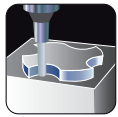


MILLING CONDITIONS

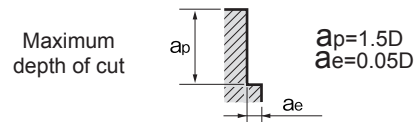
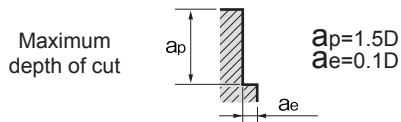
Multi-flute carbide end mill

SIDE MILLING

HYP-ROCKET-MILL, LS-ROCKET-MILL



Vc	Mild Steels Cast Iron		Alloy Steels Tool Steels		Hardened Steels Tool Steels				Titanium Alloy		Nickel Base Alloys	
	< 25 HRC		< 45 HRC		< 55 HRC		< 60 HRC		< 40 HRC		< 45 HRC	
	132 m/min		72 m/min		39 m/min		22 m/min		66 m/min		20 m/min	
Ø	Speed (min ⁻¹)	Feed (mm/min.)	Speed (min ⁻¹)	Feed (mm/min.)	Speed (min ⁻¹)	Feed (mm/min.)	Speed (min ⁻¹)	Feed (mm/min.)	Speed (min ⁻¹)	Feed (mm/min.)	Speed (min ⁻¹)	Feed (mm/min.)
3	11,400	1,800	6,360	480	3,240	192	2,280	120	5,040	840	1,680	54
4	8,640	1,800	4,800	480	2,640	240	1,800	120	3,840	900	1,260	66
5	6,840	1,560	3,840	480	2,160	264	1,560	120	3,000	900	984	84
6	6,360	3,120	3,480	1,020	1,920	360	1,320	192	2,520	1,080	840	108
8	4,800	2,880	2,640	1,020	1,440	360	996	180	1,920	1,080	624	108
10	3,840	2,520	2,160	1,020	1,152	336	804	180	1,560	960	480	108
12	3,480	2,520	1,920	924	960	336	672	156	1,260	900	408	96
16	2,640	1,920	1,440	696	720	264	528	120	960	840	312	84
20	2,160	1,560	1,140	552	576	192	420	102	780	720	240	84
25	1,500	1,440	900	570	450	216	300	96	720	600	216	72



1 flute carbide end mill

SLOTTING

HYP-F1



Vc	Aluminium		Plastics	
	Speed (min ⁻¹)	Feed (mm/min.)	Speed (min ⁻¹)	Feed (mm/min.)
	Ø			
3	40,000	2,500	20,000	2,000
4	35,000	2,500	20,000	2,000
5	30,000	3,000	20,000	3,000
6	25,000	3,000	20,000	3,000
8	25,000	3,000	20,000	3,000
10	22,300	3,000	16,000	3,000
12	18,600	3,000	13,500	3,000

