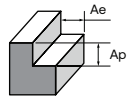


Recommended Cutting Data



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



NiTiCo 30 DH 4xD Long Internal Oil Hole, Weldon, Recess, 5 Flutes - K67

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	1.50 × 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		0.10 × D		0.10 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
4	250	0.014	280	0.014	230	0.018	160	0.020	85	0.020	45	0.020	35	0.019
5		0.019		0.019		0.023		0.025		0.027		0.027		0.026
6		0.023		0.024		0.029		0.031		0.035		0.035		0.033
8		0.031		0.032		0.039		0.041		0.050		0.050		0.047
10		0.041		0.041		0.050		0.052		0.066		0.066		0.062
12		0.053		0.054		0.063		0.065		0.084		0.084		0.080
16		0.068		0.069		0.082		0.084		0.107		0.107		0.101
20		0.080		0.083		0.099		0.101		0.126		0.126		0.120



NiTiCo 30 DH 4xD Long Internal Oil Hole, Weldon, Recess, 5 Flutes - K67

Trochoidal Milling	K		P		M		S							
Working Material	Grey Cast Iron		Carbon Steel		Alloy Steel		Stainless Steel		Titanium Alloy		Nickel Alloy		Cobalt Alloy	
Proprietà	-		-		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	2.00 × D		2.00 × D		2.00 × D		2.00 × D		2.00 × D		2.00 × D		2.00 × D	
Cutting Width, ae	0.12 × D		0.12 × D		0.10 × D		0.08 × D		0.08 × D		0.08 × D		0.08 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
4	300	0.013	330	0.014	280	0.014	200	0.016	115	0.021	61	0.021	47	0.020
5		0.018		0.019		0.021		0.023		0.028		0.028		0.026
6		0.024		0.025		0.028		0.030		0.035		0.035		0.034
8		0.034		0.035		0.040		0.042		0.049		0.049		0.046
10		0.045		0.046		0.055		0.057		0.066		0.066		0.062
12		0.059		0.060		0.072		0.074		0.089		0.089		0.084
16		0.072		0.074		0.088		0.090		0.107		0.107		0.101
20		0.081		0.082		0.099		0.101		0.123		0.123		0.117