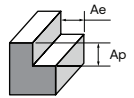


Recommended Cutting Data



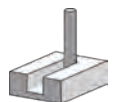
Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



NiTiCo 30 DH Long Internal Oil Hole, 4xD, Weldon, Recess, 5 Flutes - K51

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	240	0.014	270	0.015	220	0.017	120	0.017	80	0.019	40	0.019	30	0.018
5		0.019		0.019		0.022		0.020		0.024		0.024		0.023
6		0.023		0.024		0.027		0.025		0.030		0.030		0.029
8		0.031		0.032		0.037		0.034		0.043		0.043		0.041
10		0.041		0.041		0.048		0.043		0.055		0.055		0.052
12		0.053		0.052		0.060		0.054		0.070		0.070		0.067
16		0.067		0.066		0.077		0.069		0.089		0.089		0.085
20		0.079		0.078		0.090		0.080		0.106		0.106		0.101

NiTiCo 30 DH Long Internal Oil Hole, 4xD, Weldon, Recess, 5 Flutes - K51



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	285	0.013	315	0.014	270	0.014	150	0.014	105	0.018	53	0.018	39	0.017
5		0.018		0.019		0.021		0.019		0.024		0.024		0.023
6		0.024		0.025		0.028		0.026		0.030		0.030		0.029
8		0.034		0.035		0.040		0.036		0.042		0.042		0.040
10		0.046		0.046		0.055		0.049		0.056		0.056		0.053
12		0.060		0.060		0.071		0.063		0.074		0.074		0.070
16		0.070		0.071		0.089		0.077		0.091		0.091		0.086
20		0.080		0.080		0.100		0.088		0.107		0.107		0.102