

Milling | Endmills | Cutting conditions

Slotting

These parameters are for use with cutting-depth of 0.5 D and a cutting-width of 1 D for end mills 2 and 3 flutes. These parameters are for use with cutting-depth of 0.25 D and a cutting-width of 1 D for end mills 4 flutes. For alu. alloys < 6% Si, please use feed/flute as indicated in the column by X by 3 times the cutting speed. For copper alloys, please use the feed/flute as indicated in the column by X by 2 times the cutting speed.

Side milling

These parameters are for use with cutting-depth of 1,5 D and a cutting-width of 0,1 D.
For alu. alloys < 6% Si, please use feed/flute as indicated in the column by X by 3 times the cutting speed.
For copper alloys, please use the feed/flute as indicated in the column by X by 2 times the cutting speed.