

Identification(Shoulder Milling)

Reduce the cutting parameters by the coefficient values shown according to the length of overhang.
For long edge and oversize types heads refer to their specific recommended conditions.

(inch)

L/D	Revolution n (min ⁻¹)	Feed per Tooth fz (IPT)	Width of Cut ae	Revolution n (min ⁻¹)	Feed per Tooth fz (IPT)	Width of Cut ae	Revolution n (min ⁻¹)	Feed per Tooth fz (IPT)	Width of Cut ae
	2	3	4	5	6	7	8	9	
2	100%	100%	100%	100%	100%	100%	100%	100%	100%
3	100%	100%	100%	100%	100%	100%	100%	100%	100%
4	80%	90%	70%	80%	90%	70%	80%	90%	70%
5	60%	80%	40%	60%	80%	40%	60%	80%	40%
6	50%	70%	30%	50%	70%	30%	50%	70%	30%
7	40%	70%	20%	40%	70%	20%	30%	60%	20%
8	40%	60%	10%	40%	60%	10%	30%	50%	10%
9	30%	60%	10%	30%	60%	10%	20%	50%	10%

L/D	Revolution n (min ⁻¹)	Feed per Tooth fz (IPT)	Width of Cut ae	Revolution n (min ⁻¹)	Feed per Tooth fz (IPT)	Width of Cut ae
	2	3	4	5	6	7
2	100%	100%	100%	100%	100%	100%
3	100%	100%	100%	100%	100%	100%
4	80%	90%	70%	80%	90%	70%
5	60%	80%	40%	60%	80%	40%
6	50%	70%	30%	50%	70%	30%
7	30%	60%	20%	30%	60%	20%
8	30%	50%	10%	30%	50%	10%
9	20%	50%	10%	20%	50%	10%

iMX-B25/iMX-B45

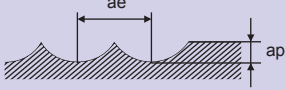
Ball nose head, 2 flute/4 flute, For hardened steels

Recommended Cutting Conditions

iMX-B2S

Shoulder Milling

(inch)

Workpiece Material		Hardened Steels (55–65HRC)							
Inclination Angle		$\alpha \leq 15^\circ$		$\alpha > 15^\circ$		Depth of Cut a_p	Width of Cut a_e		
DC	RE	Revolution n (min ⁻¹)	Feed Rate v_f (IPM)	Revolution n (min ⁻¹)	Feed Rate v_f (IPM)				
(mm)	(inch)	(mm)	(inch)	(mm)	(inch)				
16	.630	8	.315	6000	66.9	3000	18.9	.012	.063
20	.787	10	.394	4800	51.2	2400	15.0	.012	.079
Depth of Cut									

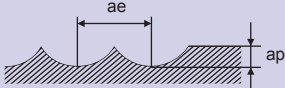
Note 1) If the depth of cut is smaller, the revolution and the feed rate can be increased.

Note 2) α is the inclination angle of the machined surface.

iMX-B4S

Shoulder Milling

(inch)

Workpiece Material		Hardened Steels (55–65HRC)							
Inclination Angle		$\alpha \leq 15^\circ$		$\alpha > 15^\circ$		Depth of Cut a_p	Width of Cut a_e		
DC	RE	Revolution n (min ⁻¹)	Feed Rate v_f (IPM)	Revolution n (min ⁻¹)	Feed Rate v_f (IPM)				
(mm)	(inch)	(mm)	(inch)	(mm)	(inch)				
16	.630	8	.315	6000	66.9	3000	28.3	.012	.063
20	.787	10	.394	4800	51.2	2400	22.8	.012	.079
Depth of Cut									

Note 1) If the depth of cut is smaller, the revolution and the feed rate can be increased.

Note 2) α is the inclination angle of the machined surface.

