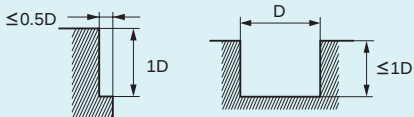


RECOMMENDED CUTTING CONDITIONS

Work material	Aluminium alloy		
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	
		Side milling	Slotting
3	40000	1800	1600
4	36000	2400	2100
5	30000	3000	2700
6	27000	3200	2800
8	20000	3400	3000
10	16000	3600	3200
12	13000	3600	3200
16	10000	3600	3200
20	8000	3300	3000
Depth of cut	 D: Dia.		

- 1) This table shows the cutting condition with less than 4D overhang length. If more than 4D, spindle speed, feed rate and depth of cut should be reduced.
- 2) If the rigidity of the machine or the workpiece installation is very low, or chattering and noise are generated, please reduce the revolution and the feed rate proportionately.
- 3) Water-soluble cutting fluid is recommended.
- 4) Climb cutting is recommended for side milling.