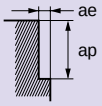
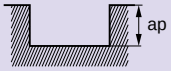
RECOMMENDED CUTTING CONDITIONS

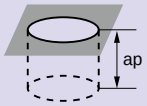
Side milling

Work material	Aluminium alloy					
Dia. (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/tooth)	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
10	500	16000	0.117	5600	8	3
12	500	13000	0.118	4600	9.6	3.6
16	500	10000	0.153	4600	12.8	4.8
20	500	8000	0.175	4200	16	6
25	500	6000	0.211	3800	20	7.5
Depth of cut						

Slotting

Work material	Aluminium alloy				
Dia. (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/tooth)	Feed rate (mm/min)	Depth of cut ap (mm)
10	500	16000	0.068	3300	5
12	500	13000	0.072	2800	6
16	500	10000	0.093	2800	8
20	500	8000	0.108	2600	10
25	500	6000	0.127	2300	12.5
Depth of cut					

Plunging

Work material	Aluminium alloy					
Dia. (mm)	Cutting speed (m/min)	Revolution (min^{-1})	Feed (mm/rev)	Feed rate (mm/min)	Depth of cut ap (mm)	Step ap (mm)
10	300	9600	0.1	960	5	2.5
12	300	8000	0.1	800	6	2.5
16	300	6000	0.1	600	8	2.5
20	300	4800	0.1	480	10	2.5
25	300	3800	0.1	380	12.5	2.5
Depth of cut						

1) The use of water-soluble coolant is recommended.
2) Vibration may occur if the rigidity of machine or workpiece is low.
   In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.