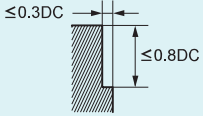
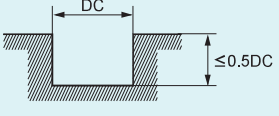


## RECOMMENDED CUTTING CONDITIONS

### Side milling

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

### Slotting

Work material	Aluminium alloy	
Dia. DC (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)
<b>12</b>	13000	3200
<b>16</b>	10000	3200
<b>18</b>	9000	3000
<b>20</b>	8000	3000
<b>25</b>	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.