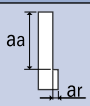
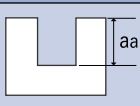




List 2104: 5 Flute, Regular Length, Reduced Neck, Square End

List 2110: 5 Flute, Regular Length, Reduced Neck, Corner Radius

	Side Milling			Slotting	
Cutting Speed	200-265 SFM			100-165 SFM	
Depth of Cut	$a_a \leq 1.8D$ $a_r = 0.2D$ 			$a_a \leq 1D$ 	
Mill Dia.	Speed RPM	Feed in/min	Speed RPM	Feed in/min	
12	1,900	33.7	1,100	10.8	
16	1,400	24.8	820	8.1	
20	1,100	23.6	655	7.7	
25	900	19.7	525	6.2	

1. Use a rigid and precise machine and holder.
2. The above cutting conditions are to be used as general guidelines. Please adjust the speed, feed and cutting depth according to actual cutting conditions.
3. Water soluble coolant is highly recommended.

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