
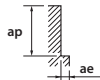


# CUTTING CONDITIONS

Milling | Endmills | Cutting conditions

## CA-RG-EDL

Side milling

	AL A7075		Cu C1100						
	Ø	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)				
	3	13.000	390	6.350	195				
	4	9.900	400	4.750	210				
	5	7.950	400	3.800	245				
	6	6.600	450	3.150	260				
	8	4.950	500	2.350	275				
	10	3.950	600	1.900	295				
	12	3.300	630	1.550	305				
Max cutting depth	<table><tr><td>ap</td><td>ae</td></tr><tr><td>2,5D</td><td>0,1D</td></tr></table> 					ap	ae	2,5D	0,1D
ap	ae								
2,5D	0,1D								
<div>1. Use a high rigidity machine set up.</div> <div>2. Use soluble oil.</div> <div>3. For side milling, modify feed to obtain required finish quality</div>									