


Milling | Endmills | Cutting conditions

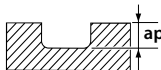
WX-G-EDSS

Slotting

	C<0,2% - GG SS400 • S55C • FC250 750 N/mm2		~30 HRC SCM • SKT • SKS • SKD		30~38 HRC NAK55 • SKT • HPM1 • SKD		38~45 HRC SUS304 • NAK80 • HPM50 • SKD		45~55 HRC-SUS Z38CDV5		55~60 HRC Z160CDV12	
	Ø	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)
1	19.500	130	14.500	125	12.500	90	11.000	65	7.000	30	5.050	25
1,5	14.000	130	10.500	125	8.900	90	7.950	65	5.050	40	3.550	25
2	11.000	135	8.400	125	7.000	90	6.350	70	3.950	40	2.750	25
2,5	8.900	170	7.250	135	6.000	95	5.600	70	3.250	40	2.300	25
3	7.450	200	7.200	230	5.850	125	5.300	100	3.200	45	2.100	25
3,5	6.650	225	6.200	230	5.000	125	4.550	100	2.750	45	1.800	25
4	6.000	235	5.400	230	4.400	125	4.000	100	2.400	45	1.600	25
4,5	5.650	270	4.800	230	3.900	125	3.550	100	2.100	45	1.400	25
5	5.300	315	4.350	235	3.500	130	3.200	100	1.900	55	1.300	30
5,5	4.800	310	3.950	235	3.250	130	2.750	100	1.750	55	1.150	30
6	4.400	310	3.600	235	2.900	130	2.650	100	1.600	55	1.050	25
8	3.300	295	2.700	235	2.200	125	2.000	100	1.200	50	795	25
10	2.650	280	2.150	230	1.750	125	1.600	95	955	50	635	25
12	2.200	280	1.800	230	1.450	125	1.350	95	795	45	530	20

Max
cutting
depth

D	ap
≤ 6	0,3D
> 6	0,5D



ap

D	ap
≤ 6	0,1D
> 6	0,2D


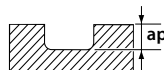
D	ap
≤ 6	0,05D
> 6	0,1D

1. Use high precision machine set up to ensure maximum rigidity.

2. In case of vibration, reduce both feed and speed.

3. Use a coolant that has a low co-efficient of smoke emission. * Modified parameters

High speed light milling

	C≤0,2% - GG		~30 HRC		30~38 HRC		38~45 HRC		45~55 HRC-SUS													
	SS400 • S55C • FC250 750 N/mm2		SCM • SKT • SKS • SKD		NAK55 • SKT • HPM1 • SKD		SUS304 • NAK80 • HPM50 • SKD		Z38CDV5													
Ø	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)												
1	30.200	545	28.600	515	25.500	405	19.100	275	12.700	120												
1,5	20.800	550	20.200	530	17.500	405	12.900	270	8.700	120												
2	15.900	550	15.500	530	13.500	405	9.900	270	6.700	120												
2,5	13.100	550	12.700	535	11.100	405	8.000	265	5.450	125												
3	10.600	605	10.600	575	8.500	410	6.350	285	4.800	145												
3,5	9.550	600	9.550	570	7.750	405	5.700	280	4.200	140												
4	8.750	560	8.750	560	7.150	400	5.150	270	3.750	135												
4,5	8.150	550	8.150	550	6.700	390	4.800	255	3.400	130												
5	7.650	535	7.650	535	6.400	380	4.450	250	3.200	130												
5,5	6.900	535	6.950	535	5.800	380	4.050	250	2.900	130												
6	6.350	535	6.350	535	5.300	380	3.700	250	2.650	130												
8	4.800	535	4.800	535	4.000	380	2.800	250	2.000	130												
10	3.800	535	3.800	535	3.200	380	2.250	250	1.600	130												
12	3.200	535	3.200	535	2.650	380	1.850	250	1.350	130												
Max cutting depth					<table><tr><td>D</td><td>ap</td></tr><tr><td>≤ 3</td><td>0,15D</td></tr><tr><td>> 3</td><td>0,2D</td></tr></table>		D	ap	≤ 3	0,15D	> 3	0,2D	<table><tr><td>D</td><td>ap</td></tr><tr><td>≤ 6</td><td>0,1D</td></tr><tr><td>> 6</td><td>0,15D</td></tr></table>				D	ap	≤ 6	0,1D	> 6	0,15D
					D	ap																
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