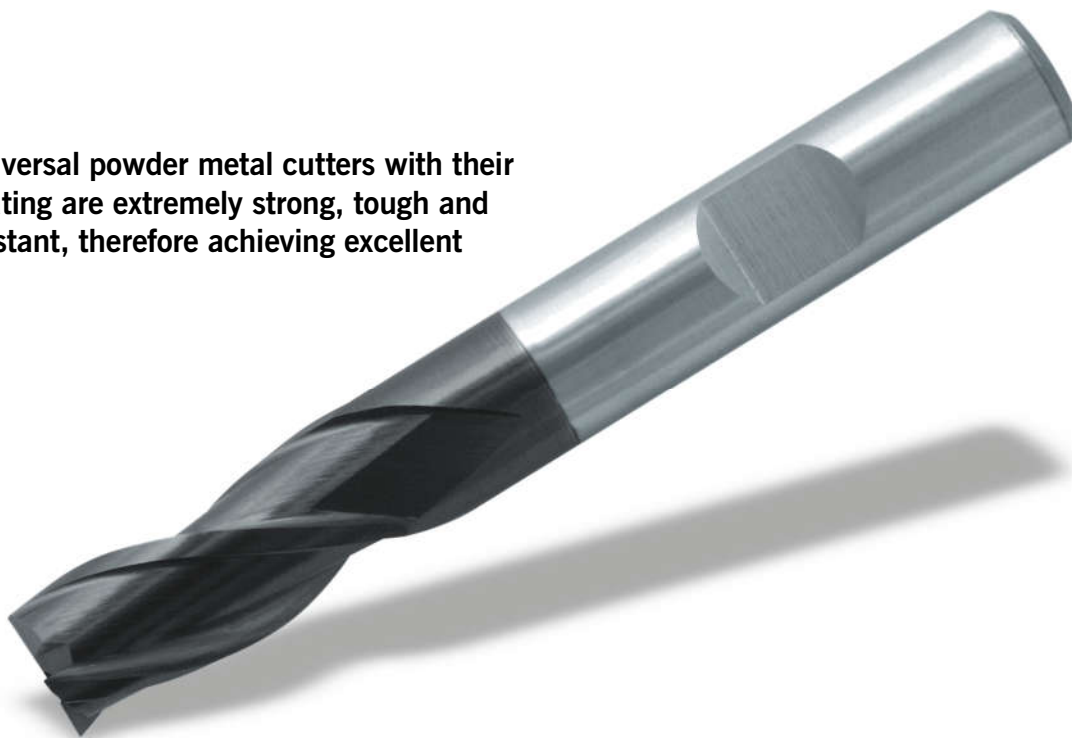


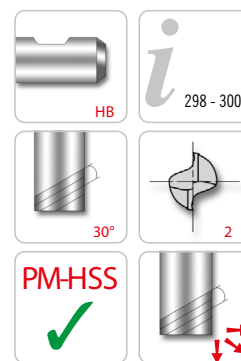
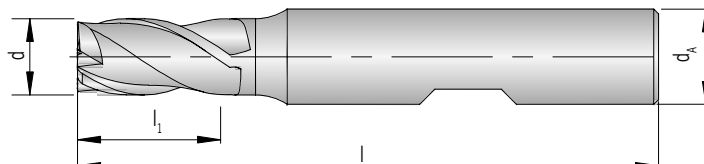
GREAT PERFORMANCE AND MINIMAL WEAR FOR MACHINING STEEL, STAINLESS STEEL, EXOTICS AND CAST MATERIALS.

These universal powder metal cutters with their TiAlN coating are extremely strong, tough and wear resistant, therefore achieving excellent tool life.



FP60120-....

2 flutes, short design



Shank DIN 6535HB	d e8	d _A h6	l ₁	l	PMC
					TAIN
FP60120-020	2	6	4	48	◆
FP60120-030	3	6	5	49	◆
FP60120-040	4	6	7	51	◆
FP60120-050	5	6	8	52	◆
FP60120-060	6	6	8	52	◆
FP60120-070	7	10	10	60	◆
FP60120-080	8	10	11	61	◆
FP60120-090	9	10	11	61	◆
FP60120-100	10	10	13	63	◆
FP60120-120	12	12	16	73	◆
FP60120-140	14	12	16	73	◆
FP60120-160	16	16	19	79	◆
FP60120-180	18	16	19	79	◆
FP60120-200	20	20	22	88	◆
FP60120-220	22	20	22	88	◆
FP60120-250	25	25	26	102	◆

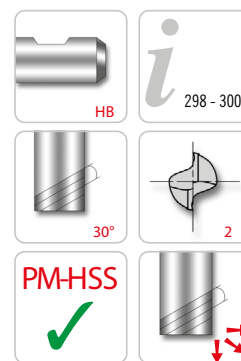
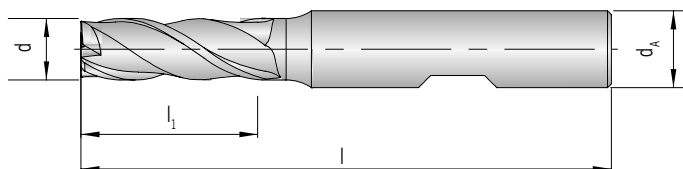
PMC = PM-HSS coated

P	●
M	●
K	●
N	
S	○
H	

● Main application
○ Secondary application

FP60121-....

