

VIOLET END MILLS

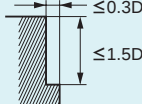
HSS

VAMH

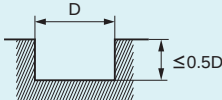
End mill, Medium cut length, 2—4 flute, High helix

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	3600	140	2700	100	1800	70	1500	60
6	3200	200	2400	150	1600	100	1300	80
8	2400	220	1800	160	1200	110	1000	90
10	1900	230	1400	170	960	120	800	100
12	1600	240	1200	180	800	120	660	100
16	1200	220	900	160	600	110	500	90
20	950	200	720	150	480	100	400	85
25	760	220	570	170	380	110	320	95
30	640	200	480	150	320	100	270	85
Depth of cut								

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	2900	105	2400	75	1500	50	1200	45
6	2600	150	2100	110	1300	75	1000	60
8	2000	165	1600	120	1000	80	800	70
10	1600	170	1300	130	800	90	640	75
12	1300	180	1100	135	660	90	530	75
16	1000	165	800	120	500	80	400	70
20	720	150	640	110	400	75	320	65
25	570	165	450	130	320	80	230	70
30	480	150	370	110	270	75	190	65
Depth of cut								

- 1) Supply cutting fluid sufficiently during slotting. When slotting with dry cut, decrease the revolution and feed rate proportionately by 20—30%.
- 2) 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.