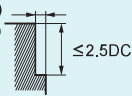


RECOMMENDED CUTTING CONDITIONS

Side milling

Work material	Aluminium alloy		Aluminium cast	
Cutting speed	150m/min		120m/min	
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
1	40000	320	38000	240
2	24000	380	19000	240
3	16000	510	13000	330
4	12000	580	9500	380
5	9500	640	7600	400
6	8000	640	6400	400
8	6000	770	4800	480
10	4800	770	3800	480
12	4000	770	3200	480
16	3000	670	2400	430
20	2400	610	1900	390
Depth of cut	$\leq 0.05DC$ ($DC < \phi 3$) $\leq 0.1DC$ ($DC \geq \phi 3$) 			

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) Water-soluble cutting fluid is recommended.
- 3) Climb cutting is recommended for side milling.
- 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.