

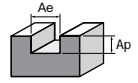
# Recommended Cutting Data



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

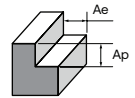


## XQ Alu Cutters DP/DH/DF Endmills, 4 Flutes - K60, K61, K62, K63



Slotting	N						O	
Working Material	Wrought Aluminium		Cast Aluminium		Copper alloy		Thermoplastic	
Properties	Si < 9%		Si ≥ 9%		-		-	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	1.00 × D		1.00 × D		0.30 × D		1.00 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
6	650	0.034	550	0.027	400	0.023	600	0.030
8		0.046		0.037		0.032		0.040
10		0.059		0.048		0.042		0.051
12		0.073		0.060		0.054		0.063
14		0.083		0.068		0.060		0.071
16		0.093		0.075		0.065		0.078
18		0.102		0.081		0.069		0.084
20		0.111		0.087		0.073		0.090

## XQ Alu Cutters DP/DH/DF Endmills, 4 Flutes - K60, K61, K62, K63



Side Milling	N						O	
Working Material	Wrought Aluminium		Cast Aluminium		Copper alloy		Thermoplastic	
Properties	Si < 9%		Si ≥ 9%		-		-	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	0.30 × D		0.30 × D		0.30 × D		0.30 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
6	750	0.039	700	0.030	500	0.025	720	0.033
8		0.053		0.042		0.034		0.045
10		0.067		0.054		0.045		0.057
12		0.082		0.067		0.057		0.070
14		0.094		0.077		0.063		0.080
16		0.105		0.086		0.069		0.089
18		0.116		0.094		0.075		0.097
20		0.126		0.102		0.080		0.105