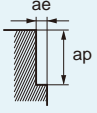


## Recommended Cutting Conditions

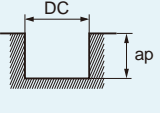
# CE4SRB

### Side milling

Work material	Inconel			
DC (mm)	Vc (m/min)	fz (mm)	ap (mm)	ae (mm)
6	>350	<0.06	<4.5	<1.2
8	>350	<0.06	<6.0	<1.6
10	>350	<0.06	<7.5	<2.0
12	>350	<0.06	<9.0	<2.4
Depth of cut				

NOTE: DO NOT USE ON TITANIUM ALLOYS

### Slotting

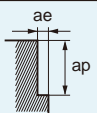
Work material	Inconel		
DC (mm)	Vc (m/min)	fz (mm)	ap (mm)
6	>350	<0.03	<1.5
8	>350	<0.03	<1.5
10	>350	<0.03	<2.0
12	>350	<0.03	<2.5
Depth of cut			

NOTE: DO NOT USE ON TITANIUM ALLOYS

\*Under 0.3 x D

# CE6SRB

### Side milling

Work material	Inconel			
DC (mm)	Vc (m/min)	fz (mm)	ap (mm)	ae (mm)
6	>350	<0.06	<4.5	<1.2
8	>350	<0.06	<6.0	<1.6
10	>350	<0.06	<7.5	<2.0
12	>350	<0.06	<9.0	<2.4
Depth of cut				

NOTE: DO NOT USE ON TITANIUM ALLOYS

- 1) The outermost layer of the material may be affected by heat. Ensure a minimum of 0.3 mm final machining allowance remains.
- 2) The recommended ramping angle is 1.5°. For ramping it is recommended to reduce the feed by 50%.
- 3) Gradually increase the width of cut (ae) starting from 0.05 x DC.