



CUTTING CONDITIONS

Milling | Indexables | Cutting conditions


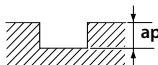
PXNL

Side milling L/D≤3,5

|  | Cast iron FC250 | | Carbon steel | | Alloy steel | | Stainless steel Hardened steel | | Stainless steel SUS304 | | | | | | | | | |
|---|--|---------------|---------------------------|---------------|---------------------------|---------------|-----------------------------------|---------------|--|---------------|--|--|----|----|-------|-------|---|--|
| Ø | S (min ⁻¹) | F (mm/min) | S (min ⁻¹) | F (mm/min) | S (min ⁻¹) | F (mm/min) | S (min ⁻¹) | F (mm/min) | S (min ⁻¹) | F (mm/min) | | | | | | | | |
| 10 | 2.860 | 720 | 3.820 | 840 | 3.180 | 520 | 2.860 | 350 | 2.550 | 280 | | | | | | | | |
| 12 | 2.390 | 600 | 3.180 | 700 | 2.650 | 440 | 2.390 | 290 | 2.120 | 230 | | | | | | | | |
| 16 | 1.790 | 620 | 2.390 | 720 | 1.990 | 450 | 1.790 | 300 | 1.590 | 240 | | | | | | | | |
| 20 | 1.430 | 660 | 1.910 | 760 | 1.590 | 480 | 1.430 | 310 | 1.270 | 250 | | | | | | | | |
| 25 | 890 | 450 | 1.270 | 560 | 1.020 | 340 | 890 | 220 | 760 | 170 | | | | | | | | |
| Max cutting depth | <table border="1"><tr><td>ap</td><td>ae</td></tr><tr><td>0,5 D</td><td>0,3 D</td></tr></table> | | | | ap | ae | 0,5 D | 0,3 D | <table border="1"><tr><td>ap</td><td>ae</td></tr><tr><td>0,5 D</td><td>0,2 D</td></tr></table> | | | | ap | ae | 0,5 D | 0,2 D |  | |
| | ap | ae | | | | | | | | | | | | | | | | |
| | 0,5 D | 0,3 D | | | | | | | | | | | | | | | | |
| ap | ae | | | | | | | | | | | | | | | | | |
| 0,5 D | 0,2 D | | | | | | | | | | | | | | | | | |

PXNL

Slotting L/D≤3,5

|  | Cast iron FC250 | | Carbon steel | | Alloy steel | | Stainless steel Hardened steel | | Stainless steel SUS304 | |
|---|---|---------------|---------------------------|---------------|---------------------------|---------------|-----------------------------------|---------------|---------------------------|---------------|
| Ø | S (min ⁻¹) | F (mm/min) | S (min ⁻¹) | F (mm/min) | S (min ⁻¹) | F (mm/min) | S (min ⁻¹) | F (mm/min) | S (min ⁻¹) | F (mm/min) |
| 10 | 2.230 | 360 | 3.180 | 450 | 2.550 | 270 | 2.230 | 170 | 1.910 | 130 |
| 12 | 1.860 | 300 | 2.650 | 370 | 2.120 | 220 | 1.860 | 140 | 1.590 | 110 |
| 16 | 1.390 | 320 | 1.990 | 400 | 1.590 | 240 | 1.390 | 150 | 1.190 | 120 |
| 20 | 1.110 | 360 | 1.590 | 450 | 1.270 | 270 | 1.110 | 170 | 950 | 130 |
| 25 | 760 | 280 | 1.150 | 370 | 890 | 210 | 760 | 130 | 640 | 100 |
| Max cutting depth | <div><div>ap</div><div>0,5 D</div></div> <div></div> | | | | | | | | | |