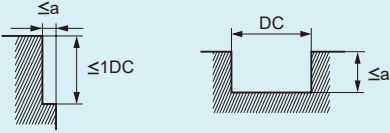


RECOMMENDED CUTTING CONDITIONS

Work material	Alloy steel, Tool steel, Pre-hardened steel				Hardened steel (45—55HRC)				Hardened steel (55—62HRC)			
	AISI H13, AISI W1—10, AISI P21 etc.				AISI H13 etc.				AISI D2 etc.			
DC (mm)	Revolution (min ⁻¹)	Table feed		Depth of cut a (mm)	Revolution (min ⁻¹)	Table feed		Depth of cut a (mm)	Revolution (min ⁻¹)	Table feed		Depth of cut a (mm)
		(mm/min)	(IPM)			(mm/min)	(IPM)			(mm/min)	(IPM)	
6	10000	2100	82.7	0.60	7000	1400	55.1	0.30	2700	320	12.6	0.20
8	8000	1500	59.1	0.80	5600	1100	43.3	0.40	2000	240	9.4	0.20
10	6400	1400	55.1	1.00	4500	950	37.4	0.50	1600	210	8.3	0.30
12	5400	1200	47.2	1.00	3800	860	33.9	0.50	1300	160	6.3	0.30
16	2400	550	21.7	3.00	1200	280	11.0	0.80	1000	130	5.1	0.30
20	1900	480	18.9	4.00	1000	240	9.4	1.00	800	100	3.9	0.30
Depth of cut												

- 1) When slotting, reduce the revolutions by 50 - 70% and the feed rate by 40 - 60%.
- 2) For austenitic stainless steels, titanium and heat-resistant alloys, VFMHV is recommended.
- 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is very low, then vibration can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.