

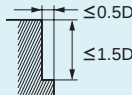
VIOLET END MILLS

VASFPR

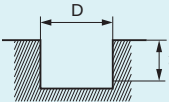
Roughing type, Short cut length, 4—6 flute, Fine pitch form

RECOMMENDED CUTTING CONDITIONS

Shoulder milling

Work material	Structural steel, Cast iron, Carbon steel		Carbon steel, Alloy steel (20—30HRC)		Alloy steel, Tool steel, Pre-hardened steel (30—35HRC)		Austenitic stainless steel, Alloy steel, Tool steel (35—40HRC)	
	Ck45, GG25, Cf53		Ck55		X40CrMoV51, X210Cr12		X5CrNi1810, X5CrNiMo17-12-2	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
5	2800	140	2200	120	1500	80	1300	70
6	2600	180	2000	140	1400	90	1200	80
8	2200	230	1700	180	1200	130	990	100
10	1750	330	1350	250	950	160	800	130
12	1450	330	1100	260	800	180	660	140
16	1100	330	850	260	600	180	500	140
20	880	340	680	260	480	180	400	140
25	700	330	540	250	380	170	320	140
30	580	300	450	230	320	170	270	140
40	350	210	270	170	190	120	160	100
50	250	170	190	130	130	90	110	75
Depth of cut	 D:Dia							

Slotting

Work material	Structural steel, Cast iron, Carbon steel		Carbon steel, Alloy steel (20—30HRC)		Alloy steel, Tool steel, Pre-hardened steel (30—35HRC)		Austenitic stainless steel, Alloy steel, Tool steel (35—40HRC)	
	Ck45, GG25, Cf53		Ck55		X40CrMoV51, X210Cr12		X5CrNi1810, X5CrNiMo17-12-2	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
5	2100	100	1650	80	1150	50	960	35
6	2000	130	1550	100	1050	60	900	45
8	1600	160	1300	130	920	90	760	60
10	1300	220	1000	175	730	110	610	80
12	1050	230	850	190	610	130	500	85
16	800	230	640	190	460	130	380	85
20	640	230	510	180	370	130	300	85
25	510	200	410	160	290	110	240	80
30	420	190	320	140	210	90	180	75
40	280	140	210	110	140	70	120	60
50	190	110	150	90	95	55	85	45
Depth of cut	 D: Dia							

- 1) Supply cutting fluid sufficiently during cutting. For dry-cutting, decrease the revolution and feed rate proportionately by 20—50%.
- 2) For smaller depths and widths of cut, the revolution may be increased by 10—20% and the feed rate by 10—40%.
- 3) When drilling, please set the feed rate at 1/3 or below the values above.
- 4) 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.