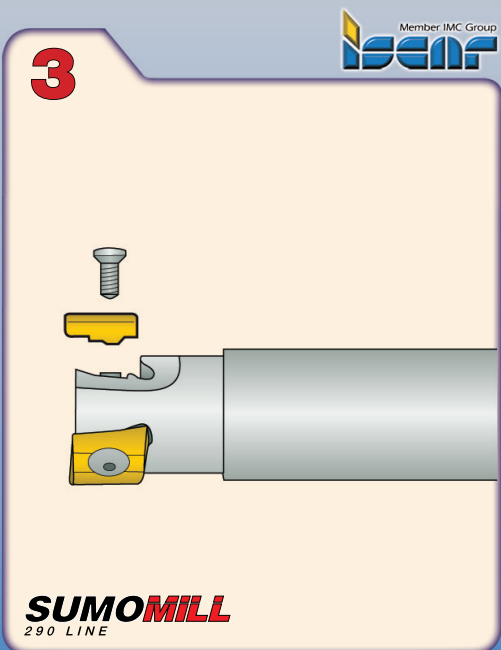
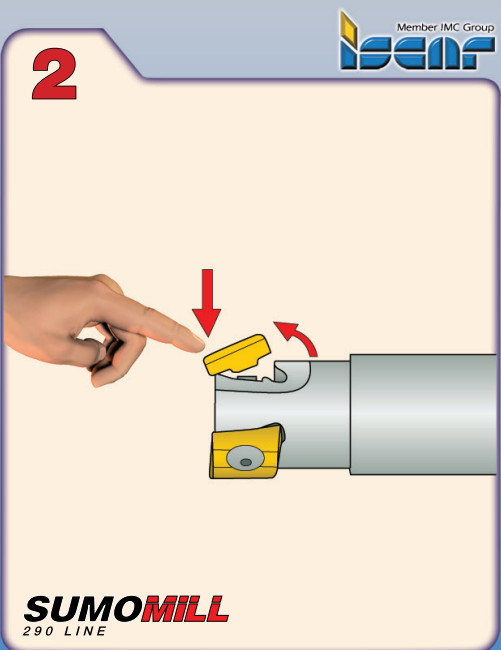
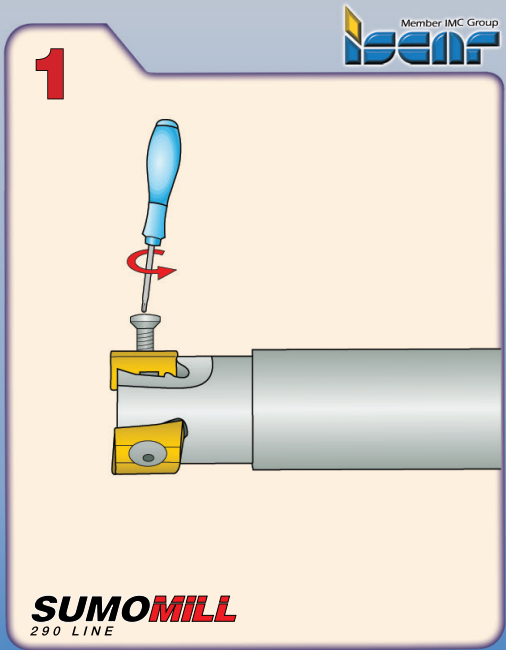