2 flutes, long design



Shank DIN 6535HB	d e8	d _A h6	l ₁	l	PMC
					TAIN
FP60121-020	2	6	7	51	◆
FP60121-030	3	6	8	52	◆
FP60121-040	4	6	11	55	◆
FP60121-050	5	6	13	57	◆
FP60121-060	6	6	13	57	◆
FP60121-070	7	10	16	66	◆
FP60121-080	8	10	19	69	◆
FP60121-090	9	10	19	69	◆
FP60121-100	10	10	22	72	◆
FP60121-120	12	12	26	83	◆
FP60121-140	14	12	26	83	◆
FP60121-160	16	16	32	92	◆
FP60121-180	18	16	32	92	◆
FP60121-200	20	20	38	104	◆
FP60121-220	22	20	38	104	◆
FP60121-250	25	25	45	121	◆

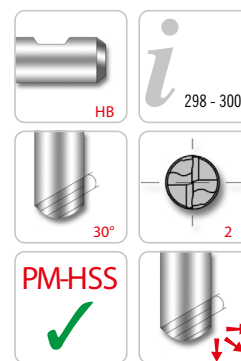
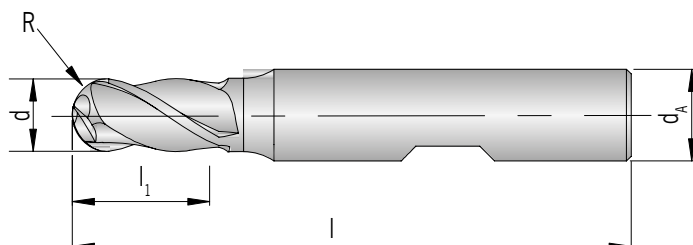
PMC = PM-HSS coated

P	●
M	●
K	●
N	
S	○
H	

● Main application
○ Secondary application

FP60320-...

2 flutes, short design



Shank DIN 6535HB	d -0,03	d _A h6	l ₁	l	R ±0,02	PMC
						TAIN
FP60320-020	2	6	4	48	1.0	◆
FP60320-030	3	6	5	49	1.5	◆
FP60320-040	4	6	7	51	2.0	◆
FP60320-050	5	6	8	52	2.5	◆
FP60320-060	6	6	8	52	3.0	◆
FP60320-070	7	10	10	60	3.5	◆
FP60320-080	8	10	11	61	4.0	◆
FP60320-090	9	10	11	61	4.5	◆
FP60320-100	10	10	13	63	5.0	◆
FP60320-120	12	12	16	73	6.0	◆
FP60320-140	14	12	16	73	7.0	◆
FP60320-160	16	16	19	79	8.0	◆
FP60320-180	18	16	19	79	9.0	◆
FP60320-200	20	20	22	88	10.0	◆
FP60320-220	22	20	22	88	11.0	◆
FP60320-250	25	25	26	102	12.5	◆

PMC = PM-HSS coated

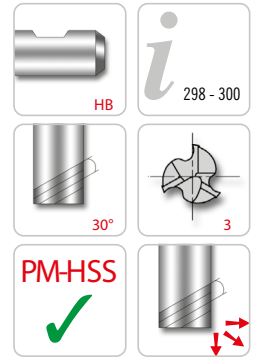
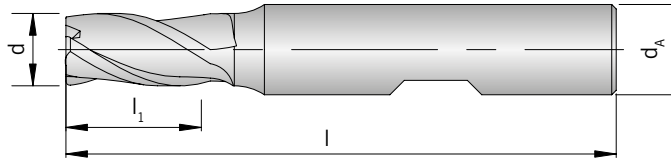
P	●
M	●
K	●
N	
S	○
H	

● Main application

○ Secondary application

FP60135-...

3 flutes, extra short design



Shank DIN 6535HB	d e8	d _A h6	l ₁	l	PMC
					TAIN
FP60135-020	2	6	4	48	◆
FP60135-030	3	6	5	49	◆
FP60135-040	4	6	7	51	◆
FP60135-050	5	6	8	52	◆
FP60135-060	6	6	8	52	◆
FP60135-070	7	10	10	60	◆
FP60135-080	8	10	11	61	◆
FP60135-090	9	10	11	61	◆
FP60135-100	10	10	13	63	◆
FP60135-120	12	12	16	73	◆
FP60135-140	14	12	16	73	◆
FP60135-160	16	16	19	79	◆
FP60135-180	18	16	19	79	◆
FP60135-200	20	20	22	88	◆
FP60135-220	22	20	22	88	◆
FP60135-250	25	25	26	102	◆

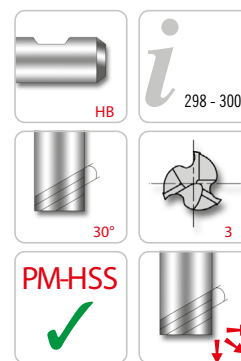
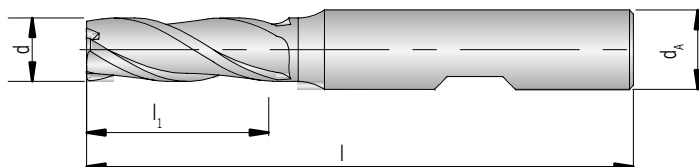
PMC = PM-HSS coated

P	●
M	●
K	●
N	
S	○
H	

● Main application
○ Secondary application

FP60130-....

