
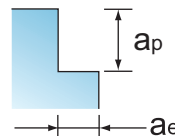



## CUTTING CONDITION - IPVR1T

FRACTIONAL

type	IPVR1T		
Side Milling 	TITANIUM ALLOYS (DIFFICULT) Ti10Al2Fe3Al, Ti5Al5V5Mo3Cr, Ti7Al4Mo, Ti3Al8V6Cr4Zr4Mo, Ti6Al6V6Sn, Ti15V3		
Hardness BRINELL	$\leq 300$		
HRC	$\leq 31$		
Vc (SFM)	60		
ae/ap	ae=0.4D ap=1.5D		
MILL DIA. (inch)	RPM	Fz	Feed (IPM) 4 flutes
1/8	5,014	0.0005	9.4
3/16	3,345	0.0007	10.0
1/4	2,507	0.0008	8.4
5/16	2,008	0.0010	7.8
3/8	1,671	0.0013	8.8
1/2	1,254	0.0017	8.4
5/8	1,008	0.0019	7.8
3/4	836	0.0023	7.5
Depth of cut			

type	IPVR1T		
Slot Milling 	TITANIUM ALLOYS (DIFFICULT) Ti10Al2Fe3Al, Ti5Al5V5Mo3Cr, Ti7Al4Mo, Ti3Al8V6Cr4Zr4Mo, Ti6Al6V6Sn, Ti15V3		
Hardness BRINELL	$\leq 300$		
HRC	$\leq 31$		
Vc (SFM)	60		
ae/ap	ae=1D ap=1.25D		
MILL DIA. (inch)	RPM	Fz	Feed (IPM) 4 flutes
1/8	4,013	0.0003	5.0
3/16	2,676	0.0006	6.0
1/4	2,006	0.0008	6.7
5/16	1,607	0.0010	6.3
3/8	1,338	0.0011	6.0
1/2	1,003	0.0017	6.7
5/8	806	0.0017	5.6
3/4	669	0.0021	5.5
Depth of cut	