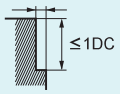
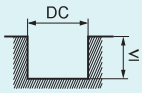
RECOMMENDED CUTTING CONDITIONS

Side milling

Work material	Aluminium alloy		Aluminium cast	
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	40000	600	40000	460
2	40000	1100	38000	850
3	32000	1400	25000	950
4	24000	1500	19000	1000
5	19000	1600	15000	1000
6	16000	1900	13000	1100
8	12000	1900	9500	1200
10	9500	1900	7600	1200
12	8000	1900	6400	1200
16	6000	1900	4800	1200
20	4800	1500	3800	1000
Depth of cut	≤0.2DC (DC < ϕ3) ≤0.5DC (DC ≥ ϕ3)  ≤1DC DC:Dia.			

Slotting

Work material	Aluminium alloy		Aluminium cast	
Dia. DC (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
1	40000	460	40000	350
2	38000	850	32000	550
3	25000	950	21000	600
4	19000	1000	16000	650
5	15000	1000	13000	700
6	13000	1100	11000	750
8	9500	1200	8000	800
10	7600	1200	6400	800
12	6400	1200	5300	800
16	4800	1000	4000	720
20	3800	970	3200	660
Depth of cut	 DC ≤1DC (MAX. 12mm) DC:Dia.			

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.