3 flutes, short design



Shank DIN 6535HB	d e8	d _A h6	l ₁	l	PMC
					TAIN
FP60130-020	2	6	7	51	◆
FP60130-030	3	6	8	52	◆
FP60130-040	4	6	11	55	◆
FP60130-050	5	6	13	57	◆
FP60130-060	6	6	13	57	◆
FP60130-070	7	10	16	66	◆
FP60130-080	8	10	19	69	◆
FP60130-090	9	10	19	69	◆
FP60130-100	10	10	22	72	◆
FP60130-120	12	12	26	83	◆
FP60130-140	14	12	26	83	◆
FP60130-160	16	16	32	92	◆
FP60130-180	18	16	32	92	◆
FP60130-200	20	20	38	104	◆
FP60130-220	22	20	38	104	◆
FP60130-250	25	25	45	121	◆

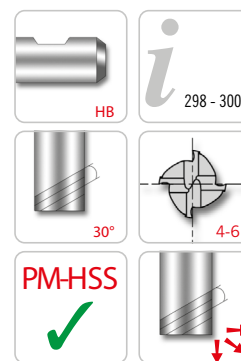
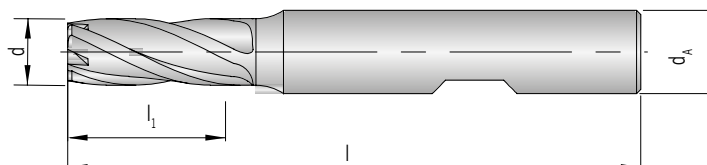
PMC = PM-HSS coated

P	●
M	●
K	●
N	
S	○
H	

● Main application
○ Secondary application

FP601.0-...

4 - 6 flutes, short design



Shank DIN 6535HB	d -0,03	d _A h6	l ₁	l	z	PMC
						TAIN
FP60140-020	2	6	7	51	4	◆
FP60140-030	3	6	8	52	4	◆
FP60140-040	4	6	11	55	4	◆
FP60140-050	5	6	13	57	4	◆
FP60140-060	6	6	13	57	4	◆
FP60140-070	7	10	16	66	4	◆
FP60140-080	8	10	19	69	4	◆
FP60140-090	9	10	19	69	4	◆
FP60140-100	10	10	22	72	4	◆
FP60140-120	12	12	26	83	4	◆
FP60140-140	14	12	26	83	4	◆
FP60140-160	16	16	32	92	4	◆
FP60140-180	18	16	32	92	4	◆
FP60140-200	20	20	38	104	4	◆
FP60140-220	22	20	38	104	4	◆
FP60140-250	25	25	45	121	4	◆
FP60160-280	28	25	45	121	6	◆
FP60160-300	30	25	45	121	6	◆
FP60160-320	32	32	53	133	6	◆

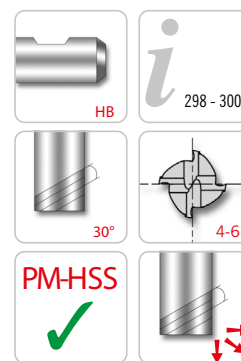
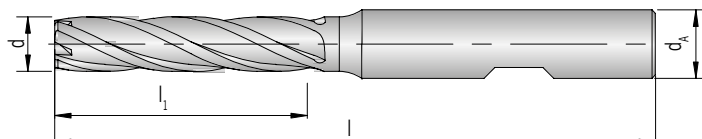
PMC = PM-HSS coated

P	●
M	●
K	●
N	
S	○
H	

● Main application
○ Secondary application

FP601.1-....

4 - 6 flutes, long design



Shank DIN 6535HB	d -0,03	d _A h6	l ₁	l	z	PMC
						TAIN
FP60141-020	2	6	10	54	4	◆
FP60141-030	3	6	12	56	4	◆
FP60141-040	4	6	19	63	4	◆
FP60141-050	5	6	24	68	4	◆
FP60141-060	6	6	24	68	4	◆
FP60141-070	7	10	30	80	4	◆
FP60141-080	8	10	38	88	4	◆
FP60141-090	9	10	38	88	4	◆
FP60141-100	10	10	45	95	4	◆
FP60141-120	12	12	53	110	4	◆
FP60141-140	14	12	53	110	4	◆
FP60141-160	16	16	63	123	4	◆
FP60141-180	18	16	63	123	4	◆
FP60141-200	20	20	75	141	4	◆
FP60141-220	22	20	75	141	4	◆
FP60141-250	25	25	90	166	4	◆
FP60161-280	28	25	90	166	6	◆
FP60161-300	30	25	90	166	6	◆
FP60161-320	32	32	106	186	6	◆

