

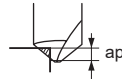
RECOMMENDED CUTTING CONDITIONS

■ Chamfer milling (Shape circumference)

(mm)

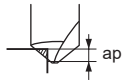
Workpiece Material		Carbon steels, Alloy steels, Gray cast irons					Alloy tool steels, Carbon steels, Alloy steels, Pre-hardened steels					Austenitic stainless steels, Titanium alloys				
		AISI 1045, AISI 4140, AISI No 45 B					SKD, SKT, AISI 4340, AISI P21, AISI P20					AISI 304, AISI 316, Ti-6Al-4V				
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	Cutting Speed (m/min)	Revolution (min ⁻¹)	Feed per Tooth (mm/t)	Feed rate (mm/min)	Depth of cut ap	Cutting Speed (m/min)	Revolution (min ⁻¹)	Feed per Tooth (mm/t)	Feed rate (mm/min)	Depth of cut ap
12	6	100	2700	0.05	810	2.4	70	1900	0.045	510	2.4	60	1600	0.04	380	2.4
16	6	100	2000	0.05	600	2.7	70	1400	0.045	380	2.7	60	1200	0.04	290	2.7
20	6	100	1600	0.05	480	3.2	70	1100	0.045	300	3.2	60	950	0.04	230	3.2

Depth of Cut



Workpiece Material		Hardenned steels (40-55HRC)					Heat resistant alloys				
		AISI H13, AISI L6					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	Cutting Speed (m/min)	Revolution (min ⁻¹)	Feed per Tooth (mm/t)	Feed rate (mm/min)	Depth of cut ap
12	6	50	1300	0.03	230	2.4	30	800	0.04	190	2.4
16	6	50	990	0.03	180	2.7	30	600	0.04	140	2.7
20	6	50	800	0.03	140	3.2	30	480	0.04	120	3.2

Depth of Cut



Note 1) For stainless steels, titanium alloys and heat resistant alloys, the use of water-soluble coolant is effective.

Note 2) Vibration may occur if there is poor rigidity of the machine or workpiece material. In that case, please adjust the revolution and feed rate.