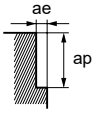


RECOMMENDED CUTTING CONDITIONS

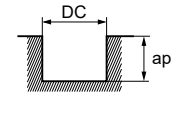
■ Side milling

S				
Work material	Inconel			
Dia. DC (mm)	Cutting speed (m/min)	Feed per tooth (mm/t)	Depth of cut ap (mm)	Depth of cut ae (mm)
6	≥ 350	≤ 0.06	≤ 4.5	≤ 1.2
8	≥ 350	≤ 0.06	≤ 6.0	≤ 1.6
10	≥ 350	≤ 0.06	≤ 7.5	≤ 2.0
12	≥ 350	≤ 0.06	≤ 9.0	≤ 2.4

Depth of cut				
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■ Slotting

S			
Work material	Inconel		
Dia. DC (mm)	Cutting speed (m/min)	Feed per tooth (mm/t)	Depth of cut ap (mm)
6	≥ 350	≤ 0.03	≤ 1.5
8	≥ 350	≤ 0.03	≤ 1.5
10	≥ 350	≤ 0.03	≤ 2.0
12	≥ 350	≤ 0.03	≤ 2.5

Depth of cut			
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- Note 1) The outermost layer of the material may be affected by heat. Ensure a minimum of 0.3 mm final machining allowance remains.
- Note 2) The recommended ramping angle is 1.5°. For ramping it is recommended to reduce the feed by 50%.
- Note 3) Gradually increase the width of cut (ae) starting from 0.05 x DC.