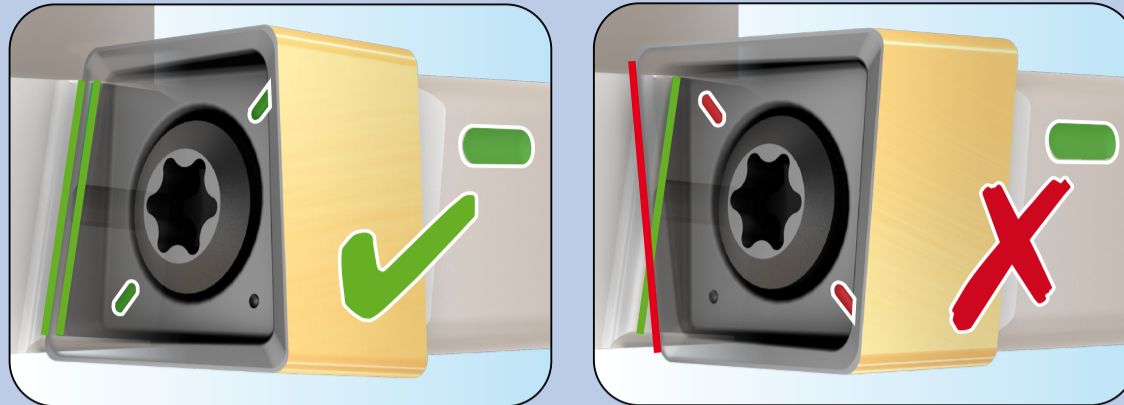
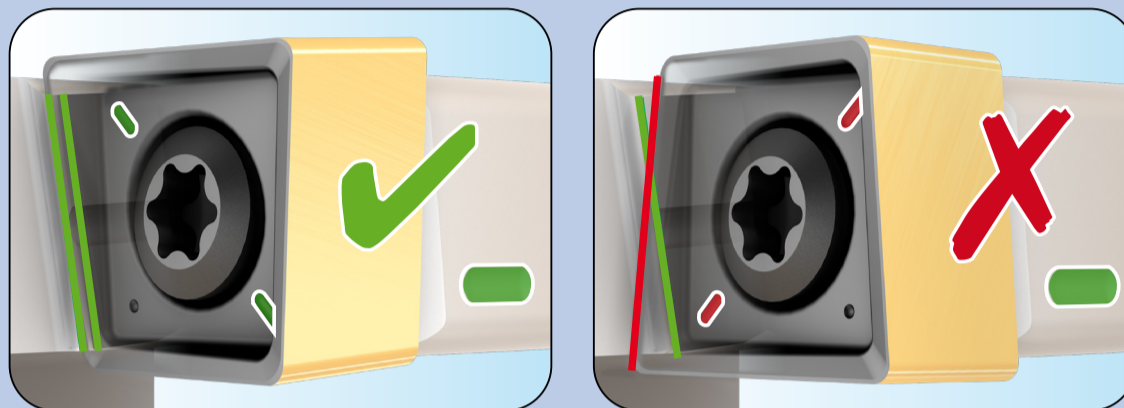


## Mounting an XNMU 0603... Insert on Slot Milling Cutters

Top Pocket



Bottom Pocket



The Symbol on the Insert and Tool Body Must Align



## Starting Feed Per Tooth $f_z$ for HeliSlot 06 Slotting Mills with Inserts XNMU 06...

ISO Class DIN/ISO 513	Workpiece Material				Feed $f_z$ mm/tooth		
	Description	ISCAR Material Group**	Typical Representative		Hardness, HB	Grades	
			AISI/SAE/ASTM	DIN W.-Nr.		IC808	IC830
P	non-alloy steel	1	1020	1.0044	130-180	0.10-0.20	0.10-0.20
	alloy steel	8	4340	1.6582	260-300	0.08-0.12	0.08-0.12
	alloy steel	9	4340	1.6582	HRC 35-42*	0.08-0.12	0.08-0.12
	high alloy steel	10	H13	1.2344	200-220	0.08-0.12	0.08-0.12
	martensitic s.s.	12	420	1.4021	200	0.08-0.12	0.08-0.12
M	austenitic s.s.	14	304L	1.4306	200	0.08-0.12	0.08-0.12
	austenitic s.s.	14	316L	1.4404	140	0.08-0.12	0.08-0.12
K	grey cast iron	16	class 40	0.6025 (GG25)	250	0.10-0.20	
	nodular cast iron	17	class 65-45-12	0.7050 (GGG50)	200	0.08-0.15	
H	hard steel and cast iron	38.1	H11	1.2343	HRC 45-49	0.06-0.12	
		38.2	P20	1.2330	HRC 50-55	0.05-0.10	

\* Quenched and tempered

\*\* ISCAR material group in accordance with VDI 3323 standard