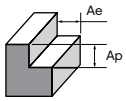
Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

P M K S P K

NiTiCo 30 DH / with Weldon Endmills, 5 Flutes - J89, J90



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		0.10 × D		0.10 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
4	250	0.017	280	0.018	230	0.018	160	0.018	85	0.024	60	0.020	50	0.019
5		0.022		0.023		0.022		0.023		0.030		0.027		0.026
6		0.027		0.028		0.027		0.028		0.037		0.034		0.032
8		0.036		0.038		0.038		0.039		0.051		0.047		0.045
10		0.049		0.048		0.049		0.050		0.065		0.062		0.059
12		0.059		0.057		0.062		0.063		0.081		0.079		0.075
16		0.077		0.074		0.076		0.077		0.103		0.096		0.092
20		0.086		0.089		0.086		0.088		0.122		0.111		0.106

NiTiCo 30 DH / with Weldon Endmills, 5 Flutes - J89, J90

Trochoidal 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		-		-		-	
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		0.08 × D		0.08 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
4	300	0.015	330	0.015	280	0.016	200	0.017	110	0.024	70	0.018	60	0.017
5		0.021		0.020		0.022		0.023		0.031		0.023		0.022
6		0.027		0.028		0.030		0.031		0.038		0.029		0.028
8		0.038		0.039		0.043		0.044		0.054		0.042		0.040
10		0.051		0.051		0.058		0.059		0.071		0.057		0.055
12		0.064		0.064		0.078		0.079		0.092		0.076		0.072
16		0.080		0.082		0.095		0.096		0.115		0.089		0.085
20		0.094		0.093		0.108		0.109		0.135		0.096		0.091