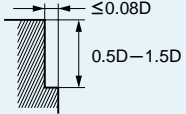
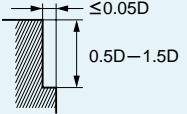


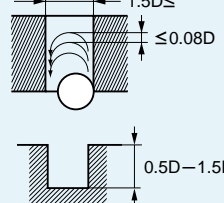
## RECOMMENDED CUTTING CONDITIONS

### Shoulder milling

Work material	Austenitic stainless steel, Titanium alloy X5CrNi1810, X5CrNiMo17-12-2, Ti6Al4V		Heat resistant alloys Inconel718	
	Dia. (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Revolution (min <sup>-1</sup> )
Depth of cut	16	3000	2100	800
	20	2400	1900	640
				

D: Dia.

### Trochoid milling

Work material	Austenitic stainless steel, Titanium alloy X5CrNi18-10, X5CrNiMo17-12-2	
	Dia. (mm)	Revolution (min <sup>-1</sup> )
Depth of cut	16	3000
	20	2400
		

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.