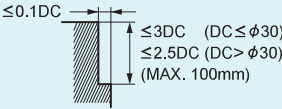


## RECOMMENDED CUTTING CONDITIONS

### Side milling

Work material	Structural steel, Cast iron, Carbon steel AISI 1045, AISI No 35 B, AISI 1050		Carbon steel, Alloy steel (20—30HRC) AISI 1055, AISI P20		Alloy steel, Tool steel, Pre-hardened steel (30—35HRC) AISI H13, AISI D2		Austenitic stainless steel, Alloy steel, Tool steel (35—40HRC) 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>10</b>	1000	75	700	55	480	40	400	30
<b>12</b>	850	90	630	70	440	50	370	40
<b>16</b>	700	100	540	80	380	55	320	45
<b>20</b>	560	100	430	80	300	55	260	50
<b>25</b>	450	100	340	75	240	55	210	50
<b>30</b>	370	100	290	75	200	50	170	45
<b>40</b>	260	80	200	60	135	45	120	40
<b>50</b>	180	65	140	50	90	35	80	30
Depth of cut								

- 1) Supply cutting fluid sufficiently during cutting. For dry-cutting, decrease the revolution and feed rate proportionately by 20—50%.
- 2) When the diameter exceeds 30 and the metal removal is less than the quantity shown in the table, the revolution and feed rate may be increased proportionately by 10—40%.
- 3) 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.