

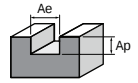
# Recommended Cutting Data



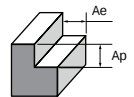
Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



## NiTiCo 45 DP/DH Torus Endmills with Recess / with Recess and Weldon, 4 Flutes - K97, K99



| Slotting          | M                 |       | S            |       |
|-------------------|-------------------|-------|--------------|-------|
| Working Material  | Stainless Steel   |       | Nickel Alloy |       |
| Properties        | Low Machinability |       | -            |       |
| Cutting depth, ap | 0.80 × D          |       | 0.30 × D     |       |
| Cutting Width, ae | 1.00 × D          |       | 1.00 × D     |       |
| D                 | Vc                | Fz    | Vc           | Fz    |
| 3                 | 100               | 0.013 | 30           | 0.011 |
| 4                 |                   | 0.018 |              | 0.016 |
| 5                 |                   | 0.024 |              | 0.020 |
| 6                 |                   | 0.029 |              | 0.027 |
| 8                 |                   | 0.039 |              | 0.036 |
| 10                |                   | 0.049 |              | 0.047 |
| 12                |                   | 0.060 |              | 0.056 |
| 14                |                   | 0.069 |              | 0.066 |
| 16                |                   | 0.077 |              | 0.071 |
| 18                |                   | 0.087 |              | 0.080 |
| 20                |                   | 0.097 |              | 0.089 |



## NiTiCo 45 DP/DH Torus Endmills with Recess / with Recess and Weldon, 4 Flutes - K97, K99

| 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                 | 85                | 0.017 | 45           | 0.013 |
| 4                 |                   | 0.023 |              | 0.019 |
| 5                 |                   | 0.030 |              | 0.024 |
| 6                 |                   | 0.036 |              | 0.029 |
| 8                 |                   | 0.050 |              | 0.041 |
| 10                |                   | 0.064 |              | 0.051 |
| 12                |                   | 0.081 |              | 0.067 |
| 14                |                   | 0.091 |              | 0.074 |
| 16                |                   | 0.102 |              | 0.081 |
| 18                |                   | 0.112 |              | 0.091 |
| 20                |                   | 0.117 |              | 0.101 |