

Recommended Cutting Conditions

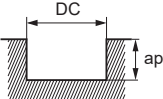
Side milling

(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 a_p	Depth of Cut a_e
(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 a_p
(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.