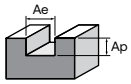
Recommended Cutting Data

HPMT

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

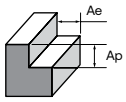
P K P K

Plunge-Mill Endmills, 3 Flutes - G10, G12



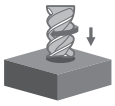
Slotting	K		P					
Working Material	Grey Cast Iron		Carbon steel		Alloy steel		Prehardened steel	
Properties	-		-		520 < Rm < 1200		35 ≤ HRC < 45	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		0.80 × D	
Cutting Width, ae	1.00 × D		1.00 × D		0.30 x D		1.00 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
1	170	0.003	200	0.003	160	0.003	150	0.003
2		0.007		0.007		0.007		0.007
3		0.010		0.010		0.010		0.010
4		0.013		0.013		0.013		0.013
5		0.018		0.018		0.018		0.018
6		0.021		0.021		0.021		0.021
8		0.029		0.029		0.029		0.029
10		0.037		0.036		0.037		0.036
12		0.045		0.045		0.045		0.045
16		0.060		0.059		0.059		0.059

Plunge-Mill Endmills, 3 Flutes - G10, G12



Side Milling	K		P					
Working Material	Grey Cast Iron		Carbon steel		Alloy steel		Prehardened steel	
Properties	-		-		520 < Rm < 1200		35 ≤ HRC < 45	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	0.25 × D		0.25 × D		0.25 × D		0.18 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
1	250	0.008	280	0.006	230	0.007	190	0.006
2		0.011		0.010		0.010		0.010
3		0.018		0.019		0.015		0.015
4		0.024		0.025		0.022		0.021
5		0.032		0.033		0.028		0.026
6		0.040		0.040		0.034		0.034
8		0.054		0.054		0.047		0.046
10		0.069		0.068		0.062		0.062
12		0.082		0.082		0.077		0.077
16		0.094		0.103		0.096		0.088

Plunge-Mill Endmills, 3 Flutes - G10, G12



Plunging	K		P			
Working Material	Grey Cast Iron		Carbon steel		Alloy steel	
Properties	-		-		520 < Rm < 1200	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	-		-		-	
D	Vc	Fz	Vc	Fz	Vc	Fz
1	150	0.008	150	0.010	130	0.008
2		0.016		0.018		0.016
3		0.025		0.028		0.024
4		0.035		0.038		0.033
5		0.044		0.048		0.042
6		0.054		0.059		0.052
8		0.074		0.080		0.070
10		0.094		0.101		0.090
12		0.118		0.126		0.113
16		0.151		0.144		0.144