




List 8220 - A Brand AE-LN-CR-VMS: 4 Flute, Long Neck, Corner Radius

Side Milling

Hardness	-	Up to 30 HRC	-	-	-	-	30-45 HRC							
Work Material	Mild Steels Carbon Steels Cast Iron	Tool Steels Alloy Steels	Stainless Steels	Precipitation Stainless	Titanium Alloy	Ni-Based Alloys Inconel 718	Prehardened Steels Hardened Steels							
Cutting Speed (SFM)	260-395	230-360	130-260	150-195	130-170	50-80	130-260							
Depth of Cut	 <table border="1"> <thead> <tr> <th>aa</th> <th>ar</th> </tr> </thead> <tbody> <tr> <td>1.5D</td> <td>0.02D</td> </tr> </tbody> </table>							aa	ar	1.5D	0.02D			
aa	ar													
1.5D	0.02D													
Mill Dia. (Inch)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)
1/4	5,191	62.3	4,809	46.2	2,748	16.5	2674	17.5	2598	16.6	1222	6.8	3,511	28.1
5/16	4,153	49.8	3,847	36.9	2,198	13.2	2139	14.3	2078	13.7	978	6.4	2,809	22.5
3/8	3,461	47.1	3,206	41.0	1,832	13.9	1783	13.7	1732	13.0	815	6.2	2,341	24.3
7/16	2,966	46.3	2,748	39.6	1,570	14.4	1528	13.4	1484	12.7	699	5.9	2,007	22.5
1/2	2,595	40.5	2,405	37.5	1,374	13.7	1337	13.2	1299	12.6	611	5.8	1,756	19.7
5/8	2,076	32.4	1,924	30.0	1,099	11.0	1070	13.0	1039	12.6	489	5.8	1,405	15.7
3/4	1,730	27.0	1,603	25.0	916	9.2	891	12.4	866	12.1	407	5.6	1,170	13.1
1	1,298	20.2	1,202	18.8	687	6.9	669	16.1	649	15.4	306	5.3	878	10.5

1. Use a rigid and precise machine and holder.
2. The rotational speed is calculated by the median of the recommended cutting speed.
3. Adjustments may be necessary depending on the rigidity or the workpiece, fixture, and machine.
4. Please use a suitable fluid with high smoke retardant properties.
5. During dry (no fluid) milling, please use air blow to remove chips from the milling area and to eliminate chip packing.
6. Please use water-soluble coolant when machining stainless steel.
7. Reduce speed and feed as well as depth of cut when high precision is required.

ABOUT OSG

DRILLING

THREADING

MILLING

HOLDERS

INDEX

