

Recommended Cutting Conditions

Table 074**A100 Seires ENSSC1**

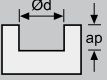
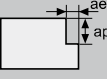
Material	Aluminum			
Application	Slot Milling 			
Vc	150 ~ 250 m/min			
Dia (mm)	RPM	Feed (mm/min)	fz (mm/tooth)	ap (mm)
4	15000	5000	0.33	0.5×d
6	10000	5000	0.50	0.5×d
8	8400	4000	0.48	0.5×d
10	6700	4000	0.60	0.5×d
12	5000	4000	0.80	0.5×d

Table 075**A100 Seires ENSSP1**

Material	Aluminum				
Application	Side Milling 				
Vc	150 ~ 250 m/min				
Dia (mm)	RPM	Feed (mm/min)	fz (mm/tooth)	ap (mm)	ae (mm)
4	15000	5000	0.33	1×d	0.3×d
6	10000	5000	0.50	1×d	0.3×d
8	8400	4000	0.48	1×d	0.3×d
10	6700	4000	0.60	1×d	0.3×d
12	5000	4000	0.80	1×d	0.3×d

1. Use as highly rigid and accurate machine as possible.
2. If the rpm available is lower than the recommend condition, please reduce the feed rate to the same ratio.
3. Use long shank type please reduce the rpm and feed rate.
4. The Feed and RPM may be changed depending on the M/C conditions ,lubricating and cooling system.