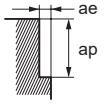
Recommended Cutting Conditions

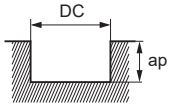
■Side milling

(inch)

Workpiece Material			Nickel-based Heat Resistant Super Alloy Inconel718, Inconel713C, WASPALOY etc.			
DC		Number of Flutes	Revolution (SFM)	Feed Rate (IPM)	Depth of Cut ap	Depth of Cut ae
(mm)	(inch)					
3	**.118**	**4**	4200	13.4	.177	.012
4	**.157**	**4**	3200	10.2	.236	.016
5	**.197**	**4**	2500	11.8	.295	.020
6	**.236**	**4**	2100	9.8	.354	.024
8	**.315**	**6**	1600	11.4	.472	.031
10	**.394**	**6**	1300	12.2	.591	.039
12	**.472**	**6**	1100	10.2	.709	.047
Depth of cut						

■Slot milling

(inch)

Workpiece Material			Nickel-based Heat Resistant Super Alloy Inconel718, Inconel713C, WASPALOY etc.		
DC		Number of Flutes	Revolution (SFM)	Feed Rate (IPM)	Depth of Cut ap
(mm)	(inch)				
3	**.118**	**4**	3200	10.2	.059
4	**.157**	**4**	2400	7.5	.079
5	**.197**	**4**	1900	9.1	.098
6	**.236**	**4**	1600	7.5	.118
8	**.315**	**6**	1200	5.5	.157
10	**.394**	**6**	1000	4.7	.197
12	**.472**	**6**	800	5.5	.236
Depth of cut					

Note 1) For heat resistant super alloy, the use of water-soluble coolant is effective.
Note 2) Chattering can still occur if the machine rigidity and clamping method are insufficient.
In these cases the feed and speed should be reduced proportionately.
Note 3) If the depth of cut is shallow, the revolution and feed rate can be increased.