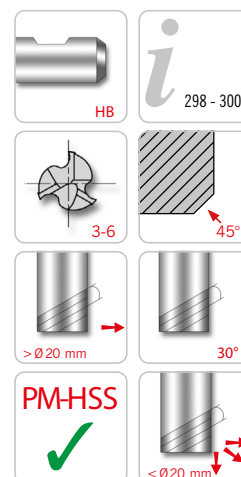
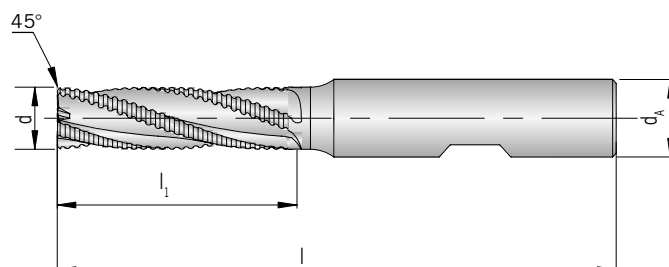
PMC = PM-HSS coated

P	●
M	●
K	●
N	
S	○
H	

● Main application
○ Secondary application

FP618.0-...

3 - 6 flutes, short design



Shank DIN 6535HB	d <i>js12</i>	d _A <i>h6</i>	l ₁	l	Chamfer	z	PMC
							TAIN
FP61830-060	6	6	13	57	0,18 x 45°	3	◆
FP61830-070	7	10	16	66	0,18 x 45°	3	◆
FP61830-080	8	10	19	69	0,18 x 45°	3	◆
FP61830-090	9	10	19	69	0,18 x 45°	3	◆
FP61840-100	10	10	22	72	0,18 x 45°	4	◆
FP61840-120	12	12	26	83	0,18 x 45°	4	◆
FP61840-140	14	12	26	83	0,25 x 45°	4	◆
FP61840-160	16	16	32	92	0,25 x 45°	4	◆
FP61840-180	18	16	32	92	0,25 x 45°	4	◆
FP61840-200	20	20	38	104	0,25 x 45°	4	◆
FP61850-220	22	20	38	104	0,36 x 45°	5	◆
FP61850-250	25	25	45	121	0,36 x 45°	5	◆
FP61860-280	28	25	45	121	0,36 x 45°	6	◆
FP61860-300	30	25	45	121	0,36 x 45°	6	◆
FP61860-320	32	32	53	133	0,36 x 45°	6	◆

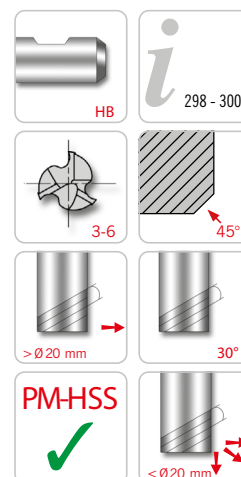
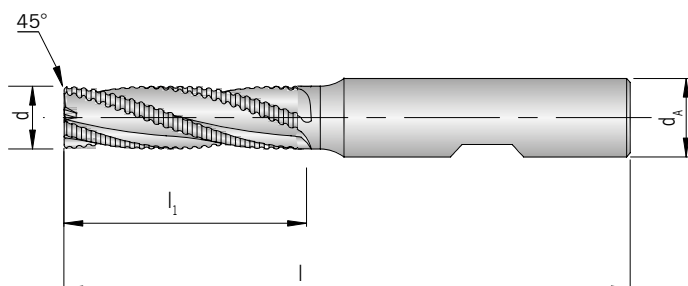
PMC = PM-HSS coated

P	●
M	●
K	●
N	
S	○
H	

● Main application
○ Secondary application

FP618.6-...

3 - 6 flutes, mid-length design



Shank DIN 6535HB	d <i>js12</i>	d _A <i>h6</i>	l ₁	l	Chamfer	z	PMC
							TAIN
FP61836-060	6	6	19	63	0,18 x 45°	3	◆
FP61836-070	7	6	19	63	0,18 x 45°	3	◆
FP61836-080	8	10	28	74	0,18 x 45°	3	◆
FP61836-090	9	10	28	74	0,18 x 45°	3	◆
FP61846-100	10	10	35	84	0,18 x 45°	4	◆
FP61846-120	12	12	40	97	0,18 x 45°	4	◆
FP61846-140	14	12	40	97	0,25 x 45°	4	◆
FP61846-160	16	16	48	108	0,25 x 45°	4	◆
FP61846-180	18	16	48	108	0,25 x 45°	4	◆
FP61846-200	20	20	58	122	0,25 x 45°	4	◆
FP61856-220	22	20	58	122	0,36 x 45°	5	◆
FP61856-250	25	25	68	144	0,36 x 45°	5	◆
FP61866-280	28	25	68	144	0,36 x 45°	6	◆
FP61866-300	30	25	68	144	0,36 x 45°	6	◆
FP61866-320	32	32	78	158	0,36 x 45°	6	◆

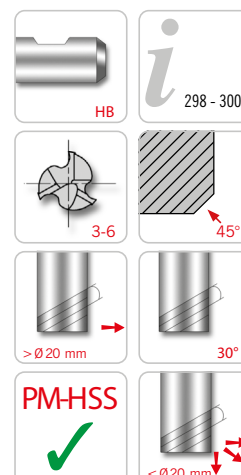
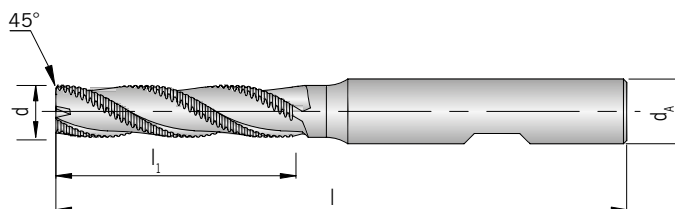
PMC = PM-HSS coated

P	●
M	●
K	●
N	
S	○
H	

● Main application
○ Secondary application

FP618.1-...

