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)

Workpiece Material	Carbon Steels, Alloy Steels, Mild Steels, Copper, Copper Alloys			Pre-hardened Steels, Carbon Steels, Alloy Steels, Alloy Tool Steels			Austenitic Stainless Steels, Ferritic and Martensitic Stainless Steels, Titanium Alloys		
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	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%

Workpiece Material	Precipitation Hardening Stainless Steels, Cobalt Chromium Alloys			Heat Resistant Alloys Inconel718		
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	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%

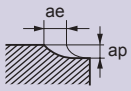
iMX-C8T/C10T/C12T/C15T-C

Corner radius, Taper head, Multi-flute, With coolant hole

Recommended Cutting Conditions

Shoulder Milling

(inch)

Workpiece Material		Austenitic Stainless Steels, Ferritic and Martensitic Stainless Steels				Precipitation Hardening Stainless Steels, Titanium Alloys				Heat Resistant Alloys			
DC (mm)	No. of Flutes	Revolution **n** (min^{-1})	Feed Rate **vf** (IPM)	Depth of Cut **ap**	Width of Cut **ae**	Revolution **n** (min^{-1})	Feed Rate **vf** (IPM)	Depth of Cut **ap**	Width of Cut **ae**	Revolution **n** (min^{-1})	Feed Rate **vf** (IPM)	Depth of Cut **ap**	Width of Cut **ae**
8	**8**	12000	378.0	.012	.047	8000	252.0	.012	.047	2400	59.1	.012	.031
10	**10**	9500	374.0	.012	.059	6400	252.0	.012	.059	1900	59.1	.012	.039
15	**12**	6400	362.2	.012	.087	4200	236.2	.012	.087	1300	63.0	.012	.059
15	**15**	6400	378.0	.012	.087	4200	248.0	.012	.087	1300	63.0	.012	.059
19	**12**	5000	283.5	.012	.110	3400	192.9	.012	.110	1000	47.2	.012	.075
19	**15**	5000	295.3	.012	.110	3400	200.8	.012	.110	1000	47.2	.012	.075
Depth of Cut													

Note 1) Vibration may occur if the rigidity of machine or workpiece material is low.
In this case, please reduce the revolution and the feed rate proportionately, or set a lower depth of cut.
Note 2) The use of water-soluble coolant is effective.