Recommended Cutting Conditions

(inch)

	Workpiece Material	Cutting Width **ae**	Cutting Speed **vc** (SFM)	Feed per Tooth **fz** (IPT)
S	Ti Alloys Ti-6Al-4V,Ti-6Al-4V-ELI Ti-10V-2Fe-3Al Ti-5Al-5V-5Mo-3Cr etc.	ae≤0.5DC	195(165－260)	.005(.004－.006)
		0.5DC< ae< 0.8DC	165(130－195)	.004(.003－.005)
		ae≥0.8DC	130(165－195)	.003(.002－.004)

Note 1) The cutting performance depends on machine and clamping rigidity, as well as the supply and pressure of the coolant. Adjust as necessary.

Note 2) Use a machine and spindle size suitable for heavy machining of titanium alloys. (7/24 taper #50 or #60, or high-rigidity HSK-A100 or A125, with an output of 20.1 HP/bhp or higher and torque of 4425 lbf-in or higher for a rotation speed of 500min-1 or less).

Note 3) If chatter and vibration or machine overloading occur, it is recommended to reduce the depth of cut ap.

Note 4) The coolant system combines internal and external lubrication, it is recommended to supply coolant in ample quantities.

Note 5) A gradual roll feed into the workpiece and use of down cutting (climb milling) is recommended. (refer to page 6)

Note 6) For RE>.126, machining of cutter body radius is recommended. (refer to page 7)