

RECOMMENDED CUTTING CONDITIONS

Side milling

Work material	Aluminium alloy	
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
3	40000	2400
4	36000	2600
5	30000	4000
6	27000	4000
8	20000	4000
10	16000	4500
12	13000	4500
16	10000	4500
20	8000	4300
25	6000	3600

Depth of cut		
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Slotting

Work material	Aluminium alloy	
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
3	40000	1500
4	36000	1800
5	30000	2800
6	27000	2800
8	20000	2800
10	16000	3200
12	13000	3200
16	10000	3200
20	8000	3000
25	6000	2500

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) 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.