

RECOMMENDED CUTTING CONDITIONS

Side milling

Work material	Aluminium alloy		Aluminium cast	
	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
3	40000	2700	25000	1100
4	36000	2700	20000	1100
5	30000	5400	16000	2200
6	27000	6100	13000	2300
8	20000	6000	10000	2400
10	16000	5800	8000	2300
12	13000	5300	6500	2100
16	10000	5100	5000	2000
20	8000	4800	4000	1900
25	6400	4600	3200	1800

Depth of cut	<p style="text-align: right;">DC: Dia.</p>
--------------	--

Slotting

Work material	Aluminium alloy		Aluminium cast	
	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
3	30000	1800	16000	700
4	24000	2200	12000	900
5	19000	2300	10000	900
6	16000	2400	8000	1000
8	12000	2500	6000	1000
10	9500	2600	5000	1100
12	8000	2300	4000	900
16	6000	2100	3000	800
20	4800	2000	2400	800
25	3800	2000	1900	700

DDepth of cut	<p style="text-align: right;">DC: Dia.</p>
---------------	--

- 1) Water-soluble cutting fluid is recommended.
- 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 3) Climb cutting is recommended for side milling.
- 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.