
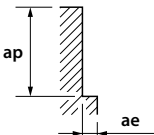


CUTTING CONDITIONS

Milling | Endmills | Cutting conditions

UVXL-TI-5FL

Titanium alloy (Ti-6Al-4V)

| | | | | | | | |
|---|---|---------------|--|----|----|-----------|--------|
|  | Side milling | | | | | | |
| Vc | 60 ~ 80 m/min | | | | | | |
| Ø | S (min ⁻¹) | F (mm/min) | | | | | |
| 12 | 2.100 | 1.050 | | | | | |
| 16 | 1.600 | 920 | | | | | |
| 20 | 1.270 | 760 | | | | | |
| 25 | 1.020 | 587 | | | | | |
| Max cutting depth | <div></div> <table><tr><td>ap</td><td>ae</td></tr><tr><td>≤ 3,75 Dc</td><td>0,1 Dc</td></tr></table> | | | ap | ae | ≤ 3,75 Dc | 0,1 Dc |
| ap | ae | | | | | | |
| ≤ 3,75 Dc | 0,1 Dc | | | | | | |