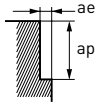
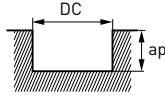


RECOMMENDED CUTTING CONDITIONS

SHOULDER MILLING

		S				
Material	Titanium Alloys Ti-6Al-4V etc.					
		Overhang Length DC×3				
DC	Vc (m/min)	n (min ⁻¹)	Vf (mm/min)	ap (mm)	ae (mm)	
16	70	1400	700	32	2.4	
20	70	1100	550	40	3	
25	70	890	440	50	3.8	
Depth of Cut					DC=Dia.	

SLOT MILLING

		S							
Material	Titanium Alloys Ti-6Al-4V etc.								
		Depth of Cut DC×1				Depth of Cut DC×2			
DC	Vc (m/min)	n (min ⁻¹)	Vf (mm/min)	ap (mm)	Vc (m/min)	n (min ⁻¹)	Vf (mm/min)	ap (mm)	
16	60	1200	420	16	60	1200	240	32	
20	60	950	330	20	60	950	190	40	
25	50	640	220	25	50	640	130	50	
Depth of Cut									DC=Dia.

1. SMART MIRACLE coating has very low electrical conductivity; therefore, an external contact type of tool setter (electric transmitted) may not work. When measuring the tool length, please use a contact type (non-electrical) or a laser tool setter.
2. When cutting titanium alloys, the use of water-soluble cutting fluid is effective.
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 work material installation is poor, vibration or abnormal sound can occur.
In this case, please reduce the speed and feed rate proportionately, or set a lower depth of cut.
4. If the depth of cut is smaller, the speed and feed rate can be increased.
5. For slot milling, use a chuck with a high clamping force.