

UP210-B2

For Steels, Cast Iron—— Profiling



Workpiece Material		mm	Vc m/min	Tool Diameter(mm)	4	5	6	7	8	9	10	11	12
P	35HRC	$ap \leq 0.2D$	160	min-1	12740	10190	8490	7280	6370	5660	5100	4630	4250
		$ae \leq 0.3D$		mm/min	1020	1020	1020	1020	1020	1020	1020	1020	1020
	35-48HRC	$ap \leq 0.15D$	120	min-1	9550	7640	6370	5460	4780	4250	3820	3470	3190
		$ae \leq 0.15D$		mm/min	610	640	660	630	620	610	610	610	610
M		$ap \leq 0.2D$	110	min-1	8760	7010	5840	5010	4380	3890	3500	3190	2920
		$ap \leq 0.2D$		mm/min	610	630	640	630	630	620	630	640	640
K	32HRC	$ap \leq 0.2D$	140	min-1	11150	8920	7430	6370	5570	4950	4460	4050	3720
		$ae \leq 0.2D$		mm/min	780	800	820	800	800	790	800	810	820
	35-45HRC	$ap \leq 0.1D$	120	min-1	9550	7640	6370	5460	4780	4250	3820	3470	3190
		$ae \leq 0.1D$		mm/min	610	640	660	660	670	650	650	660	670

Make sure work piece and machine are stable and use a precision holder.

Please adjust the speed, feed and cutting depth according to actual cutting conditions.

The milling conditions are for an end mill where the tool overhang length is less than $4 \cdot D$ (mill dia).

When the tool overhang length is longer, please adjust the speed, feed and cutting depth.