

MC

Universal milling cutter, suitable for a wide range of materials, high cost performance, integrating roughness and fineness

Milling type

side Milling



workpiece	Vc (m/min)	Cutting Depth	D1		D2		D3		D4		D5		D6	
			(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)
Stainless steel, tempered steel	60-90	$ap \leq 1.5 \times DC$ $ae \leq 0.2 \times DC$	15900	509	8745	560	7420	712	6360	890	5406	930	4770	1011
Titanium alloy, nickel-based alloy, heat-resistant alloy	35-70	$ap \leq 1.5 \times DC$ $ae \leq 0.1 \times DC$	11130	267	5565	267	4770	382	4373	455	4134	562	3710	668
Forged steel, carbon steel, cast iron	80-120	$ap \leq 1.5 \times DC$ $ae \leq 0.3 \times DC$	23850	1049	11925	1049	8480	1018	7155	1288	6360	1526	6360	1781
Alloy steel, tool steel	70-100	$ap \leq 1.5 \times DC$ $ae \leq 0.3 \times DC$	20670	827	10335	827	7950	859	6758	1081	5724	1145	5300	1272

workpiece	Vc (m/min)	Cutting Depth	D8		D10		D12		D16		D20	
			(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)
Stainless steel, tempered steel	60-90	$ap \leq 1.5 \times DC$ $ae \leq 0.2 \times DC$	3578	973	2862	916	2385	954	1789	787	1431	687
Titanium alloy, nickel-based alloy, heat-resistant alloy	35-70	$ap \leq 1.5 \times DC$ $ae \leq 0.1 \times DC$	2783	646	2226	579	1855	594	1391	557	1113	490
Forged steel, carbon steel, cast iron	80-120	$ap \leq 1.5 \times DC$ $ae \leq 0.3 \times DC$	4770	1717	3816	1679	3180	1526	2385	1240	1908	1068
Alloy steel, tool steel	70-100	$ap \leq 1.5 \times DC$ $ae \leq 0.3 \times DC$	3975	1272	3180	1208	2650	1166	1988	954	1590	827

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Milling type

slot milling



workpiece	Vc (m/min)	Cutting Depth	D1		D2		D3		D4		D5		D6	
			(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)
Stainless steel, tempered steel	60-90	$D \leq 2, ap=0.3 \times DC$ $D > 2, ap=0.5 \times DC$	7950	191	3975	223	4240	373	3578	429	3816	581	3180	572
Titanium alloy, nickel-based alloy, heat-resistant alloy	35-70	$D \leq 2, ap=0.2 \times DC$ $D > 2, ap=0.3 \times DC$	7950	127	3975	159	3180	254	2385	267	2544	326	2120	339
Forged steel, carbon steel, cast iron	80-120	$D \leq 2, ap=0.5 \times DC$ $D > 2, ap=1.0 \times DC$	9540	305	4770	305	4240	407	3975	509	3816	611	3445	661
Alloy steel, tool steel	70-100	$D \leq 2, ap=0.5 \times DC$ $D > 2, ap=1.0 \times DC$	7950	191	3975	223	4240	373	3578	429	3816	580	3180	572

workpiece	Vc (m/min)	Cutting Depth	D8		D10		D12		D16		D20	
			(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)	(min-1)	Feed rate (mm/min)
Stainless steel, tempered steel	60-90	$D \leq 2, ap=0.3 \times DC$ $D > 2, ap=0.5 \times DC$	2385	572	1908	550	1590	509	1193	429	954	382
Titanium alloy, nickel-based alloy, heat-resistant alloy	35-70	$D \leq 2, ap=0.2 \times DC$ $D > 2, ap=0.3 \times DC$	1590	318	1272	331	1060	318	795	286	636	254
Forged steel, carbon steel, cast iron	80-120	$D \leq 2, ap=0.5 \times DC$ $D > 2, ap=1.0 \times DC$	2783	712	2226	712	1855	668	1391	557	1113	534
Alloy steel, tool steel	70-100	$D \leq 2, ap=0.5 \times DC$ $D > 2, ap=1.0 \times DC$	2385	572	1908	550	1590	509	1193	429	954	382