

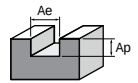
Recommended Cutting Data



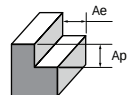
Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



NiTiCo 45 DP/DH Endmills with Recess / with Recess and Weldon, 4 Flutes - K93, K95



Slotting	M		S	
Working Material	Stainless Steel		Nickel Alloy	
Properties	Low Machinability		-	
Cutting depth, ap	0.45 × D		0.30 × D	
Cutting Width, ae	1.00 × D		1.00 × D	
D	Vc	Fz	Vc	Fz
3	55	0.014	25	0.011
4		0.018		0.015
5		0.023		0.019
6		0.029		0.024
8		0.039		0.032
10		0.050		0.043
12		0.061		0.054
14		0.070		0.060
16		0.078		0.065
18		0.087		0.073
20		0.095		0.079



NiTiCo 45 DP/DH Endmills with Recess / with Recess and Weldon, 4 Flutes - K93, K95

Side Milling	M		S	
Working Material	Stainless Steel		Nickel Alloy	
Properties	Low Machinability		-	
Cutting depth, ap	1.00 × D		1.00 × D	
Cutting Width, ae	0.18 × D		0.10 × D	
D	Vc	Fz	Vc	Fz
3	70	0.016	35	0.014
4		0.023		0.019
5		0.029		0.024
6		0.035		0.030
8		0.048		0.041
10		0.062		0.052
12		0.078		0.067
14		0.088		0.076
16		0.098		0.084
18		0.106		0.094
20		0.113		0.101