

CUTTING CONDITIONS

Milling | Indexables | Cutting conditions

PFAL BORE

Face milling finishing cutter for aluminium

	Work Material	Component	Material Symbol	Application	Cutting Speed Vc (m/min)		Feed per Tooth fz (mm/t)	Depth of Cut ap (mm)
					BT30	BT40, BT50 HSK63		
N	Aluminium Alloy	~ 12% Si	A7075, A5052, A2017, ADC12	Semi-finishing	1.000 (800 ~ 2.000)	2.000 (1.000 ~ 5.000)	0.08 (0.05 ~ 0.10)	1.5 (1.0 ~ 2.0)
				Finishing			0.06 (0.05 ~ 0.08)	0.5 (0.3 ~ 1.0)
	Aluminium Alloy	~ 13% Si	AC9A, AC98	Semi-finishing	600 (400 ~ 800)		0.08 (0.05 ~ 0.10)	1.5 (1.0 ~ 2.0)
				Finishing			0.06 (0.05 ~ 0.08)	0.5 (0.3 ~ 1.0)