
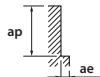


CUTTING CONDITIONS


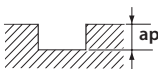
Milling | Endmills | Cutting conditions

CA-RG-EDS

Side milling

	AL A7075		Cu C1100						
	Ø	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)				
1	32.000	220	23.500	220					
2	32.000	420	11.500	215					
3	21.000	700	7.950	250					
4	15.500	725	5.950	280					
5	12.500	760	4.750	295					
6	10.500	830	3.950	310					
8	7.950	890	2.950	350					
10	6.350	995	2.350	365					
12	5.300	1.050	1.950	390					
14	4.500	1.050	1.700	395					
16	3.950	1.050	1.450	390					
18	3.500	1.050	1.300	390					
20	3.150	1.050	1.150	385					
Max cutting depth	<div><table><tr><td>ap</td><td>ae</td></tr><tr><td>1,5D</td><td>0,1D</td></tr></table></div>					ap	ae	1,5D	0,1D
ap	ae								
1,5D	0,1D								
1. Use a high rigidity machine set up. 2. Use soluble oil.									

Slotting

	AL A7075		Cu C1100	
Ø	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)
1	32.000	220	23.500	220
2	23.500	310	11.500	215
3	15.500	515	7.950	250
4	11.500	540	5.950	280
5	9.500	575	4.750	295
6	7.950	630	3.950	310
8	5.950	665	2.950	350
10	4.750	745	2.350	365
12	3.950	790	1.950	390
14	3.400	795	1.700	395
16	2.950	795	1.450	390
18	2.650	795	1.300	390
20	2.350	785	1.150	385
Max cutting depth	<div><div>ap</div><div>1D</div></div> <div></div>			
1. Use a high rigidity machine set up. 2. Use soluble oil.				