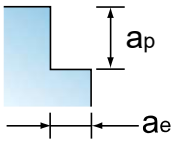
CUTTING CONDITION - ISEUD

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
3/8	9,678	0.0119	230	9,678	0.0207	400
1/2	7,258	0.0210	305	7,258	0.0289	420
Depth of cut	 ae ≤ 0.5X D ap ≤ 1.5X D					

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