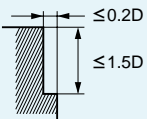
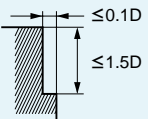


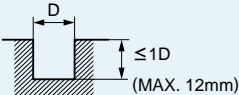
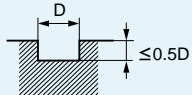
RECOMMENDED CUTTING CONDITIONS

Shoulder milling

| Work material | Carbon steel, Cast iron, Alloy steel (–30HRC) Cf53, GG25 | | Alloy steel, Tool steel, Pre-hardened steel (–45HRC) | | Stainless steel (–1100N/mm ²) | |
|---------------|---|---------------------------------|--|---------------------------------|---|---------------------------------|
| | Dia. (mm) | Revolution (min ⁻¹) | Feed rate (mm/min) | Revolution (min ⁻¹) | Feed rate (mm/min) | Revolution (min ⁻¹) |
| 6 | 9000 | 2240 | 8000 | 2240 | 5300 | 1060 |
| 8 | 7000 | 1680 | 6000 | 1680 | 4000 | 960 |
| 10 | 5000 | 1440 | 4800 | 1440 | 3200 | 770 |
| 12 | 4000 | 1200 | 4000 | 1200 | 2700 | 760 |
| 16 | 3000 | 1140 | 3000 | 1140 | 2000 | 560 |
| 20 | 2400 | 860 | 2400 | 860 | 1600 | 510 |
| Depth of cut |  | | | |  | |

D:Dia.

Slot milling

| Work material | Carbon steel, Cast iron, Alloy steel (–30HRC) Cf53, GG25 | | Alloy steel, Tool steel, Pre-hardened steel (–45HRC) | | Stainless steel (–1100N/mm ²) | |
|---------------|---|---------------------------------|--|---------------------------------|---|---------------------------------|
| | Dia. (mm) | Revolution (min ⁻¹) | Feed rate (mm/min) | Revolution (min ⁻¹) | Feed rate (mm/min) | Revolution (min ⁻¹) |
| 6 | 6500 | 1280 | 4000 | 740 | 3700 | 440 |
| 8 | 5000 | 1150 | 3000 | 670 | 2800 | 340 |
| 10 | 4000 | 910 | 2500 | 530 | 2200 | 350 |
| 12 | 3500 | 900 | 2000 | 530 | 1900 | 300 |
| 16 | 2500 | 670 | 1500 | 390 | 1400 | 280 |
| 20 | 2000 | 610 | 1200 | 350 | 1100 | 260 |
| Depth of cut |  | | | |  | |

D:Dia.

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) Air blow or oil mist is recommended for good chip evacuation.
- 3) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abnormal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.