

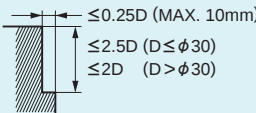
VIOLET END MILLS

VAJR

Roughing type, Semi long cut length, 4—6 flute, Medium 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		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)
10	1400	170	1100	130	760	80	640	65
12	1200	170	900	130	640	90	530	80
16	870	170	680	130	480	90	400	80
20	700	170	540	130	380	90	320	80
25	560	170	430	120	300	90	260	80
30	460	155	360	120	260	80	220	65
40	280	105	220	90	150	65	130	65
50	200	90	150	65	100	50	90	40
Depth of cut								

- 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.