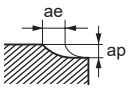
Recommended Cutting Conditions

■ Shoulder milling (L/D=3)

(mm)

Workpiece Material		Austenitic stainless steels, Ferritic and Martensitic stainless steels AISI 304, AISI 316, AISI 304LN, AISI 316LN, AISI 410, AISI 430, AISI 431, AISI 420J2						Precipitation-hardening stainless steels, Titanium alloys AISI 630, AISI 631, Ti-6Al-4V						Heat resistant alloys Inconel718					
Dia. **DC**	No. of Flutes	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae	Cutting Speed (m/min)	Revolution (min^{-1})	Feed per Tooth (mm/t)	Feed rate (mm/min)	Depth of cut ap	Width of Cut ae
8	**8**	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
10	**10**	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
15	**12**	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
15	**15**	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
19	**12**	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
19	**15**	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 effective.
Note 2) If the machine or workpiece material is not rigid, or if chatter or abnormal noises occur, adjust the revolution, feed rate and depth of cut.