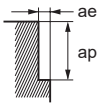
RECOMMENDED CUTTING CONDITIONS

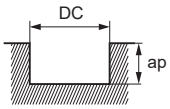
■ Side milling

(mm)

Workpiece Material		Nickel-Based Heat Resistant Super Alloy Inconel718, Inconel713C, WASPALOY etc.			
DC	Number of Flutes	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap	Depth of cut ae
3	**4**	4200	340	4.5	0.3
4	**4**	3200	260	6	0.4
5	**4**	2500	300	7.5	0.5
6	**4**	2100	250	9	0.6
8	**6**	1600	290	12	0.8
10	**6**	1300	310	15	1
12	**6**	1100	260	18	1.2
Depth of cut					

■ Slot milling

(mm)

Workpiece Material		Nickel-Based Heat Resistant Super Alloy Inconel718, Inconel713C, WASPALOY etc.		
DC	Number of Flutes	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap
3	**4**	3200	260	1.5
4	**4**	2400	190	2
5	**4**	1900	230	2.5
6	**4**	1600	190	3
8	**6**	1200	220	4
10	**6**	1000	180	5
12	**6**	800	140	6
Depth of cut				

Note 1) The use of water-soluble coolant is effective for heat resistant super alloys.

Note 2) Vibration damping end mills are more effective in suppressing chatter and vibration compared to general end mills, but these may still occur if the rigidity of the machine or the workpiece material is low. In this case, please adjust the spindle speed, feed rate, and depth of cut according to the table above.

Note 3) If the depth of cut is shallow, the revolution and feed rate can be increased.