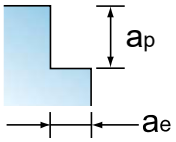
# CUTTING CONDITION - ISES

| Side Milling  | Wood, Plywood, Plastic | | | MDF/Laminate | | |
|---|---|---|---|---|---|---|
| Vc (SFM) | 950 (800~1100) | | | 950 (800~1100) | | |
| Diameter(D1) inch | RPM | Fz | Feed (IPM) 2 Flutes | RPM | Fz | Feed (IPM) 2 Flutes |
| 1/4 | 14,516 | 0.0041 | 120 | 14,516 | 0.0079 | 230 |
| Depth of cut |   | | | | | |

RPM = SFM × 3.82/D1
Feed(IPM) = RPM x Fz x T(Flute)