
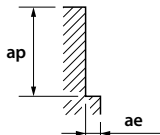
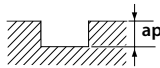


# CUTTING CONDITIONS

Milling | Endmills | Cutting conditions

## UVX-TI-5FL SAFE-LOCK®

Titanium alloy (Ti-6Al-4V)

	Side milling		Slotting							
Vc	60 ~ 80 m/min		30 ~ 50 m/min							
Ø	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)						
12	1.900	855	1.350	340						
16	1.400	630	990	250						
20	1.100	600	800	240						
25	900	500	640	192						
Max cutting depth		<table border="1"><tr><td>ap</td><td>ae</td></tr><tr><td>≤ 1,8 Dc</td><td>0,2 Dc</td></tr></table>	ap	ae	≤ 1,8 Dc	0,2 Dc		<table border="1"><tr><td>ap</td></tr><tr><td>≤ 1 Dc</td></tr></table>	ap	≤ 1 Dc
ap	ae									
≤ 1,8 Dc	0,2 Dc									
ap										
≤ 1 Dc										