

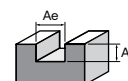
Recommended Cutting Data



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

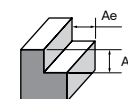


NiTiCo 30 DP/DH Endmills, 4 Flutes - 949, C49, K78, C48, C52, A1R, A1T, H98, J01



Slotting	K		P		M		S			
Working Material	Grey Cast Iron		Carbon Steel		Alloy steel		Stainless steel		Titanium	
Properties	-		-		520 < Rm < 1200		High Machinability		-	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D		0.50 × D	
Cutting Width, ae	1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
1	170	0.003	200	0.003	160	0.003	120	0.003	60	0.004
2		0.006		0.005		0.006		0.006		0.008
3		0.009		0.009		0.009		0.009		0.013
4		0.012		0.012		0.012		0.013		0.018
5		0.016		0.015		0.015		0.017		0.024
6		0.019		0.019		0.019		0.021		0.029
8		0.027		0.027		0.027		0.031		0.042
10		0.037		0.036		0.036		0.041		0.055
12		0.046		0.046		0.045		0.053		0.071
14		0.053		0.053		0.052		0.060		0.081
16		0.058		0.058		0.058		0.066		0.088
18		0.064		0.064		0.064		0.071		0.097
20		0.069		0.069		0.069		0.076		0.103

NiTiCo 30 DP/DH Endmills, 4 Flutes - 949, C49, K78, C48, C52, A1R, A1T, H98, J01



Side Milling	K		P				M		S	
Working Material	Grey Cast Iron		Carbon Steel		Alloy steel		Stainless steel		Titanium	
Properties	-		-		520 < Rm < 1200		High Machinability		-	
Cutting depth, ap	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	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
1	250	0.008	280	0.009	230	0.007	160	0.006	85	0.007
2		0.010		0.010		0.010		0.012		0.014
3		0.016		0.016		0.015		0.018		0.022
4		0.022		0.022		0.021		0.025		0.030
5		0.029		0.029		0.027		0.031		0.038
6		0.035		0.035		0.033		0.038		0.047
8		0.050		0.050		0.047		0.052		0.065
10		0.066		0.066		0.061		0.067		0.084
12		0.083		0.083		0.077		0.082		0.104
14		0.095		0.095		0.088		0.093		0.116
16		0.106		0.107		0.099		0.103		0.126
18		0.116		0.118		0.109		0.112		0.136
20		0.126		0.129		0.118		0.121		0.143

Recommended Cutting Data



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P

M

K

S



P

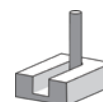
K



NiTiCo 30 DP/DH Endmills, 4 Flutes - 949, C49, K78, C48, C52, A1R, A1T, H98, J01

Ramp/Helical	K		P				M		S	
Working Material	Grey Cast Iron		Carbon Steel		Alloy steel		Stainless steel		Titanium	
Properties	-		-		520 < Rm < 1200		High Machinability		-	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Ramping Angle	5°		5°		5°		3°		2°	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
3	200	0.008	200	0.009	140	0.008	70	0.008	50	0.005
4		0.011		0.012		0.011		0.012		0.008
5		0.014		0.016		0.014		0.016		0.011
6		0.018		0.020		0.018		0.020		0.014
8		0.025		0.028		0.026		0.031		0.021
10		0.033		0.037		0.034		0.043		0.031
12		0.042		0.046		0.043		0.058		0.041
14		0.047		0.052		0.049		0.063		0.046
16		0.052		0.057		0.054		0.067		0.049
18		0.056		0.061		0.058		0.069		0.052
20		0.060		0.065		0.062		0.070		0.053

NiTiCo 30 DP/DH Endmills, 4 Flutes - 949, C49, K78, C48, C52, A1R, A1T, H98, J01



Trochoidal Milling	K		P				M		S	
Working Material	Grey Cast Iron		Carbon Steel		Alloy steel		Stainless steel		Titanium	
Properties	-		-		520 < Rm < 1200		High Machinability		-	
Maximum Slot Width	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	
Cutting Width, ae	0.15 × D		0.15 × D		0.15 × D		0.10 × D		0.10 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
4	330	0.021	360	0.023	300	0.019	220	0.024	130	0.024
5		0.027		0.029		0.025		0.030		0.031
6		0.034		0.037		0.032		0.037		0.039
8		0.049		0.051		0.047		0.051		0.055
10		0.065		0.067		0.063		0.067		0.074
12		0.087		0.089		0.085		0.090		0.101
14		0.093		0.095		0.090		0.095		0.106
16		0.098		0.102		0.095		0.100		0.111
18		0.104		0.108		0.100		0.110		0.120
20		0.110		0.114		0.106		0.116		0.126