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)
16	3000	2100	800	240
20	2400	1900	640	200
Depth of cut	≤0.08D 0.5D—1.5D		≤0.05D 0.5D—1.5D	

D:Dia.

Trochoid milling

Work material	Austenitic stainless steel, Titanium alloy X5CrNi18-10, X5CrNiMo17-12-2	
Dia. (mm)	Revolution (min^{-1})	Feed rate (mm/min)
16	3000	1400
20	2400	1200
Depth of cut	1.5D≤ ≤0.08D 0.5D—1.5D	

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 abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.