

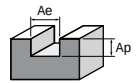
Recommended Cutting Data



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



Optimum Short DP/DH Endmills, 3 Flutes - K86



Slotting	N						K				P					
Working Material	Wrought Aluminium		Cast Aluminium		Copper Alloy		Grey Cast Iron		Ductile Cast Iron		Carbon steel		Alloy steel		Prehardened Steel	
Properties	Si < 9%		Si ≥ 9%		-		-		-		-		520 < Rm < 1200		-	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D		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		1.00 × D		1.00 × D		1.00 × D		1.00 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
1	220	0.005	200	0.005	165	0.003	110	0.002	209	0.001	135	0.002	120	0.001	95	0.001
2		0.008		0.008		0.008		0.006		0.002		0.006		0.004		0.002
3		0.014		0.013		0.013		0.011		0.003		0.011		0.007		0.004
4		0.019		0.019		0.018		0.017		0.007		0.016		0.010		0.007
5		0.025		0.024		0.024		0.023		0.009		0.022		0.014		0.010
6		0.031		0.030		0.030		0.029		0.011		0.028		0.018		0.013
8		0.045		0.042		0.043		0.043		0.016		0.041		0.028		0.019
10		0.060		0.056		0.058		0.061		0.021		0.056		0.040		0.025
12		0.077		0.070		0.074		0.081		0.026		0.074		0.054		0.030

Optimum Short DP/DH Endmills, 3 Flutes - K86

Slotting	M				S			
Working Material	Stainless Steel		Stainless Steel		Titanium Alloy		Nickel Alloy	
Properties	High Machinability		Low Machinability		-		-	
Cutting depth, ap	0.80 × D		0.80 × 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
1	100	0.001	44	0.001	66	0.001	110	0.001
2		0.003		0.004		0.002		0.002
3		0.006		0.007		0.004		0.004
4		0.009		0.010		0.007		0.007
5		0.013		0.014		0.010		0.010
6		0.017		0.017		0.013		0.013
8		0.026		0.024		0.019		0.019
10		0.038		0.030		0.025		0.025
12		0.052		0.036		0.030		0.030