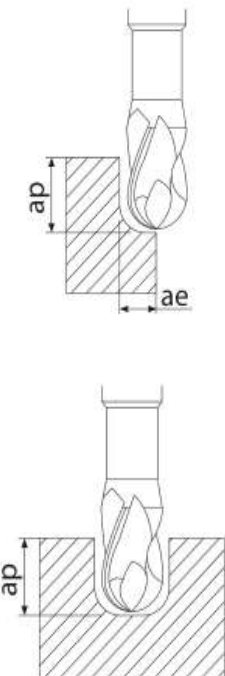


4 Flute ball nose end mill

Processing mode	Material	Mode	Dia(mm)	φ5	φ6	φ8	φ10	φ12	φ16	φ20
	soft steel	Side	Speed(min ⁻¹)	9400	7900	5900	4700	3900	2900	2400
			Feed(mm/min)	1020	1130	1270	1020	990	800	760
		Groove	Speed(min ⁻¹)	8600	7200	5400	4300	3600	2700	2200
			Feed(mm/min)	930	1030	1160	930	900	730	700
	stainless steel	Side	Speed(min ⁻¹)	5700	4800	3600	2900	2400	1800	1400
			Feed(mm/min)	620	630	630	640	560	450	390
		Groove	Speed(min ⁻¹)	5100	4200	3200	2500	2100	1600	1300
			Feed(mm/min)	550	610	570	550	500	400	350
	titanium alloy	Side	Speed(min ⁻¹)	3200	2700	2000	1600	1300	1000	800
			Feed(mm/min)	180	190	220	170	170	160	160
		Groove	Speed(min ⁻¹)	2900	2400	1800	1400	1200	900	700
			Feed(mm/min)	160	170	190	170	170	160	160
	heat-resisting alloy	Side	Speed(min ⁻¹)	1700	1400	1000	800	700	500	400
			Feed(mm/min)	70	80	100	80	90	90	80
		Groove	Speed(min ⁻¹)	1400	1200	900	700	600	400	400
			Feed(mm/min)	60	70	80	80	80	80	70
	grey cast iron	Side	Speed(min ⁻¹)	7800	6500	4900	3900	3200	2400	1900
			Feed(mm/min)	840	930	1050	840	820	660	630
		Groove	Speed(min ⁻¹)	7000	5800	4400	3500	2900	2200	1800
			Feed(mm/min)	760	840	950	760	740	600	570