

CUTTING CONDITIONS

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PAO BORE

45° Face milling

	Work Material	Tensile Strength / Hardness	Milling Speed Vc (m/min)	Feed per Tooth fz (mm/t)	Depth of Cut ap (mm)	Grade
P	Mild Steel-Carbon Steel (SS400-S10C)	~180HB	180 (100 ~ 250)	0,25 (0,20 ~ 0,50)	2	XP3035
	Carbon Steel-Alloy Steel (S50C-SCM440)	~280HB	180 (100 ~ 250)	0,25 (0,20 ~ 0,50)	2	XP3035
	Die Steel (SKD11-SKD61)	~280HB	150 (80 ~ 200)	0,25 (0,15 ~ 0,40)	2	XP3035
M	Stainless Steel (Wet) (SUS304-SUS420)	~250HB	120 (80 ~ 180)	0,20 (0,15 ~ 0,40)	2	XP2040
K	Cast Iron (FC250)	~300N/mm ²	200 (100 ~ 350)	0,30 (0,20 ~ 0,50)	2	XC1015 XP1020
	Ductile Cast Iron (FCD400)	~600N/mm ²	180 (100~270)	0,28 (0,15 ~ 0,40)	2	XC1015 XP1020
S	Heat Resistant Alloys (Inconel 718)	-	35 (25 ~ 60)	0,12 (0,05 ~ 0,2)	1	XC5040
	Titanium Alloy (Ti-Al-4V)	-	40 (30 ~ 120)	0,15 (0,1 ~ 0,25)	1,5	XC5040
H	Pre-hardened Steel (NAK80)	40~43HRC	100 (60 ~ 150)	0,15 (0,10 ~ 0,25)	1,5	XP2040
	Steel for Die Casting (DAC55-DH31)	43~48HRC	80 (40 ~ 120)	0,12 (0,05 ~ 0,20)	0,5	XP2040
	Hardened Steel (SKD11)	50~55HRC	60 (40 ~ 90)	0,10 (0,05 ~ 0,20)	0,5	XP2040