
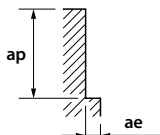
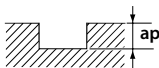


CUTTING CONDITIONS

Milling | Endmills | Cutting conditions

UVX-TI-4FL

Titanium alloy (Ti-6Al-4V)

	Side milling		Slotting							
Vc	60 ~ 80 m/min		30 ~ 50 m/min							
Ø	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)						
12	1.900	680	1.350	270						
16	1.400	500	990	200						
20	1.100	480	800	190						
25	900	400	640	150						
Max cutting depth	 <table><tr><td>ap</td><td>ae</td></tr><tr><td>≤ 1,8 Dc</td><td>0,2 Dc</td></tr></table>		ap	ae	≤ 1,8 Dc	0,2 Dc	 <table><tr><td>ap</td></tr><tr><td>≤ 1 Dc</td></tr></table>		ap	≤ 1 Dc
ap	ae									
≤ 1,8 Dc	0,2 Dc									
ap										
≤ 1 Dc										