## Recommended Feeds

### HER Feeds $f_z$ (mm/tooth) - Slotting / Pocketing

| D | Unalloyed Steel <600 N/mm² <180 HBN | Unalloyed Steel 700-950N/mm² 200-280 HBN | Alloyed Steel <600 N/mm² <180 HBN | Alloyed Steel 950-1200N/mm² 280-355 HBN | Alloyed Steel 1200-1400N/mm² 355-415 HBN | Stainless Steel Austenitic + Ferretic 300 Series | Stainless Steel Martensitic 400 Series | Stainless Steel Refractory PH | Cast Irons Grey GG-FT | Cast Irons Spheroidal- Ductile GGG-FGS | Cast Irons Malleable GTS -MN/MP | Aluminium & Alloys <16% Si 116 HBN | Aluminium & Silicon >16% Si 92 HBN | HTA Iron Based Alloys | HTA Cobalt Based Alloys | HTA Nickel Based Alloys | HTA Titanium Based Alloys | Hard Steel >1400 N/mm² >415 HBN | Chilled Cast Iron >1400 N/mm² >400 HBN |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Range | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. | Min. - Max. |
| 2,0 | - | - | 0,005<br>0,007 | 0,005<br>0,007 | 0,005<br>0,007 | - | - | - | 0,005<br>0,007 | 0,005<br>0,007 | 0,005<br>0,007 | - | - | - | - | - | - | 0,003<br>0,005 | 0,003<br>0,005 |
| 3,0 | - | - | 0,008<br>0,012 | 0,008<br>0,012 | 0,007<br>0,011 | - | - | - | 0,008<br>0,012 | 0,008<br>0,012 | 0,008<br>0,011 | - | - | - | - | - | - | 0,005<br>0,008 | 0,005<br>0,008 |
| 4,0 | - | - | 0,010<br>0,017 | 0,010<br>0,016 | 0,009<br>0,015 | - | - | - | 0,010<br>0,017 | 0,010<br>0,016 | 0,010<br>0,015 | - | - | - | - | - | - | 0,006<br>0,011 | 0,006<br>0,011 |
| 5,0 | - | - | 0,013<br>0,023 | 0,013<br>0,021 | 0,011<br>0,020 | - | - | - | 0,013<br>0,023 | 0,013<br>0,021 | 0,013<br>0,020 | - | - | - | - | - | - | 0,008<br>0,015 | 0,008<br>0,015 |
| 6,0 | - | - | 0,015<br>0,029 | 0,015<br>0,026 | 0,013<br>0,024 | - | - | - | 0,015<br>0,029 | 0,015<br>0,026 | 0,015<br>0,024 | - | - | - | - | - | - | 0,009<br>0,019 | 0,009<br>0,018 |
| 8,0 | - | - | 0,020<br>0,042 | 0,020<br>0,037 | 0,017<br>0,033 | - | - | - | 0,020<br>0,042 | 0,020<br>0,037 | 0,020<br>0,033 | - | - | - | - | - | - | 0,012<br>0,026 | 0,012<br>0,025 |
| 10,0 | - | - | 0,025<br>0,057 | 0,025<br>0,048 | 0,021<br>0,042 | - | - | - | 0,025<br>0,057 | 0,025<br>0,048 | 0,025<br>0,042 | - | - | - | - | - | - | 0,015<br>0,034 | 0,015<br>0,032 |
| 12,0 | - | - | 0,030<br>0,072 | 0,030<br>0,060 | 0,025<br>0,051 | - | - | - | 0,030<br>0,072 | 0,030<br>0,060 | 0,030<br>0,051 | - | - | - | - | - | - | 0,018<br>0,043 | 0,018<br>0,039 |
| 16,0 | - | - | 0,040<br>0,104 | 0,040<br>0,085 | 0,032<br>0,070 | - | - | - | 0,040<br>0,104 | 0,040<br>0,085 | 0,040<br>0,070 | - | - | - | - | - | - | 0,024<br>0,061 | 0,024<br>0,055 |

Note: HTA = High Temperature Alloys

| Shoulder Milling / Profiling | Feed Correction Parameters | |
|---|---|---|
| | $a_e$ | Correction Factor |
|  | 0,01 | 5,00 x $f_z$ |
| | 0,03 | 2,90 x $f_z$ |
| | 0,05 | 2,25 x $f_z$ |
| | 0,08 | 1,85 x $f_z$ |

For $a_e$ less than $a_e$ max, use correction factors stated above.
For $a_e$ max, use feeds stated above.