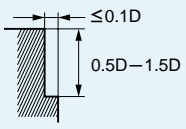
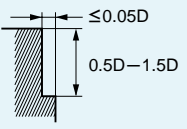


RECOMMENDED CUTTING CONDITIONS

Shoulder milling

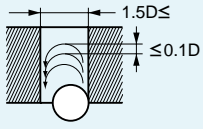
Dia. (mm)	Austenitic stainless steel, Titanium alloy X5CrNi1810, X5CrNiMo17-12-2, Ti6Al4V		Heat resistant alloys Inconel718	
	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
10	4800	2000	1300	260
12	4000	2000	1100	230
16	3000	1600	800	180
20	2400	1400	640	150

Depth of cut	Austenitic stainless steel, Titanium alloy X5CrNi1810, X5CrNiMo17-12-2, Ti6Al4V		Heat resistant alloys Inconel718	
	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
				

D: Dia.

Trochoid milling

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

Depth of cut	Austenitic stainless steel, Titanium alloy X5CrNi1810, X5CrNiMo17-12-2	
	Revolution (min ⁻¹)	Feed rate (mm/min)
		

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.