



Tips & Parameters

Super6 insert WFM-34R100

For tightening the insert screw please always use a torque driver with 4.5 Nm. We recommend our driver DNTV00S with Torx 15 bit DS-T15TB.

The insert enables a max. cutting depth of $a_p = 7$ mm.



Recommended Cutting Data:

ISO	material	cutting parameters	IN2005	IN2015
P	unalloyed steel <900 N/mm ²	cutting speed Vc [m/min]	150-250	120-200
		feed per tooth fz [mm]	0.12-0.30	0.12-0.30
	alloyed steel 900-1100 N/mm ²	cutting speed Vc [m/min]	120-180	90-150
		feed per tooth fz [mm]	0.12-0.25	0.12-0.25
	alloyed steel 1100-1400 N/mm ²	cutting speed Vc [m/min]	100-180	80-160
		feed per tooth fz [mm]	0.12-0.20	0.12-0.20
M	stainless steel	cutting speed Vc [m/min]	100-180	80-160
		feed per tooth fz [mm]	0.12-0.25	0.12-0.25
K	cast materials	cutting speed Vc [m/min]	180-250	150-250
		feed per tooth fz [mm]	0.12-0.35	0.12-0.35