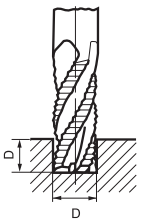
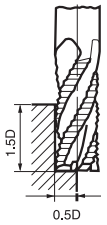
Cutting Conditions

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.

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B

• HEAVY End Mills L6366/L6368

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
3	2700	150	1900	95	1300	54	1100	37	3200	440	6400	810
5	1600	150	1100	95	800	52	640	36	1900	430	3800	780
6	1300	150	930	95	660	53	530	37	1600	440	3200	800
8	1000	150	700	95	500	53	400	37	1200	440	2400	800
10	800	150	560	97	400	54	320	37	960	450	1900	820
12	660	150	460	97	330	54	270	37	800	440	1600	810
15	530	150	370	96	270	54	210	37	640	440	1300	810
20	400	140	280	90	200	50	160	34	480	410	960	760
25	320	110	220	69	160	38	130	26	380	320	760	580
30	270	120	190	74	130	41	110	28	320	340	640	620
40	200	80	140	51	100	28	80	19	240	230	480	420
50	160	41	110	26	80	14	64	10	190	120	380	220

หมายเหตุ : รุ่น **Heavy End Mils Long** **L6368** ใช้ความเร็วรอบเท่าเดิม แต่ลด Feed ลง 40% (ใช้ค่า Feed 60% ของค่าในตาราง)

• Roughing End Mills Medium L6304/L6306

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
6	1300	100	930	63	660	35	530	25	1600	130	3200	530
8	1000	100	700	63	500	35	400	25	1200	130	2400	530
10	800	100	560	65	400	36	320	25	960	140	1900	550
12	660	100	460	64	330	36	270	25	800	130	1600	540
15	530	100	370	64	270	36	210	25	640	130	1300	540
20	400	96	280	60	200	33	160	23	480	130	960	520
25	320	91	220	57	160	32	130	22	380	130	760	500
30	270	82	190	52	130	29	110	20	320	120	640	460
40	200	53	140	33	100	18	80	13	240	77	480	300
50	160	37	110	23	80	13	64	8	190	54	380	200

หมายเหตุ : รุ่น **Roughing End Mills Medium** **L6306** ใช้ความเร็วรอบเท่าเดิม แต่ลด Feed ลง 25% (ใช้ค่า Feed 75% ของค่าในตาราง)

• SG-FAX Roughing End Mills Fine Pitch Medium L7302P/L7304P

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
6	2100	160	1600	100	1300	68	1100	47	2400	190	4500	730
8	1600	150	1200	100	1000	67	800	46	1800	190	3400	720
10	1300	160	960	110	800	69	640	47	1400	200	2700	740
12	1100	200	800	130	660	86	530	59	1200	240	2300	920
15	850	200	640	130	530	86	420	59	960	240	1800	920
20	640	180	480	120	400	81	320	55	720	240	1400	890
25	510	190	380	130	320	85	250	58	570	260	1100	950
30	420	170	320	120	270	76	210	52	480	240	900	860
40	320	110	240	76	200	49	160	34	360	150	680	560
50	250	71	190	48	160	31	130	21	290	100	540	350

หมายเหตุ : รุ่น **SG-FAX Roughing End Mills Fine Pitch Medium** **L7302P** ใช้ความเร็วรอบเท่าเดิม แต่ลด Feed ลง 25% (ใช้ค่า Feed 75% ของค่าในตาราง)