

CUTTING CONDITIONS

Milling | Endmills | Cutting conditions


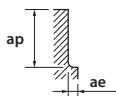
EPL-HP-5FL

Slotting

		Steels St-52 • C45 • GG-25			Hardened steels ~35 HRC 42CrMo4			Hardened steels ~45 HRC 1.2379			Stainless steel 1.4301			Titanium Ti6AlV4																						
Vc		120 m/min			120 m/min			70 m/min			60 m/min			50 m/min																						
Ø	Z	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)																				
8	5	4.775	1.432	0,060	4.775	1.432	0,060	2.785	836	0,060	2.387	477	0,040	1.989	398	0,040																				
10	5	3.820	1.432	0,075	3.820	1.432	0,075	2.228	836	0,075	1.910	477	0,050	1.592	398	0,050																				
12	5	3.183	1.432	0,090	3.183	1.432	0,090	1.857	836	0,090	1.592	477	0,060	1.326	398	0,060																				
16	5	2.387	1.432	0,120	2.387	1.432	0,120	1.393	836	0,120	1.194	477	0,080	995	398	0,080																				
20	5	1.910	1.432	0,150	1.910	1.432	0,150	1.114	836	0,150	955	477	0,100	796	398	0,100																				
ap x d F(fz) correction					<table><tr><td>ae</td><td></td></tr><tr><td>1xd</td><td></td></tr></table>			ae		1xd		<table><tr><td>ap</td><td>Fakt.</td></tr><tr><td>0,5</td><td>1,0</td></tr><tr><td>1,0</td><td>0,7</td></tr><tr><td>1,5</td><td>0,5</td></tr><tr><td>2,0</td><td>0,3</td></tr></table>			ap	Fakt.	0,5	1,0	1,0	0,7	1,5	0,5	2,0	0,3										The above stated application data are as per RED marked parameters.		
ae																																				
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0,5	1,0																																			
1,0	0,7																																			
1,5	0,5																																			
2,0	0,3																																			

EPL-HP-5FL

Side milling

		Steels St-52 · C45 · GG-25			Hardened steels ~35 HRC 42CrMo4			Hardened steels ~45 HRC 1.2379			Stainless steel 1.4301			Titanium Ti6AlV4																										
Vc		140 m/min			140 m/min			80 m/min			70 m/min			60 m/min																										
Ø	Z	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)	S (min ⁻¹)	F (mm/min)	fz (mm)																								
8	5	5.570	4.456	0,160	5.570	4.456	0,160	3.183	2.546	0,160	2.785	1.114	0,080	2.387	955	0,080																								
10	5	4.456	4.456	0,200	4.456	4.456	0,200	2.546	2.546	0,200	2.228	1.114	0,100	1.910	955	0,100																								
12	5	3.714	4.456	0,240	3.714	4.456	0,240	2.122	2.546	0,240	1.857	1.114	0,120	1.592	955	0,120																								
16	5	2.785	4.456	0,320	2.785	4.456	0,320	1.592	2.546	0,320	1.393	1.114	0,160	1.194	955	0,160																								
20	5	2.228	4.456	0,400	2.228	4.456	0,400	1.273	2.546	0,400	1.114	1.114	0,200	955	955	0,200																								
ap x d F(fz) correction					<table><tr><td>ap</td><td>Fakt.</td></tr><tr><td>ae</td><td>0,5</td></tr><tr><td>0,2xd</td><td>1,2</td></tr><tr><td></td><td>1,5</td></tr><tr><td></td><td>2</td></tr></table>			ap	Fakt.	ae	0,5	0,2xd	1,2		1,5		2	<table><tr><td>ae</td><td></td></tr><tr><td>0,5xd</td><td></td></tr></table>			ae		0,5xd		<table><tr><td>ap</td><td>Fakt.</td></tr><tr><td>0,5</td><td>1,2</td></tr><tr><td>1,0</td><td>1,0</td></tr><tr><td>1,5</td><td>0,7</td></tr><tr><td>2,0</td><td>0,5</td></tr></table>			ap	Fakt.	0,5	1,2	1,0	1,0	1,5	0,7	2,0	0,5	The above stated application data are as per RED marked parameters.		
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