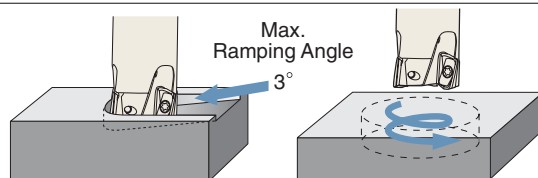
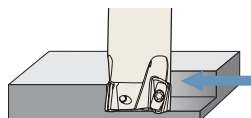


# FCR Cutting Data



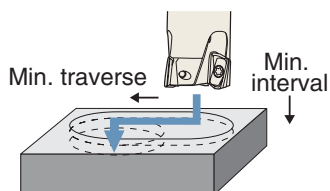
## Ramping and helical interpolation

Cutter Dia. øD	Work Material	Carbon steel Alloy steel	Unalloyed steel	Prehardened steel < HRC40	Stainless steel	Die steel	Cast iron	Aluminum
	Insert Grade	ACZ350S					ACZ310	DC20
	Cutting fluid	Dry		Wet	Dry/Wet	Dry		Dry/Wet
.625 (16mm)	Speed(SFM)	330-655	490-720	195-260	330-490	195-260	330-590	655-3280
	Feed(IPT)	.002-.005	.002-.005	.002-.003	.003-.006	.002-.004	.003-.007	.002-.009
.750(20mm) 1.000(25mm)	Speed(SFM)	330-655	490-655	195-330	395-490	195-330	330-590	655-3280
	Feed(IPT)	.003-.008	.003-.008	.002-.004	.005-.008	.002-.004	.001-.007	.004-.014
1.250 (32mm)	Speed(SFM)	330-655	490-655	195-330	395-490	195-395	330-590	655-3280
	Feed(IPT)	.003-.008	.003-.008	.002-.004	.005-.008	.003-.005	.002-.008	.004-.014



## Shouldering and slotting

Cutter Dia. øD	Work Material	Carbon steel Alloy steel	Unalloyed steel	Prehardened steel < HRC40	Stainless steel	Die steel	Cast iron	Aluminum
	Insert Grade	ACZ350S					ACZ310	DC20
	Cutting fluid	Dry		Wet	Dry/Wet	Dry		Dry/Wet
.625(16mm) .750(20mm)	Speed(SFM)	330-655	330-655	195-260	395-590	260-395	330-590	655-3280
	Feed(IPT)	.003-.007	.003-.007	.002-.004	.005-.007	.003-.005	.003-.007	.004-.012
1.000(25mm) 1.250(32mm)	Speed(SFM)	330-655	330-655	195-330	395-590	260-395	330-590	655-4920
	Feed(IPT)	.003-.008	.003-.008	.002-.004	.005-.008	.003-.005	.003-.008	.004-.014



Cutter Dia. øD	Min. interval	Min. traverse
.625(16mm)	0.5	14
.750(20mm)	1	18
1.000(25mm)	1	23
1.250(32mm)	2	30

## Plunge milling

Cutter Dia. øD	Work Material	Carbon steel Alloy steel	Unalloyed steel	Prehardened steel < HRC40	Stainless steel	Die steel	Cast iron	Aluminum
	Insert Grade	ACZ350S					ACZ310	DC20
	Cutting fluid	Air blow		Wet	Air/Wet	Air blow		ir/Wet
.625 (16mm)	Speed(SFM)	260-395	260-395	197	260-395	197-262	260-525	655-1150
	Feed (IPR)	.002-.004	.002-.004	.001-.002	.002-.003	.002-.003	.002-.004	.002-.004
.750(20mm) 1.000(25mm)	Speed(SFM)	330-525	330-525	197-328	330-525	197-328	260-590	655-1640
	Feed (IPR)	.004-.001	.004-.001	.004-.001	.005-.001	.004-.008	.003-.012	.004-.012
1.250 (32mm)	Speed(SFM)	330-525	330-525	197-328	330-525	197-328	260-590	655-1970
	Feed (IPR)	.004-.012	.004-.012	.001-.012	.0047-.0118	.004-.008	.003-.016	.004-.012



### Caution

- \*The table is just a reference to determine cutting conditions. It should be adjusted according to the condition of the machine tool and workpiece.
- \*When long projection length type is used, it is necessary to lower feed rate.
- \*Since chips may scatter, utilize safety enclosures.
- \*Do not use oil-based cutting fluid, or a fire may take place.