Shouldering and Slotting ⁽¹⁾

			Typical Examples		Depth of Cut (D.O.C.)		Width of Cut		Cutting Speed		D - Cutter Diameter (mm / <i>inch</i>)				
Feed Rate fz (mm/t / <i>inch/t</i>)															
	VDI 3323 Material Group	Workpiece Material	SAE/AISI (DIN) ⁽²⁾	Hardness	mm	<i>inch</i>	mm	<i>inch</i>	Vc m/min	<i>SFM</i>	8 mm <i>.312"</i>	10 mm <i>.375"</i>	12 mm <i>.50"</i>	14 mm <i>.56"</i>	16 mm <i>.625"</i>
P	1-5	Non-alloy steel	1018 1020 ST-37 (DIN 1.0402)	130-180 HB	4	<i>0.16</i>	2	<i>0.078</i>	80-120	<i>260-400</i>	0.03-0.05	0.03-0.05	0.03-0.05	0.05-0.08	0.05-0.08
					1	<i>0.04</i>	0.7D				<i>.001-.002</i>	<i>.001-.002</i>	<i>.001-.002</i>	<i>.002-.003</i>	<i>.002-.003</i>
	6-8	Low alloy	4340 (DIN 1.6582)	24-30 HRC	4	<i>0.16</i>	2	<i>0.078</i>	80-120	<i>260-400</i>	0.03-0.05	0.03-0.05	0.03-0.05	0.05-0.08	0.05-0.08
					1	<i>0.04</i>	0.7D				<i>.001-.002</i>	<i>.001-.002</i>	<i>.001-.002</i>	<i>.002-.003</i>	<i>.002-.003</i>
	9	Steel	P20 (DIN 1.2311)	30-35 HRC	4	<i>0.16</i>	2	<i>0.078</i>	70-100	<i>230-330</i>	0.03-0.04	0.03-0.04	0.03-0.04	0.05-0.06	0.05-0.06
					1	<i>0.04</i>	0.7D				<i>.001-.0015</i>	<i>.001-.0015</i>	<i>.001-.0015</i>	<i>.002-.0023</i>	<i>.002-.0023</i>
M	13	Stainless Steel (Martensitic)	AISI 420 (DIN 1.4021)	200 HB	4	<i>0.04</i>	2	<i>0.078</i>	80-100	<i>260-330</i>	0.04-0.06	0.04-0.07	0.04-0.07	0.04-0.07	0.04-0.07
											<i>.0015-.0023</i>	<i>.0015-.0027</i>	<i>.0015-.0027</i>	<i>.0015-.0027</i>	<i>.0015-.0027</i>
	14	Stainless Steel (Austenitic)	AISI 304L (DIN 1.4306)	200 HB	4	<i>0.16</i>	2	<i>0.078</i>	60-90	<i>200-300</i>	0.03-0.05	0.04-0.07	0.04-0.07	0.04-0.07	0.04-0.07
					1	<i>0.04</i>	0.7D				<i>.001-.002</i>	<i>.0015-.0027</i>	<i>.0015-.0027</i>	<i>.0015-.0027</i>	<i>.0015-.0027</i>
			AISI 316L (DIN 1.4304)	140 HB	4	<i>0.16</i>	2	<i>0.078</i>	70-100	<i>230-330</i>	0.04-0.06	0.04-0.07	0.04-0.07	0.04-0.07	0.04-0.07
					1	<i>0.16</i>	0.7D				<i>.0015-.0023</i>	<i>.0015-.0027</i>	<i>.0015-.0027</i>	<i>.0015-.0027</i>	<i>.0015-.0027</i>
K	16	Grey cast iron	A48-40 B GG25 (DIN 0.6025)	250HB	4	<i>0.16</i>	2	<i>0.078</i>	100-150	<i>330-500</i>	0.04-0.08	0.04-0.09	0.04-0.09	0.04-0.09	0.04-0.09
					1	<i>0.04</i>	0.7D				<i>.0015-.003</i>	<i>.0015-.0035</i>	<i>.0015-.0035</i>	<i>.0015-.0035</i>	<i>.0015-.0035</i>
	17	Nodular cast iron	65-45-12 GGG50 (DIN 0.705)	200HB	4	<i>0.16</i>	2	<i>0.078</i>	90-140	<i>300-460</i>	0.05-0.06	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
					1	<i>0.04</i>	0.7D				<i>.002-.0023</i>	<i>.002-.003</i>	<i>.002-.003</i>	<i>.002-.003</i>	<i>.002-.003</i>

⁽¹⁾ for slotting applications, reduce the cutting conditions (Vc & fz) by 30% ⁽²⁾ Same or equivalent grade



In order to extract the insert, press it on the front side with your finger tip.

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T290-05 Insert Information