

RECOMMENDED CUTTING CONDITIONS

Side milling

Work material	Aluminium alloy	
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
3	40000	1800
4	36000	2400
5	30000	3000
6	27000	3200
8	20000	3400
10	16000	3600
12	13000	3600
16	10000	3600
20	8000	3300

Depth of cut		
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Slotting

Work material	Aluminium alloy	
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
3	40000	1600
4	36000	2100
5	30000	2700
6	27000	2800
8	20000	3000
10	16000	3200
12	13000	3200
16	10000	3200
20	8000	3000

Depth of cut		
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- 1) Water-soluble cutting fluid is recommended.
- 2) Climb cutting is recommended for side milling.
- 3) If tool clamping is poor, the tool can be pulled out of the holder. Ensure that the tool is sufficiently clamped.
- 4) This table shows the cutting condition with less than 4D overhang length. If more than 4D, spindle speed, feed rate and depth of cut should be reduced.
- 5) 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.