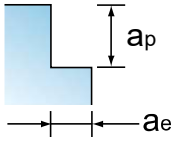
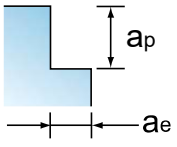
CUTTING CONDITION - IEB/ISEU/ISED for Wood Working

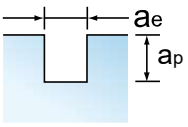
Side Milling 	Hardwoods			Softwoods			Plywoods			Plastics		
Vc(SFM)	1474 (1178~1767)			1854 (1482~2223)			1854 (1482~2223)			1854 (1482~2223)		
Diameter(D1) inch	RPM	Fz	Feed (IPM) 2 flutes	RPM	Fz	Feed (IPM) 2 flutes	RPM	Fz	Feed (IPM) 2 flutes	RPM	Fz	Feed (IPM) 2 flutes
1/8	45,000	0.0008	75	56,612	0.0010	110	56,612	0.0013	150	56,612	0.0008	90
1/4	22,500	0.0016	70	28,306	0.0019	110	28,306	0.0025	140	28,306	0.0018	100
3/8	15,000	0.0025	75	18,871	0.0029	110	18,871	0.0041	155	18,871	0.0025	95
1/2	11,250	0.0031	70	14,153	0.0035	100	14,153	0.0051	145	14,153	0.0036	102
Depth of cut	 ae ≤ 0.5X D ap ≤ 1.5X D											

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

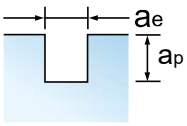
Side Milling 	ALUMINUM ALLOYS 2017,2024,356,6061,7075			COPPER ALLOYS Alum Bronze,C110,Muntz Brass		
Hardness BRINELL	≦ 150			≦ 140		
HRC	≦ 80 HRB			≦ 76.4 HRB		
Vc (sfm)	968 (810~1214)			533 (446~669)		
MILL DIA. (inch)	RPM	Fz	Feed (IPM) 2Flutes	RPM	Fz	Feed (IPM) 2Flutes
1/8	29,380	0.00060	35.3	16,193	0.00030	9.7
3/16	19,587	0.00110	43.1	10,795	0.00055	11.9
1/4	14,690	0.00160	47.0	8,096	0.00080	13.3
5/16	11,752	0.00230	54.1	6,477	0.00115	14.9
3/8	9,793	0.00300	58.8	5,398	0.00150	16.2
1/2	7,345	0.00400	58.8	4,048	0.00200	16.2
5/8	5,876	0.00440	51.7	3,239	0.00220	14.3
3/4	4,897	0.00480	47.0	2,699	0.00240	13
1	3,673	0.00560	41.1	2,024	0.00280	11.3
Depth of cut						

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

CUTTING CONDITION - IEB/ISEU/ISED Aluminum Application

Slot Milling 	Hardwoods			Softwoods			Plywoods			Plastics		
Vc(SFM)	1474 (1178~1767)			1854 (1482~2223)			1854 (1482~2223)			1854 (1482~2223)		
Diameter(D1) inch	RPM	Fz	Feed (IPM) 2 flutes	RPM	Fz	Feed (IPM) 2 flutes	RPM	Fz	Feed (IPM) 2 flutes	RPM	Fz	Feed (IPM) 2 flutes
1/8	45,000	0.0008	75	56,612	0.0010	110	56,612	0.0013	150	56,612	0.0008	90
1/4	22,500	0.0016	70	28,306	0.0019	110	28,306	0.0025	140	28,306	0.0018	100
3/8	15,000	0.0025	75	18,871	0.0029	110	18,871	0.0041	155	18,871	0.0025	95
1/2	11,250	0.0031	70	14,153	0.0035	100	14,153	0.0051	145	14,153	0.0036	102
Depth of cut												

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

Slot Milling 	ALUMINUM ALLOYS 2017,2024,356,6061,7075			COPPER ALLOYS Alum Bronze,C110,Muntz Brass		
Hardness BRINELL	≦ 150			≦ 140		
HRC	≦ 80 HRB			≦ 76.4 HRB		
Vc (sfm)	810 (648~972)			446 (357~535)		
MILL DIA. (inch)	RPM	Fz	Feed (IPM) 2Flutes	RPM	Fz	Feed (IPM) 2Flutes
1/8	23,504	0.00060	28.2	12,954	0.00030	7.8
3/16	15,670	0.00110	34.5	8,636	0.00055	9.5
1/4	11,752	0.00160	37.6	6,477	0.00080	10.4
5/16	9,402	0.00230	43.2	5,182	0.00115	11.9
3/8	7,835	0.00300	47.0	4,318	0.00150	13.0
1/2	5,876	0.00400	47.0	3,239	0.00200	13.0
5/8	4,701	0.00440	41.4	2,591	0.00220	11.4
3/4	3,917	0.00480	37.6	2,159	0.00240	10.4
1	2,938	0.00560	32.9	1,619	0.00280	9.1
Depth of cut						

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

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