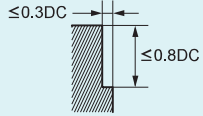
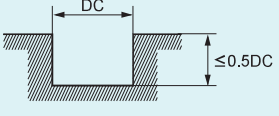


RECOMMENDED CUTTING CONDITIONS

Side milling

Work material	Aluminium alloy	
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
12	13000	5400
16	10000	5400
18	9000	5000
20	8000	5000
25	6000	4500
Depth of cut		

Slotting

Work material	Aluminium alloy	
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
12	13000	3200
16	10000	3200
18	9000	3000
20	8000	3000
25	6000	2800
Depth of cut		

- 1) Water-soluble cutting fluid is recommended.
- 2) Climb cutting is recommended for side milling.
- 3) 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.
- 4) These end mills do not have a centre cutting edge, therefore when entering a workpiece use a ramping process rather than vertical feed.
- 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, or set the depth of cut smaller.