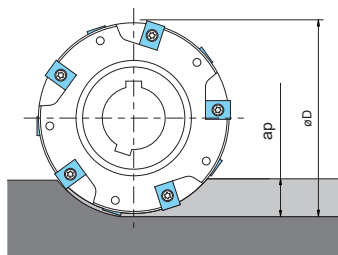


Slot Mill Up-right: LN Insert

◆ Recommended Cutting Conditions

Workpiece Material		Hardness (HB)	Recommended Insert Grade (Cutting Speed Vc: m/min)	fz (mm/t)		Remarks
			PVD Coated Carbide	Insert Thickness (mm)		
			PR0725	3.5~4.0	4.5~6.0	
Low Carbon Steel	St42-2 C10E~C25	125	170-210	0.07-0.20	0.10-0.22	Dry
Carbon Steel	C30~C60 (Annealed)	190	100-140	0.07-0.20	0.10-0.22	
	C30~C60 (Heat treated)	250	90-120	0.07-0.20	0.10-0.22	
Alloy Steel	34CrMo4 (Annealed)	180	90-120	0.07-0.20	0.10-0.22	
	34CrMo4 (Heat treated)	275	80-110	0.05-0.18	0.08-0.20	
High Carbon Carbide	X40CrMoV51, etc.	280	70-90	0.05-0.18	0.08-0.20	Coolant
Stainless Steel	X5CrNi1810, etc.	220	110-140	0.05-0.18	0.08-0.20	
	X10Cr13, etc.	300	100-120	0.05-0.18	0.08-0.20	
Heat-resistant Alloy	Inconel 718, etc.	350	15-30	0.05-0.18	0.08-0.20	
Titanium Alloy	TiAl6V4, etc.	270	20-50	0.05-0.18	0.08-0.20	
Gray Cast Iron	GG25~GG35	260	110-130	0.07-0.22	0.10-0.25	Dry
Nodular Cast Iron	GGG40~GGG50	160	80-100	0.07-0.22	0.10-0.25	
	GGG60~GGG80	250	70-90	0.07-0.22	0.10-0.25	

- Note) 1. Use down-cut machining.
 2. If a_p is under 1/10 of Cutter Dia. (ϕD), it is possible to increase feed per tooth (f_z) 40%.



M



Milling