3 - 6 flutes, long design



Shank DIN 6535HB	d <i>js12</i>	d _A <i>h6</i>	l ₁	l	Chamfer	z	PMC
							TAIN
FP61831-060	6	6	24	68	0,18 x 45°	3	◆
FP61831-070	7	10	30	80	0,18 x 45°	3	◆
FP61831-080	8	10	38	88	0,18 x 45°	3	◆
FP61831-090	9	10	38	88	0,18 x 45°	3	◆
FP61841-100	10	10	45	95	0,18 x 45°	4	◆
FP61841-120	12	12	53	110	0,18 x 45°	4	◆
FP61841-140	14	12	53	110	0,25 x 45°	4	◆
FP61841-160	16	16	63	123	0,25 x 45°	4	◆
FP61841-180	18	16	63	123	0,25 x 45°	4	◆
FP61841-200	20	20	75	141	0,25 x 45°	4	◆
FP61851-220	22	20	75	141	0,36 x 45°	5	◆
FP61851-250	25	25	90	166	0,36 x 45°	5	◆
FP61861-280	28	25	90	166	0,36 x 45°	6	◆
FP61861-300	30	25	90	166	0,36 x 45°	6	◆
FP61861-320	32	32	106	186	0,36 x 45°	6	◆

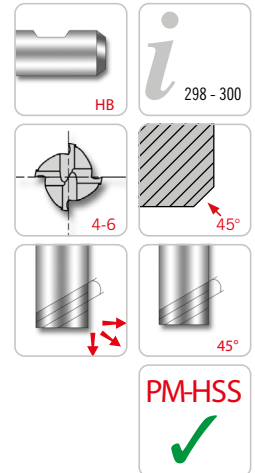
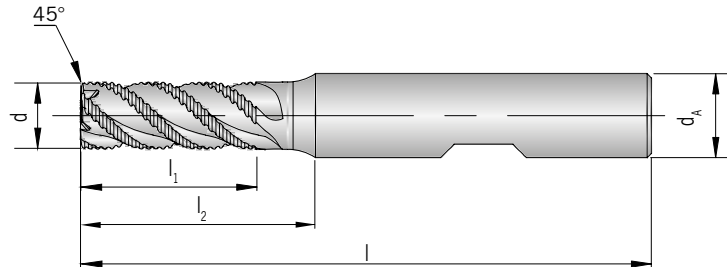
PMC = PM-HSS coated

P	●
M	●
K	●
N	○
S	○
H	○

● Main application
○ Secondary application

FP619.5-...

4 - 6 flutes, extra short design



Shank DIN 6535HB	d <i>js12</i>	d _A <i>h6</i>	l ₁	l ₂	l	Chamfer	z	PMC
								TAIN
FP61945-060	6	6	8	-	52	0,15 x 45°	4	◆
FP61945-080	8	10	11	-	61	0,18 x 45°	4	◆
FP61945-100	10	10	13	23	63	0,20 x 45°	4	◆
FP61945-120	12	12	16	28	73	0,20 x 45°	4	◆
FP61955-140	14	12	16	-	73	0,20 x 45°	5	◆
FP61955-160	16	16	19	31	79	0,20 x 45°	5	◆
FP61965-180	18	16	19	-	79	0,20 x 45°	6	◆
FP61965-200	20	20	22	38	88	0,20 x 45°	6	◆
FP61965-250	25	25	26	46	102	0,20 x 45°	6	◆

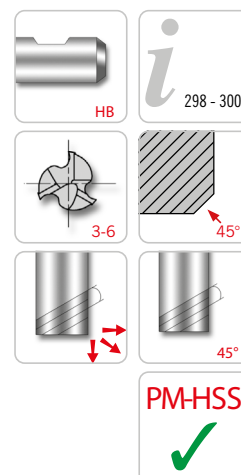
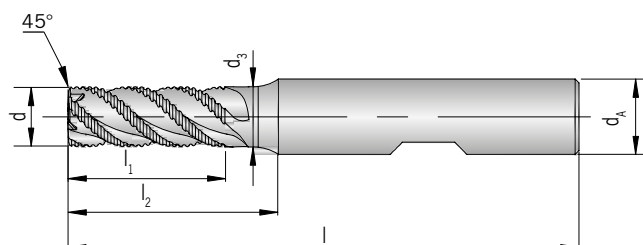
PMC = PM-HSS coated

P	●
M	●
K	●
N	
S	○
H	

● Main application
○ Secondary application

FP619.0-...

