

Unit : mm

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
4LCD3700	37	105	190	32	4	●	3
4LCD3800	38	105	190	32	4	●	3
4LCD3900	39	110	195	32	4	●	3
4LCD4000	40	110	195	32	4	●	3

RECOMMENDED CUTTING CONDITIONS

Side milling

Work material	Structural steel, Carbon steel		Carbon steel, Alloy steel (20—30HRC)		Alloy steel, Tool steel, Pre-hardened steel (30—35HRC)		Austenitic stainless steel		Cast iron		Aluminium alloy	
	AISI 1045, AISI 1050	AISI 1055, AISI P20	AISI 1055, AISI P20	AISI H13	AISI 304, AISI 316	AISI No 35 B						
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
3	2300	105	1800	80	1400	65	1100	45	2000	110	4800	280
4	1800	120	1400	85	1100	65	850	45	1600	125	3800	370
5	1600	135	1200	105	900	70	710	50	1300	140	3200	420
6	1400	140	1000	105	780	80	610	55	1100	155	2800	460
8	1100	155	800	110	580	80	470	55	850	160	2200	530
10	860	170	640	120	470	80	380	65	700	180	1800	500
12	720	155	530	110	390	70	310	55	580	160	1600	490
16	540	135	400	105	300	65	230	50	440	140	1200	410
20	430	110	320	85	240	55	190	45	350	120	960	350
25	350	100	250	70	190	45	150	35	285	105	760	310
30	290	90	210	65	160	40	120	30	240	100	640	280
40	210	70	150	40	120	30	90	25	180	80	480	220

Depth of cut

$\leq 0.2DC$
 $\leq 1.5DC$

DC: Dia.

- 1) Use the milling by reducing the revolution in the table shown above by 20—30% and the feedrate 40—50% to match the cutting type.
- 2) 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.

SQUARE

BALL

RADIUS

TAPER

SOLID END MILLS