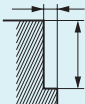
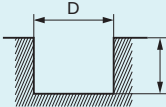


RECOMMENDED CUTTING CONDITIONS

Shoulder milling

Work material	Aluminium alloy		Aluminium cast, Copper, Copper alloys	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
1	40000	600	40000	460
2	40000	1100	38000	850
3	32000	1400	25000	950
4	24000	1500	19000	1000
5	19000	1600	15000	1000
6	16000	1900	13000	1100
8	12000	1900	9500	1200
10	9500	1900	7600	1200
12	8000	1900	6400	1200
16	6000	1900	4800	1200
20	4800	1500	3800	1000
Depth of cut	$\leq 0.2D$ ($D < \phi 3$) $\leq 0.5D$ ($D \geq \phi 3$)		 $\leq 1D$ D: Dia.	

Slotting

Work material	Aluminium alloy		Aluminium cast, Copper, Copper alloys	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
1	40000	460	40000	350
2	38000	850	32000	550
3	25000	950	21000	600
4	19000	1000	16000	650
5	15000	1000	13000	700
6	13000	1100	11000	750
8	9500	1200	8000	800
10	7600	1200	6400	800
12	6400	1200	5300	800
16	4800	1000	4000	720
20	3800	970	3200	660
Depth of cut	 D: Dia.			

- 1) When cutting a very hard workpiece, reduce the feed rate.
- 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.