

When stepdown milling is performed by use of passes, the depth of cut per pass should not exceed the depth of cut as recommended in the ISCAR catalog.

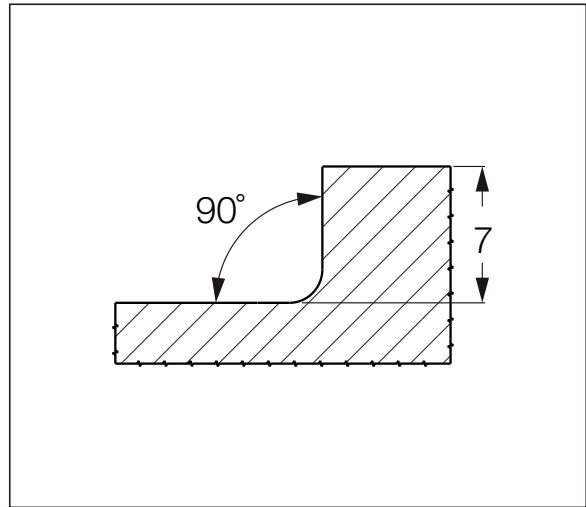


Fig. 1- Generated profile for a depth of cut of up to 7mm

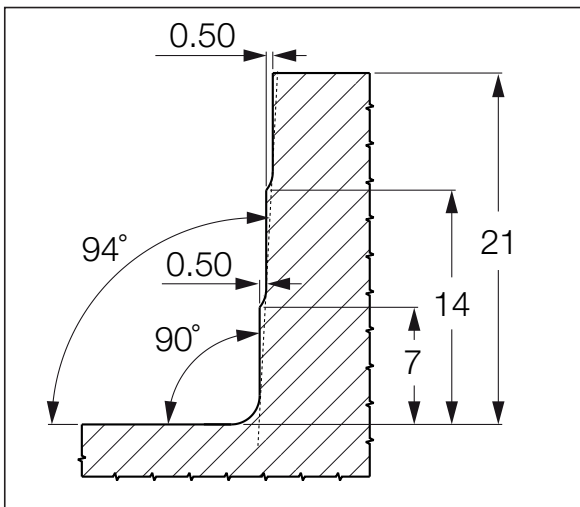


Fig. 2- Generated profile for a depth of cut in stepdown milling

Starting feed per tooth F_z for S890 face mills with inserts S890 SZMU 10...

Workpiece Material						F_z , mm/Tooth for Grades*				
ISO Class DIN/ISO 513	Description	Typical Representative		Hardness, HB	ISCAR Mat. Group**	IC 5100	IC810	IC808	IC845	IC5400
P	non-alloy steel	AISI/SAE/ASTM	DIN W.-Nr.							
		1020	1.044	130-180	1			0.1-0.25	0.1-0.25	0.1-0.25
	alloy steel	4340	1.658	260-300	8			0.1-0.2	0.1-0.2	0.1-0.2
		4340	1.658	HRC 35-42*	9			0.1-0.2	0.1-0.2	0.1-0.2
	high alloy steel	H13	1.234	200-220	10			0.08-0.15	0.08-0.15	0.08-0.15
M	martensitic S.S.	420	1.402	200	12			0.08-0.15	0.08-0.15	0.08-0.15
		304L	1.431	200	14			0.1-0.15	0.1-0.15	0.1-0.15
	austenitic S.S.	316L	1.440	140	14			0.1-0.15	0.1-0.15	0.1-0.15
K	grey cast iron	class 40	0.6025 (GG25)	250	16	0.15-0.25	0.15-0.25			
	nodular cast iron	class 65-45-12	0.7050 (GGG50)	200	17	0.12-0.2	0.12-0.2			
H	hard steel and cast iron	H11	1.234	HRC 45-49	38.1			0.06-0.12	0.06-0.12	0.06-0.12
		P20	1.2330	HRC 50-55	38.2			0.05-0.1	0.05-0.1	0.05-0.1

* Quenched and tempered

** ISCAR material group in accordance with VDI 3323 standard