
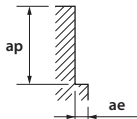


Milling | Endmills | Cutting conditions

Side milling

	C≤0,2% - GG		30~38 HRC		38~45 HRC	
	SS400 • S55C • FC250 750 N/mm²		SKT • SKD • NAK55 • HPM1		SKT • SKD • NAK80 • HPM50	
Ø	S (min⁻¹)	F (mm/min)	S (min⁻¹)	F (mm/min)	S (min⁻¹)	F (mm/min)
3	4.200	150	2.950	85	2.650	80
4	3.150	150	2.200	85	1.950	80
5	2.500	150	1.750	85	1.550	80
6	2.100	150	1.450	85	1.300	80
8	1.550	150	1.100	85	995	80
10	1.250	150	890	85	795	80
12	1.050	150	740	85	660	80
Max cutting depth						
<div> <div> <div>ap</div> <div>ae</div> <div>6D</div> <div>0,01D</div> </div> <div> <ol style="list-style-type: none"> 1. Use a rigid and precise machine and holder. 2. When chattering occurs, reduce the speed and feed simultaneously. 3. Use a suitable cutting fluid with high smoke retardant properties. </div> </div>						