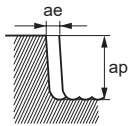


## Recommended Cutting Conditions


### Side Milling

(inch)

Workpiece Material		Aluminum Alloys			
RE		Revolution (min <sup>-1</sup> )	Feed Rate (IPM)	Depth of Cut ap	Depth of Cut ae
(mm)	(inch)				
<b>0.5</b>	<b>.020</b>	20000	78.7	.591	.030
<b>1.0</b>	<b>.039</b>	20000	157.5	.591	.059
<b>1.5</b>	<b>.059</b>	20000	204.7	.591	.089
<b>2.0</b>	<b>.079</b>	20000	204.7	.906	.118
Depth of Cut					

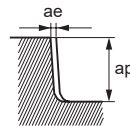
### Slotting

(inch)

Workpiece Material		Aluminum Alloys		
RE		Revolution (min <sup>-1</sup> )	Feed Rate (IPM)	Depth of Cut ap
(mm)	(inch)			
<b>0.5</b>	<b>.020</b>	20000	23.6	.394
<b>1.0</b>	<b>.039</b>	20000	110.2	.394
<b>1.5</b>	<b>.059</b>	20000	157.5	.394
<b>2.0</b>	<b>.079</b>	20000	157.5	.591
Depth of Cut				

### Side Milling (Finishing)

(inch)

Workpiece Material		Aluminum Alloys			
RE		Revolution (min <sup>-1</sup> )	Feed Rate (IPM)	Depth of Cut ap	Depth of Cut ae
(mm)	(inch)				
<b>0.5</b>	<b>.020</b>	20000	31.5	.709	.004
<b>1.0</b>	<b>.039</b>	20000	78.7	.709	.008
<b>1.5</b>	<b>.059</b>	20000	94.5	.709	.012
<b>2.0</b>	<b>.079</b>	20000	94.5	1.063	.012
Depth of Cut					



Case Examples for Non-standard Shapes

Note 1) Water-soluble cutting fluid is recommended.

Note 2) Climb cutting is recommended for side milling.

Note 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately, or set the depth of cut smaller.