

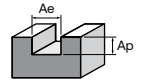
Recommended Cutting Data



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

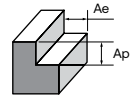


NiTiCo 30 DP/DH OH Standard Endmills, 4 Flutes - K70



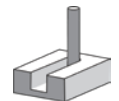
Slotting	K		P		M		S	
Working Material	Grey Cast Iron		Carbon Steel		Alloy steel		Stainless steel	
Properties	-		-		520 < Rm < 1200		High Machinability	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	1.00 × D		1.00 × D		1.00 × D		1.00 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
4	200	0.015	230	0.015	190	0.014	140	0.020
5		0.019		0.019		0.018		0.026
6		0.023		0.024		0.022		0.032
8		0.031		0.032		0.030		0.043
10		0.040		0.040		0.038		0.055
12		0.049		0.049		0.047		0.069
16		0.064		0.065		0.062		0.091
20		0.079		0.080		0.077		0.111

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Side Milling	K		P		M		S	
Working Material	Grey Cast Iron		Carbon Steel		Alloy steel		Stainless steel	
Properties	-		-		520 < Rm < 1200		High Machinability	
Cutting depth, ap	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	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
4	280	0.020	310	0.023	260	0.018	180	0.025
5		0.027		0.030		0.025		0.033
6		0.034		0.037		0.032		0.041
8		0.049		0.051		0.047		0.057
10		0.065		0.068		0.063		0.072
12		0.084		0.087		0.083		0.099
16		0.107		0.109		0.105		0.118
20		0.123		0.127		0.121		0.137

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

ALU LINE
 EZ LINE -
 ENDMILL
 SE 30
 NITICO 30
 OPTIMUM
 SE 45
 SE 45X
 NITICO 45
 SE 60
 SE 60X
 DM70 -
 SE 70
 SE GR
 TE 45
 PLUNGE
 -MILL
 THREAD
 MILL