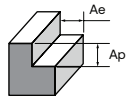


# Recommended Cutting Data



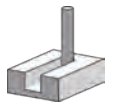
Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



## NiTiCo 30 DH Standard Internal Oil Hole, 2xD, Weldon, Recess, 5 Flutes - K50

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		0.15 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
4	265	0.017	295	0.017	240	0.018	135	0.017	90	0.022	45	0.022	35	0.021
5		0.021		0.022		0.024		0.022		0.028		0.028		0.027
6		0.026		0.027		0.029		0.027		0.034		0.034		0.032
8		0.036		0.037		0.040		0.037		0.047		0.047		0.045
10		0.047		0.047		0.052		0.047		0.060		0.060		0.057
12		0.057		0.057		0.065		0.057		0.074		0.074		0.070
16		0.074		0.073		0.082		0.072		0.093		0.093		0.088
20		0.085		0.089		0.097		0.085		0.111		0.111		0.105

## NiTiCo 30 DH Standard Internal Oil Hole, 2xD, Weldon, Recess, 5 Flutes - K50



Trochoidal Milling	K		P				M		S					
Working Material	Grey Cast Iron		Carbon Steel		Alloy Steel		Stainless Steel		Titanium Alloy		Nickel Alloy		Cobalt Alloy	
Proprietà	-		-		520 < Rm < 1200		High Machinability		-		-		-	
Maximum Slot Width	1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D	
Cutting depth, ap	1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D	
Cutting Width, ae	0.15 × D		0.15 × D		0.12 × D		0.10 × D		0.10 × D		0.10 × D		0.10 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
4	315	0.018	345	0.018	290	0.020	170	0.019	120	0.028	60	0.028	47	0.027
5		0.024		0.024		0.028		0.026		0.036		0.036		0.034
6		0.031		0.032		0.037		0.035		0.045		0.045		0.043
8		0.044		0.044		0.052		0.048		0.063		0.063		0.060
10		0.059		0.059		0.071		0.064		0.082		0.082		0.078
12		0.076		0.075		0.094		0.084		0.108		0.108		0.103
16		0.094		0.094		0.116		0.104		0.133		0.133		0.126
20		0.109		0.107		0.131		0.117		0.157		0.157		0.149