RECOMMENDED CUTTING CONDITIONS

	Work Material		Grade	Breaker	Cutting Speed **vc** (m/min)	Cutting Width **ae** (mm)	Depth of Cut **ap** (mm)	Feed per Tooth (mm/tooth) Cutting Edge Diameter **D1**				
								ϕ20	**ϕ25–ϕ28**	**ϕ32–ϕ35**	**ϕ40**	**ϕ50–ϕ125**
N	Aluminium Alloy (A6061, A7075)	**Si<5%**	**TF15 LC15TF**	**GL**	1000 (200–3000)	<0.25 D1	<5	<0.05	<0.25			
							<10	<0.05	<0.2			
							<14.5	<0.05	<0.15			
						<0.5 D1	<5	<0.05	<0.25			
							<10	–	<0.2			
							<14.5	–	<0.15			
						<0.75 D1	<5	<0.05	<0.25			
							<10	–	<0.2			
							<14.5	–	<0.15			
						D1	<5	<0.05	<0.25			
							<10	–	–			
							<14.5	–	–			
	Aluminium Alloy (A6061, A7075)	**Si<5%**	**TF15 MP9120**	**GM**	1000 (200–3000)	<0.25 D1	<5	<0.05	<0.35	<0.35	<0.4	<0.4
							<10	<0.05	<0.3	<0.3	<0.35	<0.35
							<14.5	<0.05	<0.25	<0.25	<0.3	<0.3
						<0.5 D1	<5	<0.05	<0.35	<0.35	<0.35	<0.4
							<10	–	<0.3	<0.3	<0.3	<0.35
							<14.5	–	<0.2	<0.25	<0.25	<0.3
						<0.75 D1	<5	<0.05	<0.3	<0.3	<0.3	<0.35
							<10	–	<0.25	<0.25	<0.25	<0.3
							<14.5	–	<0.2	<0.2	<0.2	<0.25
						D1	<5	<0.05	<0.25	<0.25	<0.3	<0.35
							<10	–	–	–	–	–
							<14.5	–	–	–	–	–
	Aluminium Alloy (AC4B) Aluminium Alloy (ADC12, A390)	5%≤Si≤10% **Si>10%**	**MP9120**	**GM**	200 (200–3000)	<0.25 D1	<5	<0.05	<0.35	<0.35	<0.4	<0.4
							<10	<0.05	<0.3	<0.3	<0.35	<0.35
							<14.5	<0.05	<0.25	<0.25	<0.3	<0.3
						<0.5 D1	<5	<0.05	<0.35	<0.35	<0.35	<0.4
							<10	–	<0.3	<0.3	<0.3	<0.35
							<14.5	–	<0.2	<0.25	<0.25	<0.3
						<0.75 D1	<5	<0.05	<0.3	<0.3	<0.3	<0.35
							<10	–	<0.25	<0.25	<0.25	<0.3
							<14.5	–	<0.2	<0.2	<0.2	<0.25
						D1	<5	<0.05	<0.25	<0.25	<0.3	<0.35
							<10	–	–	–	–	–
							<14.5	–	–	–	–	–
S	Titanium Alloy (Ti6Al4V)	–	**MP9120**	**GM**	40 (30–60)	<0.25 D1	<5	<0.05	<0.1			
							<10	<0.05	<0.1			
							<14.5	<0.05	<0.1			
						<0.5 D1	<5	<0.05	<0.08	<0.1	<0.1	<0.1
							<10	–	<0.08	<0.1	<0.1	<0.1
							<14.5	–	<0.08	<0.1	<0.1	<0.1
						<0.75 D1	<5	<0.05	<0.05	<0.08	<0.1	<0.1
							<10	–	<0.05	<0.08	<0.1	<0.1
							<14.5	–	<0.05	<0.08	<0.1	<0.1
						D1	<5	<0.05	<0.05	<0.05	<0.05	<0.05
							<10	–	–	–	–	–
							<14.5	–	–	–	–	–

(Note 1) The above cutting conditions are determined based on high workpiece and machine rigidity, where no vibration occurred. If vibrations occur make adjustments according to the machining conditions.
(Note 2) Note, vibrations may occur in the following conditions.
When using long tool overhang.
When pocket machining corner radii.
When the workpiece has poor clamping rigidity or when the machine rigidity or workpiece rigidity is low, vibrations can occur easily, if so, reduce cutting conditions such as width and depth of cut and feed per tooth.

SPARE PARTS ➢ M001
TECHNICAL DATA ➢ N001