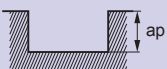
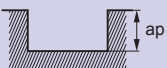


INDEXABLE HEAD END MILLS**IMX-R4F**

Roughing head, 4 flute

RECOMMENDED CUTTING CONDITIONS**Slotting**

Dia. (mm)	Cutting speed (m/min)	Revolution (min ⁻¹)	Feed (mm/tooth)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min ⁻¹)	Feed (mm/tooth)	Feed rate (mm/min)	Depth of cut ap (mm)	Cutting speed (m/min)	Revolution (min ⁻¹)	Feed (mm/tooth)	Feed rate (mm/min)	Depth of cut ap (mm)
10	120	3800	0.045	680	5	100	3200	0.03	380	5	60	1900	0.02	150	4
12	120	3200	0.045	580	6	100	2700	0.0325	350	6	60	1600	0.025	160	4.8
16	120	2400	0.05	480	8	100	2000	0.0375	300	8	60	1200	0.03	140	6.4
20	120	1900	0.05	380	10	100	1600	0.0375	240	10	60	950	0.034	130	8
25	120	1500	0.06	360	12	100	1300	0.0375	200	12	60	760	0.034	100	10
Depth of cut															

Dia. (mm)	Cutting speed (m/min)	Revolution (min ⁻¹)	Feed (mm/tooth)	Feed rate (mm/min)	Depth of cut ap (mm)
10	40	1300	0.016	83	4
12	40	1100	0.02	88	4.8
16	40	800	0.024	77	6.4
20	40	640	0.0272	70	8
25	40	510	0.0272	55	10
Depth of cut					

- 1) For stainless steel, titanium alloy and heat resistant alloy, the use of water-soluble coolant is effective.
- 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 3) Vibration may occur if the rigidity of machine or workpiece is low.
In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.