

## CUTTING CONDITIONS


## Milling | Endmills | Cutting conditions

## CA-PKE

## High speed side milling

	AL A7075		AC <Si 13%		Cu C1100	
Ø	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)
3	40.000	2.100	24.000	1.250	17.000	625
4	32.000	2.550	19.200	1.550	14.300	800
5	32.000	3.250	19.200	1.950	12.700	960
6	26.500	3.500	15.900	2.150	10.600	960
8	20.000	3.750	12.000	2.250	8.000	1.130
10	16.000	4.300	9.600	2.580	6.350	1.150
12	13.300	4.400	8.000	2.650	5.300	1.250
16	10.000	4.400	6.000	2.650	4.000	1.250
20	8.000	4.400	4.800	2.650	3.200	1.250

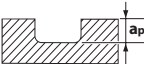
Max cutting depth



ap	ae
1D	0,1D

1. Use a rigid and precise machine and holder.
2. When chattering occurs, reduce the speed and feed simultaneously.
3. Use a suitable cutting fluid with high smoke retardant properties.

## Slotting

	AL A7075		AC <Si 13%		Cu C1100	
Ø	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)
3	40.000	1.450	24.000	880	7.950	325
4	32.000	1.700	19.200	1.000	5.950	375
5	32.000	2.200	19.200	1.330	4.750	385
6	26.500	2.400	15.900	1.450	3.950	400
8	20.000	2.500	12.000	1.500	2.950	460
10	16.000	2.800	9.600	1.700	2.350	475
12	13.300	2.950	8.000	1.800	1.950	510
16	10.000	3.000	6.000	1.800	1.450	510
20	8.000	3.000	4.800	1.800	1.150	510
Max cutting depth	<div>ap</div> <div>0,25D</div>		<div>ap</div> <div>0,25D</div> 		<div>ap</div> <div>0,5D</div>	

1. Use a rigid and precise machine and holder.
2. When chattering occurs, reduce the speed and feed simultaneously.
3. Use a suitable cutting fluid with high smoke retardant properties.