

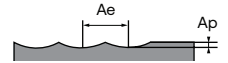
Recommended Cutting Data



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

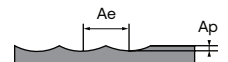


AL BN Ballnose Cutters, 2 Flutes - G74, G75



Roughing	N						O	
Working Material	Wrought Aluminium		Cast Aluminium		Copper alloy		Thermoplastic	
Properties	Si < 9%		Si ≥ 9%		-		-	
Cutting depth, ap	0.10 × D		0.10 × D		0.10 × D		0.10 × D	
Cutting Width, ae	0.35 × D		0.35 × D		0.30 × D		0.35 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
3	450	0.027	400	0.023	350	0.019	380	0.020
4		0.037		0.032		0.026		0.027
5		0.048		0.041		0.033		0.035
6		0.059		0.050		0.041		0.043
8		0.080		0.069		0.057		0.059
10		0.102		0.088		0.074		0.076
12		0.126		0.108		0.092		0.094
16		0.164		0.141		0.119		0.122
20		0.202		0.173		0.144		0.149

AL BN Ballnose Cutters, 2 Flutes - G74, G75



Finishing	N						O	
Working Material	Wrought Aluminium		Cast Aluminium		Copper alloy		Thermoplastic	
Properties	Si < 9%		Si ≥ 9%		-		-	
Cutting depth, ap	0.05 × D		0.05 × D		0.05 × D		0.05 × D	
Cutting Width, ae	0.02 × D		0.02 × D		0.02 × D		0.02 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
3	470	0.021	420	0.018	370	0.014	400	0.015
4		0.028		0.024		0.020		0.021
5		0.037		0.031		0.025		0.027
6		0.045		0.038		0.031		0.033
8		0.061		0.052		0.043		0.045
10		0.078		0.067		0.056		0.058
12		0.097		0.083		0.069		0.072
16		0.126		0.108		0.090		0.093
20		0.155		0.132		0.109		0.113