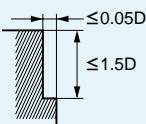
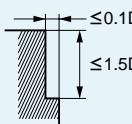


RECOMMENDED CUTTING CONDITIONS

Shoulder milling

Work material	Alloy steel, Tool steel, Pre-hardened steel X40CrMoV51		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)	Revolution (min ⁻¹)	Feed rate (mm/min)
6	10600	2900	8000	2000	2100	320	
8	8000	2900	6000	2000	1600	300	
10	6400	2700	4800	2000	1300	260	
12	5300	2700	4000	2000	1100	230	
16	4000	2200	3000	1600	800	180	
20	3200	1900	2400	1400	640	150	

Depth of cut



D:Dia.

- 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
- 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 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.