

RECOMMENDED CUTTING CONDITIONS

Shoulder milling

Work material	Carbon steel, Cast iron, Alloy steel (–30HRC)		Alloy steel, Tool steel, Pre-hardened steel		Austenitic stainless steel, Titanium alloy		Hardened steel (45–55HRC)		Heat resistant alloys	
	Cf53, GG25		X40CrMoV51		X5CrNi1810, X5CrNiMo17-12-2, Ti6Al4V		X40CrMoV51		Inconel718	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
2	21000	1100	21000	1100	14000	560	9600	310	4800	130
3	15000	1250	15000	1250	10600	850	7400	380	4200	200
4	11000	1400	11000	1400	8000	960	5600	400	3200	220
5	9600	1920	9600	1920	6400	1020	4500	430	2500	250
6	8000	2240	8000	2240	5300	1060	3700	440	2100	250
7	6800	1900	6800	1900	4500	1010	3200	450	1800	260
8	6000	1680	6000	1680	4000	960	2800	450	1600	260
9	5300	1480	5300	1480	3500	840	2500	450	1400	220
10	4800	1440	4800	1440	3200	770	2200	440	1300	210
11	4400	1350	4400	1350	2900	760	2000	400	1200	190
12	4000	1250	4000	1250	2700	760	1900	380	1100	180
13	3700	1180	3700	1180	2500	700	1700	360	1000	160
14	3400	1160	3400	1160	2300	640	1600	350	900	140
16	3000	1140	3000	1140	2000	560	1400	340	800	130
18	2700	970	2700	970	1800	550	1200	340	700	110
20	2400	860	2400	860	1600	510	1100	330	600	100

Depth of cut	≤0.2D ≤1.5D		≤0.1D ≤1.5D		≤0.05D ≤1.5D	

D:Dia.

Slotting

Work material	Carbon steel, Cast iron, Alloy steel (–30HRC)		Alloy steel, Tool steel, Pre-hardened steel		Austenitic stainless steel, Titanium alloy		Hardened steel (45–55HRC)		Heat resistant alloys	
	Cf53, GG25		X40CrMoV51		X5CrNi1810, X5CrNiMo17-12-2, Ti6Al4V		X40CrMoV51		Inconel718	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
2	17000	680	10000	400	9600	310	4800	130	3200	80
3	12000	720	6900	410	7400	380	3200	140	2700	110
4	9200	810	5600	490	5600	400	2400	150	2000	120
5	7600	1060	4500	630	4500	410	1900	170	1600	130
6	6400	1280	3700	740	3700	440	1600	190	1300	160
7	5500	1210	3200	700	3200	410	1400	190	1100	140
8	4800	1150	2800	670	2800	390	1200	190	1000	130
9	4200	1010	2500	600	2500	350	1100	180	900	130
10	3800	910	2200	530	2200	350	1000	160	800	130
11	3500	900	2000	530	2000	320	900	160	720	120
12	3200	900	1900	530	1900	300	800	160	660	110
13	2900	810	1700	480	1700	290	730	150	610	100
14	2700	760	1600	450	1600	290	680	140	570	90
16	2400	670	1400	390	1400	280	600	120	500	80
18	2100	670	1200	380	1200	270	530	120	440	70
20	1900	610	1100	350	1100	260	480	120	400	60

Depth of cut	D ≤1D (MAX. 12mm)		D ≤0.5D		D ≤0.2D	

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.