

RECOMMENDED CUTTING CONDITIONS

CUTTING SPEED

Work Material	Hardness	Insert				ae (mm)			
		Grade Priority		Breaker	≤0.25DC	0.25-0.5DC	0.5-0.75DC	DC (Slot)	
		1st	2nd						Cutting Speed Vc (m/min)
P Mild Steel	≤180HB	MP6120	VP15TF	M H	230(180-270)	220(170-260)	180(140-210)	180(140-210)	
		MP6130	VP20RT	M H	200(150-240)	190(140-230)	150(110-180)	150(110-180)	
Carbon Steel Alloy Steel	180-350HB	MP6120	VP15TF	M H	180(140-210)	170(130-200)	140(110-160)	140(110-160)	
		MP6130	VP20RT	M H	150(110-180)	140(100-170)	110(80-130)	110(80-130)	
M Stainless Steel	≤270HB	MP7130	VP20RT	M H	180(140-210)	170(130-200)	140(110-160)	140(110-160)	
K Gray Cast Iron	≤350MPa	MC5020	VP15TF	H -	250(200-300)	240(190-290)	210(160-260)	140(110-160)	
	≤800MPa	MC5020	VP15TF	H -	130(100-150)	120(90-140)	100(80-120)	100(80-120)	
S Titanium Alloy	≤350HB	MP9120	VP15TF	H M	50(40-70)	-	-	50(40-70)	
		MP9130	VP20RT	H M	40(30-60)	-	-	40(30-60)	
	Heat-resistant Alloy	MP9120	VP15TF	H M	40(30-60)	-	-	40(30-60)	
		MP9130	VP20RT	H M	30(20-40)	-	-	30(20-40)	
H Hardened Steel	40-55HRC	VP15TF	-	H -	90(70-100)	85(60-100)	70(50-80)	70(50-80)	

DEPTH OF CUT AND FEED PER TOOTH

Work Material	Hardness	ae (mm)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t.)		
				Cutter Diameter DC (mm)		
				ø25-ø40	ø50-ø80	ø100-ø160
P Mild Steel Carbon Steel Alloy Steel	≤180HB	≤0.5DC	≤5	0.30	0.30	0.25
			5-7.5	0.25	0.25	0.20
			7.5-10	0.20	0.20	0.15
			10-12.5	0.15	0.15	0.10
			12.5-15	0.10	0.10	0.07
		0.5-0.75DC	≤5	0.20	0.20	0.15
	180-350HB	0.5-0.75DC	5-10	0.15	0.15	0.10
			10-15	0.10	0.10	0.07
			DC (Slot)	≤5	0.15	0.15
		5-7.5	0.10	0.10	0.10	
		7.5-10	0.07	0.07	0.07	
		M Stainless Steel	≤270HB	≤0.5DC	≤5	0.30
5-7.5	0.25				0.20	0.20
7.5-10	0.20				0.15	0.15
10-12.5	0.15				0.10	0.10
12.5-15	0.10				0.07	0.07
0.5-0.75DC	≤5			0.20	0.15	0.15
DC (Slot)	5-10		0.15	0.10	0.10	
	10-15		0.10	0.07	0.07	
	≤5		0.15	0.15	0.15	
	5-7.5		0.10	0.10	0.10	
	7.5-10		0.07	0.07	0.07	
	K Gray Cast Iron Ductile Cast Iron		Tensile Strength ≤350MPa	≤0.5DC	≤5	0.30
5-7.5		0.25			0.25	0.20
7.5-10		0.20			0.20	0.15
10-12.5		0.15			0.15	0.10
12.5-15		0.10			0.10	0.07
0.5-0.75DC		≤5		0.20	0.20	0.15
		5-10		0.15	0.15	0.10
		10-15		0.10	0.10	0.07
		DC (Slot)		≤5	0.15	0.15
Tensile Strength ≤800MPa		≤0.5DC	≤5	0.25	0.25	0.25
			5-7.5	0.20	0.20	0.20
			7.5-10	0.15	0.15	0.15
			10-12.5	0.10	0.10	0.10
			12.5-15	0.07	0.07	0.07
		0.5-0.75DC	≤5	0.20	0.20	0.15
			5-10	0.15	0.15	0.10
			10-15	0.10	0.10	0.07
			DC (Slot)	≤5	0.15	0.15
DC (Slot)	5-7.5	0.10	0.10	0.10		
	7.5-10	0.07	0.07	0.07		

