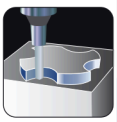
MILLING CONDITIONS

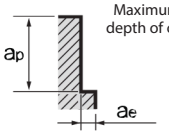
3 flute corner radius endmill for pocket milling

SIDE MILLING

HYP-AL-PKE, AL-PKE-DLC



	Aluminium alloy A7075				Aluminium Alloy Casting Die Casting				Magnesium Alloy Copper Alloy			
	Regular Milling		High Speed Milling		Regular Milling		High Speed Milling		Regular Milling		High Speed Milling	
Vc	200 m/min		500 m/min		200 m/min		300 m/min		100 m/min		200 m/min	
ø	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)
6	10600	1910	26550	4780	10600	1910	15900	2860	5300	950	10600	1910
8	7950	1910	19900	4780	7950	1910	11950	2870	4000	960	7950	1910
10	6350	1910	15900	4770	6350	1910	9550	2870	3200	960	6350	1910
12	5300	1910	13250	4770	5300	1910	7950	2860	2650	950	5300	1910
16	4000	1920	9950	4780	4000	1920	5950	2860	2000	960	4000	1920
Maximum depth of cut	ap=1D ae=0.2D		ap=1D ae=0.1D		ap=1D ae=0.2D		ap=1D ae=0.1D		ap=1D ae=0.2D		ap=1D ae=0.1D	



SLOTTING

HYP-AL-PKE, AL-PKE-DLC

	Aluminium alloy A7075				Aluminium Alloy Casting Die Casting				Magnesium Alloy Copper Alloy			
	Regular Milling		High Speed Milling		Regular Milling		High Speed Milling		Regular Milling		High Speed Milling	
Vc	200 m/min		500 m/min		200 m/min		300 m/min		100 m/min		200 m/min	
ø	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)
6	10600	1270	26550	3190	10600	1270	15900	1910	5300	640	10600	1270
8	7950	1430	19900	3580	7950	1430	11950	2150	4000	720	7950	1430
10	6350	1520	15900	3820	6350	1520	9550	2290	3200	770	6350	1520
12	5300	1590	13250	3980	5300	1590	7950	2390	2650	800	5300	1590
16	4000	1440	9950	3580	4000	1440	5950	2140	2000	720	4000	1440
Maximum depth of cut	= < D x 0.5		= < D x 0.25		= < D x 0.5		= < D x 0.25		= < D x 0.5		= < D x 0.25