CARBIDE END MILLS

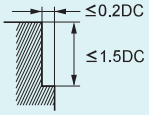
End mill, Medium cut length, 4 flute, Center cutting **C4MC**

End mill, Semi long cut length, 4 flute, Center cutting **C4JC** 1)

End mill, Long cut length, 4 flute, Center cutting **C4LC** 2)

RECOMMENDED CUTTING CONDITIONS

Side milling

Work material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20—30HRC) AISI 1050, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30—45HRC) AISI P20, AISI H13, AISI P21		Austenitic stainless steel, Titanium alloy AISI 304, AISI 316	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
3	4100	150	3500	130	2800	100	2300	90
4	3400	260	2900	210	2200	140	1900	120
5	2900	290	2400	230	1800	150	1500	135
6	2500	300	2100	260	1600	170	1300	140
8	1900	300	1600	260	1200	160	1000	150
10	1500	270	1250	230	950	140	800	135
12	1250	230	1050	200	800	120	660	110
16	940	170	800	140	600	90	500	80
20	750	140	640	120	480	75	400	70
Depth of cut	(C4MC)  DC:Dia.							

1) Decrease the feed rate by 20—30% for C4JC.
2) Decrease the revolution by 20—30% and the feed rate by 40—50% for C4LC.
3) 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.