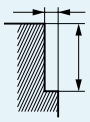
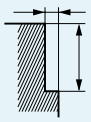
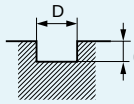
RECOMMENDED CUTTING CONDITIONS

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	2000	560	800	110
20	1600	510	600	100
Depth of cut				

D:Dia.

Slotting

Work material	Austenitic stainless steel, Titanium alloy X5CrNi1810, X5CrNiMo17-12-2, Ti6Al4V	
Dia. (mm)	Revolution (min^{-1})	Feed rate (mm/min)
16	1400	170
20	1100	130
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 abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.