Side Milling

Work Material		GR.1 Carbon Steel		GR.2 Low-alloyed Steel (~24HRC)		GR.3 Hi-alloyed Steel (~30HRC)		GR.4 Hardened Steel (30~38HRC)		GR.5 Hardened Steel (38~48HRC)		GR.8 Stainless Steel		GR.9 Cast Iron		GR.11 Copper	
Vc m/min		65		65		55		40		38		40		65		115	
Code No.	Dc	RPM (min-1)	Feed (mm/min)	RPM (min-1)	Feed (mm/min)	RPM (min-1)	Feed (mm/min)	RPM (min-1)	Feed (mm/min)	RPM (min-1)	Feed (mm/min)	RPM (min-1)	Feed (mm/min)	RPM (min-1)	Feed (mm/min)	RPM (min-1)	Feed (mm/min)
E126X/E128X-3	3	6,750	360	6,750	360	5,550	265	3,975	90	3,600	85	3,975	90	6,750	360	11,850	645
E126X/E128X-4	4	5,000	375	5,000	375	4,125	265	3,200	100	2,775	85	3,200	100	5,000	375	9,000	675
E126X/E128X-5	5	3,975	450	3,975	450	3,375	315	2,625	100	2,400	90	2,625	100	3,975	450	7,050	780
E126X/E128X-6	6	3,375	450	3,375	450	2,775	320	2,250	105	1,988	95	2,250	105	3,375	450	5,850	780
E126X-7	7	2,900	430	2,900	430	2,360	315	1,800	100	1,700	95	1,820	100	2,900	430	5,000	770
E126X/E128X-8	8	2,475	410	2,475	410	1,950	310	1,400	90	1,425	95	1,400	90	2,475	410	4,350	760
E126X-9	9	2,200	400	2,200	400	1,775	305	1,270	95	1,270	100	1,250	95	2,200	400	3,950	760
E126X/E128X-10	10	1,950	390	1,950	390	1,575	300	1,125	95	1,125	100	1,125	95	1,950	390	3,600	760
E126X-11	11	1,800	390	1,800	390	1,450	305	1,000	90	1,000	95	1,000	90	1,800	390	3,300	760
E126X/E128X-12	12	1,650	390	1,650	390	1,350	305	900	90	900	90	900	90	1,650	390	3,000	760
E126X-14	14	1,430	413	1,430	413	1,200	310	900	105	825	90	900	105	1,430	413	2,550	750
E126X/E128X-16	16	1,275	400	1,275	400	1,050	310	825	100	750	75	825	100	1,275	400	2,250	720
E126X/E128X-20	20	975	375	975	375	825	275	675	70	600	70	675	70	975	375	1,800	670
(mm)		ap:2.5D		ap:2.5D		ap:2.5D		ap:2.5D		ap:2.5D		ap:2.5D		ap:2.5D		ap:2.5D	
		ae:0.1D		ae:0.1D		ae:0.1D		ae:0.1D		ae:0.1D		ae:0.1D		ae:0.1D		ae:0.1D	

※ Notice: E128X is Long Length series End Mills. Please adjust the parameter according

1. Please work with good rigidity / high precision facilities and collet chuck.
2. Please choose proper cutting fluid.
3. The cutting data is reference value only. Please adjust it according to your real working conditions.
4. If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
5. If vibration occurs during cutting, please reduce cutting parameter.