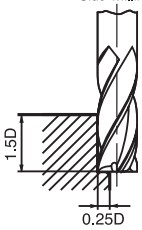
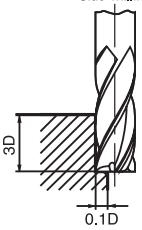
Cutting Conditions

Regular Length End Mill
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.

Long End Mill
Side Milling



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• SUPER HARD End Mills Four Flutes L6210

Work Material / Milling Condition	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	
Dia. of Mill mm	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	130	1900	79	1300	45	1100	31	3200	360	6400	670
5	1600	130	1100	79	800	44	640	31	1900	360	3800	650
6	1300	130	930	79	660	44	530	31	1600	360	3200	670
8	1000	130	700	79	500	44	400	31	1200	360	2400	670
10	800	130	560	81	400	45	320	31	960	370	1900	680
12	660	130	460	81	330	45	270	31	800	370	1600	670
15	530	130	370	80	270	45	210	31	640	370	1300	670
20	400	120	280	75	200	42	160	29	480	340	960	630
25	320	92	220	58	160	32	130	22	380	260	760	480
30	270	73	190	46	130	26	110	18	320	210	640	390
40	200	50	140	32	100	18	80	12	240	140	480	270
50	160	26	110	16	80	9	60	6	190	74	380	140

หมายเหตุ : รุ่น **Super Hard End Mills 4 Flutes Long** L6212 ใช้ความเร็วรอบเท่าเดิม แต่ลด Feed ลง 40% (ใช้ค่า Feed 60% ของตาราง)

• G Standard End Mills Four Flutes L6274P

Work Material / Milling Condition	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	
Dia. of Mill mm	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	3700	180	2700	110	2100	72	1900	54	4200	490	8500	900
5	2200	180	1600	110	1300	69	1100	52	2500	490	5100	870
6	1900	180	1300	110	1100	71	930	54	2100	490	4200	890
8	1400	180	1000	110	800	71	700	54	1600	490	3200	890
10	1100	180	800	120	640	72	560	54	1300	500	2500	910
12	930	180	660	120	530	71	460	54	1100	490	2100	900
15	740	180	530	110	420	71	370	54	850	490	1700	900
20	560	170	400	110	320	67	280	50	640	460	1300	840
25	450	130	320	82	250	51	220	38	510	350	1000	650
30	370	100	270	66	210	41	190	31	420	280	850	520
40	280	70	200	45	160	28	140	21	320	190	640	350
50	220	36	160	23	130	14	110	11	250	100	510	180

• Victory End Mills Four Flutes L6480
• SG-FAX End Mills Four Flutes L7474P

Work Material / Milling Condition	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	
Dia. of Mill mm	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	4200	200	3200	140	2700	90	2100	61	4800	550	9000	950
5	2500	200	1900	140	1600	86	1300	59	2900	550	5400	920
6	2100	200	1600	140	1300	88	1100	61	2400	550	4500	950
8	1600	200	1200	140	1000	88	800	60	1800	550	3400	950
10	1300	210	960	140	800	90	640	62	1400	550	2700	970
12	1100	200	800	140	660	89	530	61	1200	550	2300	950
15	850	200	640	140	530	89	420	61	960	550	1800	950
20	640	190	480	130	400	84	320	57	720	520	1400	890
25	510	150	380	100	320	64	250	44	570	400	1100	690
30	420	120	320	79	270	51	210	35	480	320	900	550