

Side Milling						
Side Milling			Fz mm/t			
Vc (m/min)	ap	ae	Ø 6-8	Ø 10-12	Ø 16	
Titanium	50-70	2D	0.4xD	0.03-0.045	0.06-0.08	0.065-0.08
Inconel	15-30	2D	0.4xD	0.02-0.040	0.02-0.045	0.05-0.07

CUTTING DATA FOR HIGH SPEED MACHINING

Side Milling						
Side Milling			Fz mm/t			
Vc (m/min)	ap	ae	Ø 6-8	Ø 10-12	Ø 16	
Titanium	70-110	2D	0.1xD	0.04-0.08	0.04-0.05	0.04-0.06
Inconel	25-50	D	0.1xD	0.03-0.06	0.05-0.08	0.05-0.09