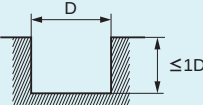


RECOMMENDED CUTTING CONDITIONS

Shoulder milling

Work material	Aluminium alloy A7075		Aluminium cast AC4B		
	Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
3	40000	2700	25000	1100	
4	36000	2700	20000	1100	
5	30000	5400	16000	2200	
6	27000	6100	13000	2300	
8	20000	6000	10000	2400	
10	16000	5800	8000	2300	
12	13000	5300	6500	2100	
16	10000	5100	5000	2000	
20	8000	4800	4000	1900	
25	6400	4600	3200	1800	
Depth of cut	≤0.25D ≤1.5D D: Dia.				

Slotting

Work material	Aluminium alloy A7075		Aluminium cast AC4B		
	Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
3	30000	1800	16000	700	
4	24000	2200	12000	900	
5	19000	2300	10000	900	
6	16000	2400	8000	1000	
8	12000	2500	6000	1000	
10	9500	2600	5000	1100	
Depth of cut	 D: Dia.				

- 1) 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, or set a smaller depth of cut.
- 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 3) Water-soluble cutting fluid is recommended.
- 4) Climb cutting is recommended for side milling.