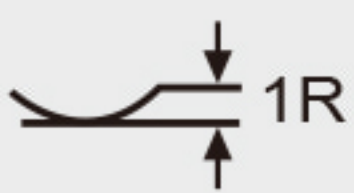



## List of recommended milling conditions for **MAB**(Side Milling)

Work Material	Copper			Aluminum		
Velocity	V=70-120m/min			V=100-250m/min		
RADIUS	SPEED (mm <sup>-1</sup> )	FEED(mm/mim)		SPEED (mm <sup>-1</sup> )	FEED(mm/mim)	
		Rough Milling	Refined Milling		Rough Milling	Refined Milling
R0.5	37680	250	700	47000	320	860
R0.75	25500	250	700	47000	320	860
R1	19100	250	700	23800	600	1650
R1.5	12700	300	900	16000	750	1650
R2	9500	300	900	12000	750	1650
R3	6400	300	900	8000	750	1650
R4	4800	300	900	6000	750	1650
R5	3800	300	900	4800	750	1650
R6	3200	300	900	4200	750	1650
	Rough Milling 			Refined Milling 		

Work Material	Copper Alloys		Aluminum Alloys	
Velocity	V=70-120m/min		V=100-250m/min	
RADIUS	SPEED (mm <sup>-1</sup> )	FEED(mm/mim)	SPEED (mm <sup>-1</sup> )	FEED(mm/mim)
		Refined Milling		Refined Milling
R3	13000	4800	26500	8000
R4	10000	4000	19500	9500
R5	8000	3200	15500	9000
R6	6600	2400	13000	8000
	Refined Milling 