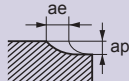


RECOMMENDED CUTTING CONDITIONS

Side milling

Work material		Austenitic stainless steel, Ferritic, Precipitation hardening stainless steel						Precipitation hardening stainless steel, Titanium alloy						Heat resistant alloys					
Work material		SUS304, SUS316, SUS304LN, SUS316LN, SUS410, SUS430, SUS431, SUS420J2						SUS630, SUS631, Ti-6Al-4V						Inconel718					
Dia. DC (mm)	No. of Flutes	Cutting Speed (m/min)	Main Spindle Revolution (min ⁻¹)	Feed per Tooth (mm/t.)	Table Feed (mm/min)	Depth of Cut ap (mm)	Depth of Cut ae (mm)	Cutting Speed (m/min)	Main Spindle Revolution (min ⁻¹)	Feed per Tooth (mm/t.)	Table Feed (mm/min)	Depth of Cut ap (mm)	Depth of Cut ae (mm)	Cutting Speed (m/min)	Main Spindle Revolution (min ⁻¹)	Feed per Tooth (mm/t.)	Table Feed (mm/min)	Depth of Cut ap (mm)	Depth of Cut ae (mm)
8	8	300	12000	0.10	9600	0.3	1.2	200	8000	0.10	6400	0.3	1.2	60	2400	0.08	1500	0.3	0.8
10	10	300	9500	0.10	9500	0.3	1.5	200	6400	0.10	6400	0.3	1.5	60	1900	0.08	1500	0.3	1.0
15	12	300	6400	0.12	9200	0.3	2.2	200	4200	0.12	6000	0.3	2.2	60	1300	0.10	1600	0.3	1.5
15	15	300	6400	0.10	9600	0.3	2.2	200	4200	0.10	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	0.10	1200	0.3	1.9
19	15	300	5000	0.10	7500	0.3	2.8	200	3400	0.10	5100	0.3	2.8	60	1000	0.08	1200	0.3	1.9
Depth of cut																			

DC: Dia.

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