

## RECOMMENDED CUTTING CONDITIONS

DC (mm)	Revolution (min <sup>-1</sup> )	Table feed		Depth of cut a (mm)	Revolution (min <sup>-1</sup> )	Table feed		Depth of cut a (mm)	Revolution (min <sup>-1</sup> )	Table feed		Depth of cut a (mm)
		(mm/min)	(IPM)			(mm/min)	(IPM)			(mm/min)	(IPM)	
<b>0.5</b>	40000	1000	39.4	0.015	40000	960	37.8	0.015	30000	600	23.6	0.01
<b>1</b>	40000	2000	78.7	0.06	32000	1600	63.0	0.06	16000	550	21.7	0.05
<b>1.5</b>	40000	3000	118.1	0.12	32000	1900	74.8	0.08	10600	500	19.7	0.08
<b>2</b>	30000	3000	118.1	0.18	24000	1900	74.8	0.10	8100	400	15.7	0.1
<b>2.5</b>	24000	2600	102.4	0.25	19000	1600	63.0	0.13	6400	350	13.8	0.13
<b>3</b>	20000	2300	90.6	0.30	16000	1400	55.1	0.15	5400	300	11.8	0.15
<b>4</b>	15000	2000	78.7	0.40	12000	1200	47.2	0.20	4000	240	9.4	0.2
<b>5</b>	12000	1600	63.0	0.50	9000	900	35.4	0.25	3200	190	7.5	0.2
<b>6</b>	10000	1400	55.1	0.60	7000	700	27.6	0.30	2700	160	6.3	0.2

Depth of cut

- 1) When slotting, reduce the revolutions by 50 - 70% and the feed rate by 40 - 60%.
- 2) For austenitic stainless steels, titanium and heat-resistant alloys, VFMHV is recommended.
- 3) The irregular helix flute end mill has a large effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is very low, then vibration can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.