
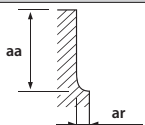


CUTTING CONDITIONS


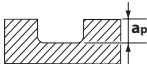
Milling | Endmills | Cutting conditions

CA-MFE

High speed side milling

	AL A7075		AC <Si 13%		Cu C1100																										
	Ø	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)																								
	10	16.000	4.300	9.600	2.600	6.350	1.150																								
	12	13.300	4.400	8.000	2.650	5.300	1.250																								
	14	11.500	4.400	6.900	2.650	4.500	1.250																								
	18	8.850	4.400	5.300	2.650	3.500	1.250																								
	22	7.400	4.000	4.500	2.400	3.000	1.200																								
Max cutting depth	<table border="1"><tr><td>ap</td><td>ae</td></tr><tr><td>1,2D</td><td>0,1D</td></tr></table>		ap	ae	1,2D	0,1D			<table border="1"><tr><td>max depth</td><td>ap</td><td>ae</td><td>S</td><td>F</td></tr><tr><td>Dx4</td><td>1,2D</td><td>0,100D</td><td>100%</td><td>100%</td></tr><tr><td>Dx5</td><td>1,2D</td><td>0,050D</td><td>60-80%</td><td>60-80%</td></tr><tr><td>Dx6</td><td>1,2D</td><td>0,025D</td><td>40-60%</td><td>40-60%</td></tr></table>			max depth	ap	ae	S	F	Dx4	1,2D	0,100D	100%	100%	Dx5	1,2D	0,050D	60-80%	60-80%	Dx6	1,2D	0,025D	40-60%	40-60%
	ap	ae																													
1,2D	0,1D																														
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<div>1. Use a rigid and precise machine and holder.</div> <div>2. When chattering occurs, reduce the speed and feed simultaneously.</div> <div>3. Use a suitable cutting fluid with high smoke retardant properties.</div>																															

High speed slotting milling

	AL A7075		AC <Si 13%																				
	Ø	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)																		
	10	16.000	2.800	9.600	1.700																		
	12	13.300	2.950	8.000	1.750																		
	14	11.500	3.000	6.800	1.800																		
	18	8.850	3.000	5.300	1.800																		
	22	7.400	3.000	4.450	1.800																		
Max cutting depth	<table border="1"><tr><td>ap</td></tr><tr><td>0,1D</td></tr></table>		ap	0,1D		<table border="1"><tr><td>max depth</td><td>ap</td><td>S</td><td>F</td></tr><tr><td>Dx4</td><td>1D</td><td>100%</td><td>100%</td></tr><tr><td>Dx5</td><td>0,50D</td><td>60-80%</td><td>60-80%</td></tr><tr><td>Dx6</td><td>0,025D</td><td>40-60%</td><td>40-60%</td></tr></table>		max depth	ap	S	F	Dx4	1D	100%	100%	Dx5	0,50D	60-80%	60-80%	Dx6	0,025D	40-60%	40-60%
	ap																						
	0,1D																						
	max depth	ap	S	F																			
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