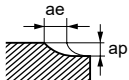


## RECOMMENDED CUTTING CONDITIONS

### ■ Shoulder milling (L/D=3)

Other than the L/D = 3, use following recommended cutting conditions by multiplying the J003 page correction factor of the overhang length.

Work material		M						M		S		S							
		Austenitic stainless steel, Ferritic and martensitic stainless steel						Precipitation hardening stainless steel, Titanium alloy				Heat resistant alloys							
Dia. DC (mm)	No. of Flutes	Cutting Speed (m/min)	Main Spindle Revolution (min <sup>-1</sup> )	Feed per Tooth (mm/t)	Table Feed per Min. (mm/min)	Depth of Cut ap (mm)	Cutting Width ae (mm)	Cutting Speed (m/min)	Main Spindle Revolution (min <sup>-1</sup> )	Feed per Tooth (mm/t)	Table Feed per Min. (mm/min)	Depth of Cut ap (mm)	Cutting Width ae (mm)	Cutting Speed (m/min)	Main Spindle Revolution (min <sup>-1</sup> )	Feed per Tooth (mm/t)	Table Feed per Min. (mm/min)	Depth of Cut ap (mm)	Cutting Width ae (mm)
<b>8</b>	<b>8</b>	300	12000	0.1	9600	0.3	1.2	200	8000	0.1	6400	0.3	1.2	60	2400	0.08	1500	0.3	0.8
<b>10</b>	<b>10</b>	300	9500	0.1	9500	0.3	1.5	200	6400	0.1	6400	0.3	1.5	60	1900	0.08	1500	0.3	1
<b>15</b>	<b>12</b>	300	6400	0.12	9200	0.3	2.2	200	4200	0.12	6000	0.3	2.2	60	1300	0.1	1600	0.3	1.5
<b>15</b>	<b>15</b>	300	6400	0.1	9600	0.3	2.2	200	4200	0.1	6300	0.3	2.2	60	1300	0.08	1600	0.3	1.5
<b>19</b>	<b>12</b>	300	5000	0.12	7200	0.3	2.8	200	3400	0.12	4900	0.3	2.8	60	1000	0.1	1200	0.3	1.9
<b>19</b>	<b>15</b>	300	5000	0.1	7500	0.3	2.8	200	3400	0.1	5100	0.3	2.8	60	1000	0.08	1200	0.3	1.9
Depth of cut																			

Note 1) The use of water-soluble coolant is recommended.

Note 2) Vibration may occur if the rigidity of machine or workpiece is low.

In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.