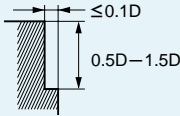
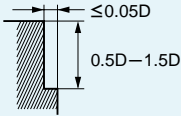


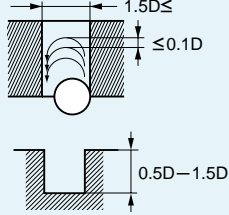
RECOMMENDED CUTTING CONDITIONS

Shoulder milling

Work material	Austenitic stainless steel, Titanium alloy X5CrNi1810, X5CrNiMo17-12-2, Ti6Al4V		Heat resistant alloys Inconel718		
	Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
10	4800	2000	1300	260	
12	4000	2000	1100	230	
16	3000	1600	800	180	
20	2400	1400	640	150	
Depth of cut					

D:Dia.

Trochoid milling

Work material	Austenitic stainless steel, Titanium alloy X5CrNi1810, X5CrNiMo17-12-2		
	Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
10	4800	1400	
12	4000	1200	
16	3000	1100	
20	2400	900	
Depth of cut			

D:Dia.

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) 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.