3 - 6 flutes, short design



Shank DIN 6535HB	d <i>js12</i>	d _A <i>h6</i>	d ₃	l ₁	l ₂	l	Chamfer	z	PMC
									TAIN
FP61930-040	4	6	-	11	-	57	0,10 x 45°	3	◆
FP61940-050	5	6	-	13	-	57	0,13 x 45°	4	◆
FP61940-060	6	6	-	13	-	57	0,15 x 45°	4	◆
FP61940-070	7	10	-	16	-	66	0,15 x 45°	4	◆
FP61940-080	8	10	-	19	-	69	0,18 x 45°	4	◆
FP61940-090	9	10	-	19	-	69	0,18 x 45°	4	◆
FP61940-100	10	10	9.5	22	31	72	0,20 x 45°	4	◆
FP61940-110	11	12	10.5	22	27	80	0,20 x 45°	4	◆
FP61940-120	12	12	11.5	26	37	83	0,20 x 45°	4	◆
FP61940-130	13	12	-	26	-	84	0,20 x 45°	4	◆
FP61950-140	14	12	-	26	-	83	0,20 x 45°	5	◆
FP61950-150	15	12	-	26	-	85	0,20 x 45°	5	◆
FP61950-160	16	16	15.0	32	44	92	0,20 x 45°	5	◆
FP61960-180	18	16	-	32	-	92	0,20 x 45°	6	◆
FP61960-200	20	20	19.0	38	54	104	0,20 x 45°	6	◆
FP61960-250	25	25	24.0	45	63	121	0,20 x 45°	6	◆

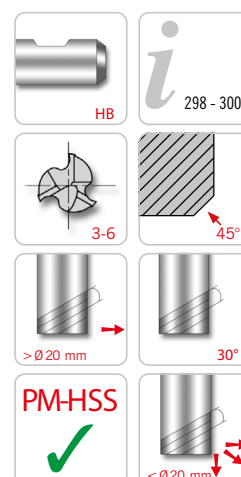
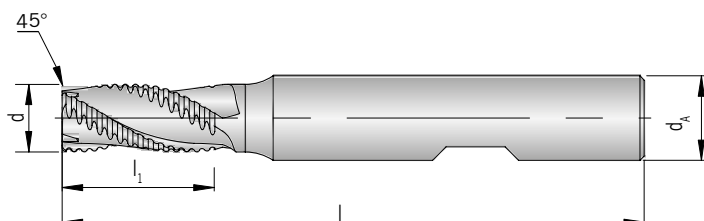
PMC = PM-HSS coated

P	●
M	●
K	●
N	
S	○
H	

● Main application
○ Secondary application

FP620.0-...

3 - 6 flutes, short design



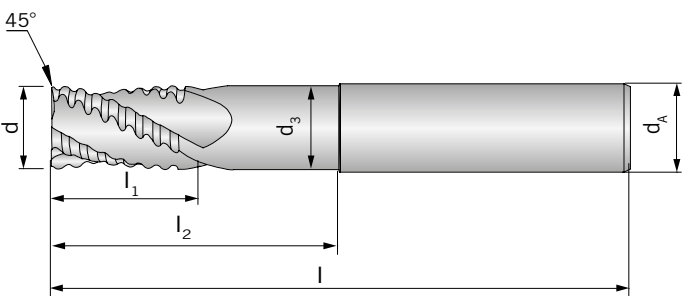
Shank DIN 6535HB	d <i>js12</i>	d _A <i>h6</i>	l ₁	l	Chamfer	z	PMC
							TAIN
FP62030-060	6	6	13	57	0,25 x 45°	3	◆
FP62030-070	7	10	16	66	0,25 x 45°	3	◆
FP62030-080	8	10	19	69	0,25 x 45°	3	◆
FP62030-090	9	10	19	69	0,36 x 45°	3	◆
FP62040-100	10	10	22	72	0,36 x 45°	4	◆
FP62040-120	12	12	26	83	0,50 x 45°	4	◆
FP62040-140	14	12	26	83	0,55 x 45°	4	◆
FP62040-160	16	16	32	92	0,55 x 45°	4	◆
FP62040-180	18	16	32	92	0,55 x 45°	4	◆
FP62040-200	20	20	38	104	0,55 x 45°	4	◆
FP62050-220	22	20	38	104	0,55 x 45°	5	◆
FP62050-250	25	25	45	121	0,55 x 45°	5	◆
FP62060-300	30	25	45	121	0,55 x 45°	6	◆
FP62060-320	32	32	53	133	0,55 x 45°	6	◆

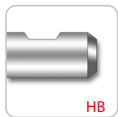
PMC = PM-HSS coated

P	●
M	●
K	●
N	○
S	○
H	○


● Main application
○ Secondary application

FP623.1-...
4 - 5 flutes, extra long design

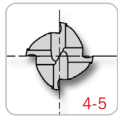




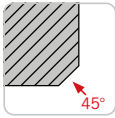
HB



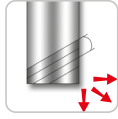
298 - 300



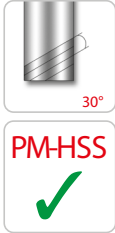
4-5



45°



30°



PM-HSS

Shank DIN 6535HB	d <i>js12</i>	d _A <i>h6</i>	d ₃	l ₁	l ₂	l	Chamfer	z	PMC
									TAIN
FP62341-100	10	10	8.5	22	69	110	0,34 x 45°	4	◆
FP62341-120	12	12	10.5	26	78	125	0,50 x 45°	4	◆
FP62341-160	16	16	14.0	32	87	138	0,55 x 45°	4	◆
FP62341-200	20	20	18.0	38	108	160	0,55 x 45°	4	◆
FP62351-250	25	25	23.0	45	155	216	0,55 x 45°	5	◆

