

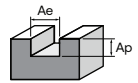
Recommended Cutting Data



Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

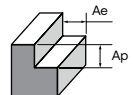


NiTiCo 30 DP/DH with Weldon Endmills, 4 Flutes - C47, C64



Slotting	K		P		M		S							
Working Material	Grey Cast Iron		Carbon Steel		Alloy steel		Stainless Steel		Titanium Alloy		Nickel Alloy		Cobalt Alloy	
Properties	-		-		520 < Rm < 1200		High Machinability		-		-		-	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D		0.50 × D		1.00 × D		1.00 × D	
Cutting Width, ae	1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D		0.15 × D		1.00 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
6	190	0.020	220	0.020	175	0.020	130	0.022	65	0.032	100	0.032	90	0.030
8		0.027		0.027		0.027		0.030		0.042		0.042		0.040
10		0.035		0.035		0.035		0.039		0.054		0.054		0.052
12		0.043		0.043		0.042		0.048		0.067		0.067		0.064
14		0.049		0.050		0.048		0.055		0.076		0.076		0.072
16		0.056		0.057		0.054		0.062		0.085		0.085		0.081
18		0.062		0.063		0.060		0.068		0.093		0.093		0.089
20		0.069		0.069		0.066		0.075		0.102		0.102		0.097

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Side Milling	K		P		M		S							
Working Material	Grey Cast Iron		Carbon Steel		Alloy steel		Stainless Steel		Titanium Alloy		Nickel Alloy		Cobalt Alloy	
Properties	-		-		520 < Rm < 1200		High Machinability		-		-		-	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	0.25 × D		0.25 × D		0.20 × D		0.18 × D		0.15 × D		0.15 × D		0.10 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
6		0.035		0.037		0.034		0.036		0.043		0.002		0.002
8		0.048		0.050		0.046		0.048		0.059		0.003		0.003
10		0.060		0.063		0.059		0.061		0.075		0.005		0.005
12		0.075		0.076		0.072		0.075		0.093		0.007		0.007
14		0.086		0.087		0.084		0.086		0.106		0.010		0.009
16		0.095		0.096		0.093		0.095		0.119		0.012		0.011
18		0.103		0.105		0.102		0.103		0.131		0.015		0.014
20		0.113		0.116		0.111		0.113		0.141		0.017		0.016