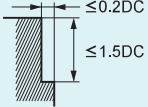


## RECOMMENDED CUTTING CONDITIONS

### Side milling

Work material	Structural steel, Cast iron, Carbon steel		Carbon steel, Alloy steel (20–30HRC)		Alloy steel, Tool steel, Pre-hardened steel (30–35HRC)		Austenitic stainless steel, Alloy steel, Tool steel (35–40HRC)	
	AISI 1045, AISI No 35 B, AISI 1050		AISI 1055, AISI P20		AISI H13, AISI D2		AISI 304, AISI 316	
Dia. DC (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)
<b>3</b>	5400	270	4000	200	2700	140	2200	100
<b>4</b>	4300	320	3200	240	2100	160	1800	120
<b>5</b>	3600	340	2700	250	1800	170	1500	130
<b>6</b>	3200	350	2400	260	1600	180	1300	140
<b>8</b>	2400	380	1800	290	1200	190	1000	145
<b>10</b>	1900	420	1400	300	950	210	800	160
<b>12</b>	1600	380	1200	290	800	190	660	145
<b>16</b>	1200	340	900	260	600	170	500	130
<b>20</b>	950	290	720	220	480	140	400	110
<b>25</b>	760	240	570	180	380	120	320	100
<b>30</b>	640	210	480	160	320	100	270	80

Depth of cut		DC: Dia.
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- 1) 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.