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				Cutter Diameter DC (mm)		
				ø25-ø40	ø50-ø80	ø100-ø160
S Titanium Alloy	≤350HB	≤0.25DC	≤5	0.15	0.10	0.10
			5-7.5	0.10	0.05	0.05
			7.5-10	0.05	-	-
		DC (Slot)	≤5	0.05	0.05	0.05
Heat-resistant Alloy	-	≤0.25DC	≤2	0.10	0.05	0.05
		DC (Slot)	≤1	0.05	0.05	0.05
H Hardened Steel	40-55HRC	≤0.25DC	≤5	0.15	0.15	0.15
			5-7.5	0.10	0.10	0.10
			7.5-10	0.07	0.07	0.07
		0.25-0.5DC	≤5	0.10	0.10	0.10
			5-7.5	0.07	0.07	0.07
		0.5-0.75DC	≤5	0.07	0.07	0.07
			DC (Slot)	≤5	0.07	0.07

Note 1) These cutting conditions are a guide to the standard shank type and the arbor type.

Please make adjustments according to the machining conditions.

Note 2) Vibration is liable to occur in certain cases. Please reduce the depth of cut and / or reduce cutting conditions in the following cases.

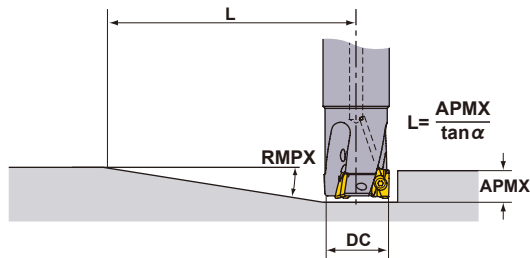
- When using the long shank type and extra long shank type.
- When using long tool overhang with the standard or arbor type.
- When the application has poor clamping rigidity or when using a low rigidity machine.

Note 3) In case of coarse and fine pitch cutters, the coarse pitch type is recommended to prevent vibration.

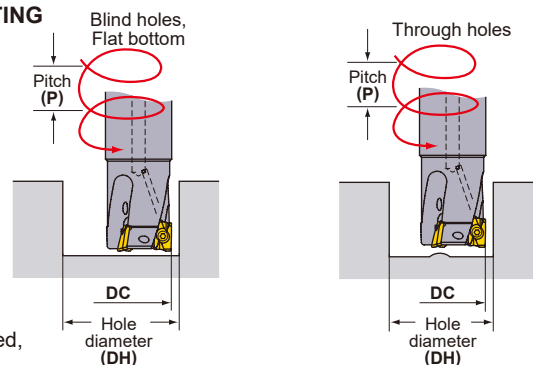
Note 4) For heavy interrupted and unstable cutting, the H breaker is first recommendation.

■ RAMPING/HELICAL CUTTING

● RAMPING



● HELICAL CUTTING



Refer to the table below for cutting conditions. For feed per tooth and cutting speed, follow the cutting conditions for slot milling.

Cutting Edge Diameter DC (mm)	Ramping		Helical Cutting (Blind Hole, Flat Bottom)				Helical Cutting (Through Hole)	
	Maximum Ramping Angle RMPX	Minimum Distance *1 L (mm)	Maximum Hole Diameter *2 DH max. (mm)	Maximum Pitch P max. (mm)	Minimum Hole Diameter DH min. (mm)	Maximum Pitch P max. (mm)	Minimum Hole Diameter DH min. (mm)	Maximum Pitch P max. (mm)
25	11°	85	48	14	45	12	32	4
28	9°	105	54	12	51	11	38	4
32	7°	135	62	11	59	10	46	5
35	6°	158	68	10	65	9	52	5
40	6°	158	78	12	75	11	62	7
50	4°	238	98	10	95	9	82	7
63	3°	318	124	10	121	9	108	7
80	2°	477	158	8	155	8	142	6
100	1.5°	636	198	8	195	7	182	6
125	1°	954	248	6	245	6	232	5
160	1°	954	318	8	315	8	302	7

Note 1) When machining highly ductile materials with ramping angles above, chips could be continuous.

In this case, decrease the ramping angle or feed per tooth.

*1 $L = 15 / \tan(\alpha)$. Cutters' moving distance until depth of cut reaches 15mm at a maximum ramping angle.

*2 In case corner radius of 0.8mm. Other than that, calculate using the formula below.

$$\{(cutting\ edge\ diameter\ DC) - (corner\ radius) - 0.2\} \times 2$$