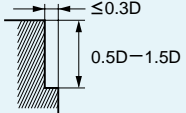
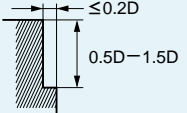


RECOMMENDED CUTTING CONDITIONS

Shoulder milling

Work material	Austenitic stainless steel, Titanium alloy		Heat resistant alloys	
	X5CrNi1810, X5CrNiMo17-12-2, Ti6Al4V		Inconel718	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
16	2400	1200	800	160
20	2000	1000	640	140
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.