

RECOMMENDED CUTTING CONDITIONS

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Work material		Aluminium alloy	
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	
		Side milling	Slotting
12	13000	5400	3200
16	10000	5400	3200
20	8000	5000	3000
25	6000	4500	2800
Depth of cut			

- Note 1) This table shows the cutting condition with less than 4DC overhang length. If more than 4DC, spindle speed, feed rate and depth of cut should be reduced.
- Note 2) If the rigidity of the machine or the workpiece installation is very low, or chattering and noise are generated, please reduce the revolution and the feed rate proportionately.
- Note 3) Water-soluble cutting fluid is recommended.
- Note 4) Climb cutting is recommended for side milling.
- Note 5) Vertical feed is not recommended. To enter the work ramping should be used.