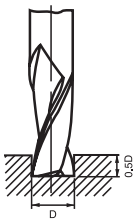
Cutting Conditions

NACHI นาชิ

Grooving



Side Milling



1. When dry milling, reduce the rotation and feed to 70% of table values.
2. Adjust milling condition when an unusual vibration, different sound occur by cutting.

B

• SUPER HARD End Mills Two Flutes L6230

Work Material / Milling Condition / Dia. of Mill mm	Rolled Steels SS Carbon Steels S C		Alloy Steels SCM Pre-Hardended Steels NAK, HPM		Mold Steels SKD Stainless Steels		Nickel Alloys Titanium Alloys		Cast Irons FC, FCD (~200HB)		Aluminium Aluminium Alloys Copper Alloys	
	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min
2	4000	80	2800	51	2000	28	1600	19	4800	230	9600	420
3	2700	84	1900	53	1300	30	1100	20	3200	240	6400	450
5	1600	84	1100	53	800	30	640	20	1900	240	3800	450
6	1300	84	930	53	660	30	530	20	1600	240	3200	450
8	1000	84	700	53	500	30	400	20	1200	240	2400	450
10	800	86	560	54	400	30	320	20	960	250	1900	450
12	660	85	460	54	330	30	270	20	800	240	1600	450
15	530	85	370	54	270	30	210	20	640	240	1300	450
20	400	80	280	50	200	28	160	19	480	230	960	420
25	320	61	220	38	160	21	130	15	380	180	760	320
30	270	49	190	31	130	17	110	12	320	140	640	260
40	200	34	140	21	100	12	80	8	240	96	480	180
50	160	17	110	11	80	6	60	4	190	50	380	90

หมายเหตุ : รุ่น **Super Hard End Mills 2 Flutes Long** L6232 ใช้ความเร็วรอบเท่าเดิม แต่ลด Feed ลง 50% ⟸ **L6232**

• G Standard End Mills Two Flutes L6272P

Work Material / Milling Condition / Dia. of Mill mm	Rolled Steels SS Carbon Steels S C		Alloy Steels SCM Pre-Hardended Steels NAK, HPM		Mold Steels SKD Stainless Steels		Nickel Alloys Titanium Alloys		Cast Irons FC, FCD (~200HB)		Aluminium Aluminium Alloys Copper Alloys	
	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min
2	5600	130	4000	88	3200	54	2800	39	6400	370	13000	680
3	3700	140	2700	90	2100	58	1900	43	4200	390	8500	720
5	2200	140	1600	90	1300	55	1100	41	2500	380	5100	700
6	1900	140	1300	90	1100	57	930	43	2100	390	4200	710
8	1400	140	1000	90	800	57	700	43	1600	390	3200	710
10	1100	140	800	93	640	57	560	43	1300	400	2500	730
12	930	140	660	92	530	57	460	43	1100	390	2100	720
15	740	140	530	92	420	57	370	43	850	390	1700	720
20	560	130	400	86	320	53	280	40	640	370	1300	670
25	450	100	320	66	250	41	220	31	510	280	1000	520
30	370	82	270	53	210	33	190	25	420	230	850	410
40	280	56	200	36	160	23	140	17	320	150	640	280
50	220	29	160	19	130	12	110	9	250	79	510	150

• Victory End Mills Two Flutes L6478
• SG-FAX End Mills Two Flutes L7472P

Work Material / Milling Condition / Dia. of Mill mm	Rolled Steels SS Carbon Steels S C		Alloy Steels SCM Pre-Hardended Steels NAK, HPM		Mold Steels SKD Stainless Steels		Nickel Alloys Titanium Alloys		Cast Irons FC, FCD (~200HB)		Aluminium Aluminium Alloys Copper Alloys	
	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min	Rotation min^{-1}	Feed mm/min
2	6400	150	4800	110	4000	68	3200	45	7200	420	14000	720
3	4200	160	3200	110	2700	72	2100	49	4800	440	9000	760
5	2500	160	1900	110	1600	69	1300	47	2900	430	5400	740
6	2100	160	1600	110	1300	71	1100	49	2400	440	4500	760
8	1600	160	1200	110	1000	70	800	49	1800	440	3400	760
10	1300	170	960	110	800	72	640	49	1400	450	2700	770
12	1100	160	800	110	660	71	530	49	1200	440	2300	760
15	850	160	640	110	530	71	420	49	960	440	1800	760
20	640	150	480	100	400	67	320	46	720	410	1400	720
25	510	120	380	79	320	51	250	35	570	320	1100	550
30	420	94	320	63	270	41	210	28	480	250	900	440
40	320	64	240	43	200	28	160	19	360	170	680	300
50	250	33	190	22	160	14	130	10	290	90	540	140