PMC = PM-HSS coated

P

M

K

N

S

H

●

●

●

○

○

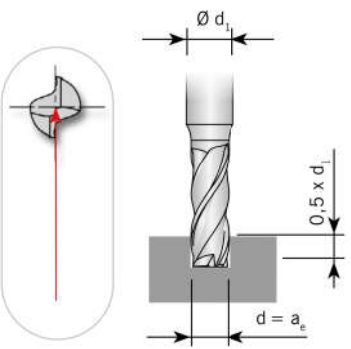
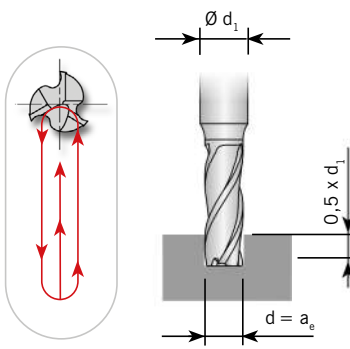
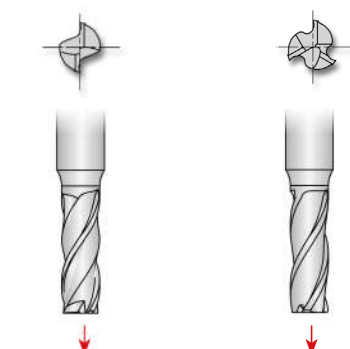
Main application

Secondary application

Material group	Structure of the material groups and identification letters		Brinell hardness HB	Tensile strength Rm (N/mm ²)	Chipping group	Correction factor	Cutting speed V _c (m/min)
							PM-HSS TiAlN
P	Unalloyed steel	C ≤ 0.25 % annealed	125	428	P1	1,2	60 - 73 - 85
		C > 0.25 ... ≤ 0.55 % annealed	190	639	P2	1,2	45 - 53 - 60
		C > 0.25 ... ≤ 0.55 % hardened and tempered	210	708	P3	1,2	45 - 53 - 60
		C > 0.55 % annealed	190	639	P4	1,2	45 - 53 - 60
		C > 0.55 % hardened and tempered	300	1013	P5	1,0	30 - 35 - 40
		Machining steel (short-chipping) tempered	220	745	P6	1,2	50 - 60 - 70
	Low alloyed steel	annealed	175	591	P7	1,2	40 - 50 - 60
		hardened and tempered	300	1013	P8	1,0	40 - 50 - 60
		hardened and tempered	380	1282	P9	0,8	30 - 35 - 40
		hardened and tempered	430	1477	P10	0,8	30 - 35 - 40
	High alloyed steel and high alloyed tool steel	annealed	200	675	P11	1,2	40 - 50 - 60
		hardened	300	1013	P12	1,0	30 - 35 - 40
		hardened	400	1361	P13	0,8	20 - 25 - 30
	Stainless steel	ferritic / martensitic, annealed	200	675	P14	1,0	20 - 25 - 30
		martensitic, hardened and tempered	330	1114	P15		-
M	Stainless steel	austenitic, chilled	200	675	M1	1,0	20 - 25 - 30
		austenitic, precipitation-hardened (PH)	300	1013	M2	0,9	15 - 18 - 20
		austenitic-ferritic, Duplex	230	778	M3	1,0	10 - 13 - 15
K	Malleable cast iron	ferritic	200	675	K1	1,0	30 - 35 - 40
		pearlitic	260	867	K2	0,8	25 - 30 - 35
	Cast iron	low tensile strength	180	602	K3	1,0	35 - 43 - 50
		high tensile strength / austenitic	245	825	K4	1,0	25 - 30 - 35
	Cast iron with nodular graphite	ferritic	155	518	K5	1,0	30 - 35 - 40
		pearlitic	265	885	K6	1,0	30 - 35 - 40
N	GGV (CGI)		200	675	K7	1,0	30 - 35 - 40
	Aluminium alloys long chipping	not heat treatable	30	-	N1		-
		heat treatable, heat treated	100	343	N2		-
	Casted aluminium alloys	≤ 12 % Si, not heat treatable	75	260	N3		-
		≤ 12 % Si, aushärtbar, ausgehärtet	90	314	N4		-
		> 12 % Si, not heat treatable	130	447	N5		-
	Magnesium alloys		70	250	N6		-
	Copper and copper alloys (Brass / Bronze)	Unalloyed, elektrolyte copper	100	343	N7		-
		Brass, Bronze	90	314	N8		-
		Cu-alloys, short-chipping	110	382	N9		-
		High-tensile, Ampco	300	1013	N10		-
	Non-ferrous materials	Lead alloys (without abrasive filling material)	-	-	N11		-
		Duroplastic (without abrasive filling material)	-	-	N12		-
		Plastic glas fibre reinforced GFRP	-	-	N13		-
		Plastic carbon fibre reinforced CFRP	-	-	N14		-
		Plastic aramid fibre reinforced AFRP	-	-	N15		-
		Graphite (tech.)	80 Shore	-	N16		-
S	High temperature resistant alloys	Fe-Basis annealed	200	675	S1		-
			280	943	S2		-
		Ni- or Co-alloyed annealed	250	839	S3	0,9	10 - 13 - 16
			350	1177	S4	0,7	9 - 12 - 14
			320	1076	S5	0,7	9 - 12 - 14
	Titanium alloys	Pure titan	200	675	S6	1,0	20 - 25 - 30
		α- and β-alloys, heat treated	375	1262	S7		-
		β-alloys	410	1396	S8		-
	Wolfram alloys		300	1013	S9	1,1	10 - 15 - 20
	Molybdän alloys		300	1013	S10		-
H	Hardened steel	hardened	50 HRC	-	H1		-
		hardened	55 HRC	-	H2		-
		hardened	60 HRC	-	H3		-
	Hardened cast iron	hardened	55 HRC	-	H4		-

