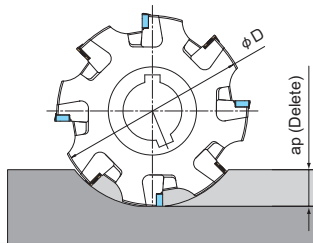


Slot Mill Lay-down type / Half Side Slot Mill

◆ Recommended Cutting Conditions (For CA0835 / PR0725)

Workpiece Material		Hardness (HB)	Recommended Insert Grade (Cutting Speed Vc: m/min)		fz (mm/t)			Remarks
			CVD Coated Carbide	PVD Coated Carbide	Chipbreaker			
			CA0835	PR0725	EN-SD ER-SD EL-SD	ER-SB EL-SB	SN-SB SR-SB SL-SB	
Low Carbon Steel	St42-2 C10E-C25	125	250-310	170-210	0.07-0.20	0.10-0.22	0.15-0.3	Dry
Carbon Steel	C30-C60 (Annealed)	190	160-190	100-140	0.07-0.20	0.10-0.22	0.15-0.3	
	C30-C60 (Heat treated)	250	140-180	90-120	0.07-0.20	0.10-0.22	0.15-0.3	
Alloy Steel	34CrMo4 (Annealed)	180	140-180	90-120	0.07-0.20	0.10-0.22	0.15-0.3	
	34CrMo4 (Heat treated)	275	120-160	80-110	0.05-0.18	0.08-0.20	0.12-0.25	
High Carbon Carbide	X40CrMoV51, etc.	280	110-130	70-90	0.05-0.18	0.08-0.20	0.12-0.25	Coolant
Stainless Steel	X5CrNi1810, etc.	220	160-200	110-140	0.05-0.18	0.08-0.20	0.12-0.25	
	X10Cr13, etc.	300	150-180	100-120	0.05-0.18	0.08-0.20	0.12-0.25	
Heat-resistant Alloy	Inconel 718, etc.	350	-	15-30	0.05-0.18	0.08-0.20	0.12-0.25	
Titanium Alloy	Ti-6Al-4V, etc.	270	-	20-50	0.05-0.18	0.08-0.20	0.12-0.25	
Gray Cast Iron	GG25-GG35	260	160-200	110-130	0.07-0.22	0.10-0.25	0.15-0.35	Dry
Nodular Cast Iron	GGG40-GGG50	160	130-160	80-100	0.07-0.22	0.10-0.25	0.15-0.35	
	GGG60-GGG80	250	110-140	70-90	0.07-0.22	0.10-0.25	0.15-0.35	

- 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 (fz) 40%.



◆ Recommended Cutting Conditions (For PR0110)

Workpiece Material		Hardness (HB)	Recommended Insert Grade (Cutting Speed Vc: m/min)		fz (mm/t)	Remarks
			PVD Coated Carbide		Chipbreaker	
			PR0110		FN-SE FR-SE FL-SE	
Non-ferrous Metals	AlZnMgCu1.5, G-AlSi7Mg	-	750-950		0.07-0.20	Coolant

- 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 (fz) 40%.

M



Milling