

## Recommended Cutting Data

Material	Grade	SFM	Parameters	Face Milling		Side Milling	
				Low HP	High HP	Low HP	High HP
Gray Cast Iron	JC8118 JC8050	830	IPT	.010"	.014"	.010"	.014"
			DOC	.140"	.216"	.400"	.590"
			WOC	70%	70%	up to 6% of D	
Nodular Cast Iron	JC8118 JC8050	500	IPT	.010"	.014"	.010"	.014"
			DOC	.080"	.160"	.400"	.590"
			WOC	70%	70%	up to 6% of D	
Carbon Steel	JC8118 JC8050	660	IPT	.010"	.014"	.010"	.014"
			DOC	.080"	.160"	.400"	.590"
			WOC	70%	70%	up to 6% of D	
Low Alloy Steel	JC8118 JC8050	600	IPT	.010"	.014"	.010"	.014"
			DOC	.080"	.160"	.400"	.590"
			WOC	60%	60%	up to 6% of D	
Mold Steel	JC8118 JC8050	500	IPT	.010"	.014"	.010"	.014"
			DOC	.080"	.160"	.400"	.590"
			WOC	60%	60%	up to 6% of D	
Tool & Die Steel	JC8118	600	IPT	.008"	.012"	.008"	.012"
			DOC	.080"	.120"	.400"	.590"
			WOC	60%	60%	up to 5% of D	
Hardened Die Steel (40-50HRC)	JC8118	330	IPT	.006"	.010"	.006"	.010"
			DOC	.040"	.100"	.400"	.590"
			WOC	60%	60%	up to 3% of D	
Stainless Steel (Austenitic)	JC8050	400	IPT	.007"	.011"	.007"	.011"
			DOC	.080"	.160"	.400"	.590"
			WOC	60%	60%	up to 6% of D	
Stainless Steel (Martensitic)	JC8118	600	IPT	.008"	.012"	.010"	.014"
			DOC	.080"	.160"	.400"	.590"
			WOC	60%	60%	up to 6% of D	
Aluminum	FC18	990	IPT	.012"	.016"	.012"	.016"
			DOC	.080"	.160"	.400"	.590"
			WOC	70%	70%	up to 8% of D	

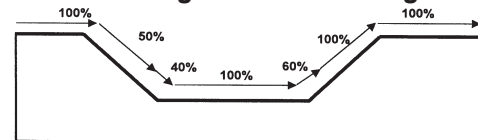
- NOTE:** 1. Above parameters should be adjusted according to the machine rigidity & work rigidity.  
 2. If chatter occurs, recommend to reduce DOC or spindle speed and maintain IPT.  
 3. If machine does not have enough power, recommend reducing DOC or spindle speed & feed.  
 4. Use air blow.  
 5. In case of slotting, reduce feed speed to 50%

## Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

**NOTE:** The above percentages should be applied, according to tool ratio.

## Reduced Cutting Data For Cutting Pattern



**NOTE:** Feed should be reduced when cutting the above pattern