

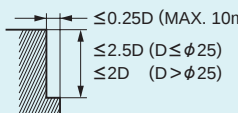
VIOLET END MILLS

VAMFPR

Roughing type, Medium 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	2600	90	2000	70	1400	50	1200	40
6	2500	100	1900	90	1300	50	1100	50
8	2000	170	1600	130	1100	90	930	80
10	1650	220	1300	170	900	100	750	90
12	1400	260	1000	210	750	140	620	120
16	1000	290	800	230	560	160	470	130
20	830	300	640	230	450	160	380	130
25	660	290	510	220	360	160	300	130
30	550	270	420	210	300	140	250	130
40	330	180	250	140	180	100	150	90
50	240	160	180	120	120	80	100	70
Depth of cut	 $\leq 0.25D$ (MAX. 10mm) $\leq 2.5D$ ($D \leq \phi 25$) $\leq 2D$ ($D > \phi 25$) D: Dia.							

- 1) Supply cutting fluid sufficiently during cutting. For dry-cutting, decrease the revolution and feed rate proportionately by 20—50%.
- 2) When the diameter exceeds 30 and the metal removal is less than the quantity shown in the table, the revolution and feed rate may be increased proportionately by 10—40%.
- 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.