The recommended cutting data are only approximate values. It may be necessary to adjust them to each individual machining application.

Feed per tooth f_z [mm]

Full slot milling (in one cut)		Profile slot milling (internal profile milling)		Circular ramping	
					
coated		coated		coated	coated
d_{l1} [mm]	f_z [mm]	Schruppen / Roughing f_z [mm]	Schlichten / Fine cutting f_z [mm]	f_z [mm]	f_z [mm]
1,5	0,005	0,005	0,007	0,002	0,001
2,0	0,006	0,006	0,009	0,003	0,002
3,0	0,010	0,010	0,016	0,005	0,003
4,0	0,013	0,013	0,024	0,007	0,004
5,0	0,017	0,017	0,033	0,009	0,006
6,0	0,022	0,022	0,043	0,011	0,007
7,0	0,026	0,025	0,051	0,012	0,008
8,0	0,029	0,029	0,061	0,014	0,010
9,0	0,032	0,032	0,071	0,016	0,011
10,0	0,037	0,037	0,082	0,019	0,012
12,0	0,044	0,044	0,101	0,022	0,015
14,0	0,054	0,054	0,118	0,027	0,018
16,0	0,062	0,062	0,135	0,031	0,021
18,0	0,072	0,072	0,151	0,036	0,024
20,0	0,078	0,078	0,167	0,039	0,026
22,0	0,088	0,088	0,184	0,044	0,029
25,0	0,098	0,098	0,208	0,049	0,033
28,0	0,108	0,108	0,217	0,052	0,039
30,0	0,120	0,120	0,230	0,060	0,041
32,0	0,135	0,135	0,251	0,071	0,048
40,0	0,150	0,150	0,260	0,070	0,050

Attention: For optimal results it is recommended to climb mill.

General rule:
Feed per tooth = $f_z \cdot K_f (f_z)$
For axial plunge milling: = Table value/Number of teeth

Feed per tooth f_z [mm]

Fine cutting				Roughing			
coated				coated			
d_1 [mm]	Schlichtgeometrie / Geometry for peripheral milling			Schruppgeometrie / Geometry for roughing			
	f_z [mm]	f_z [mm]	f_z [mm]	f_z [mm]	f_z [mm]	f_z [mm]	
1,0	0,005	0,005	0,005	0,005	0,005	0,005	
1,5	0,007	0,007	0,007	0,007	0,007	0,007	
2,0	0,009	0,009	0,009	0,010	0,010	0,008	
3,0	0,012	0,012	0,010	0,013	0,012	0,010	
4,0	0,018	0,015	0,014	0,016	0,014	0,012	
5,0	0,026	0,020	0,015	0,021	0,018	0,016	
6,0	0,035	0,024	0,017	0,027	0,022	0,019	
7,0	0,045	0,028	0,021	0,031	0,027	0,022	
8,0	0,051	0,032	0,022	0,036	0,030	0,026	
9,0	0,061	0,036	0,025	0,052	0,034	0,031	
10,0	0,072	0,041	0,028	0,047	0,039	0,034	
12,0	0,091	0,049	0,034	0,057	0,047	0,041	
14,0	0,106	0,059	0,041	0,069	0,058	0,050	
16,0	0,121	0,067	0,046	0,079	0,066	0,057	
18,0	0,136	0,077	0,053	0,093	0,078	0,067	
20,0	0,151	0,083	0,057	0,101	0,084	0,073	
22,0	0,166	0,094	0,065	0,114	0,096	0,082	
25,0	0,188	0,104	0,072	0,129	0,108	0,093	
28,0	0,210	0,120	0,083	0,150	0,125	0,108	
30,0	0,225	0,127	0,088	0,161	0,135	0,116	
32,0	0,240	0,137	0,094	0,173	0,145	0,125	
40,0	0,240	0,170	0,120	0,200	0,160	0,140	

Attention: For optimal results it is recommended to climb mill.

General rule:

Feed per tooth = $f_z \cdot K_f$ (f_z)

For axial plunge milling: = Table value/Number of teeth