Recommended cutting conditions

CRH 4 teeth

(Unit: mm)

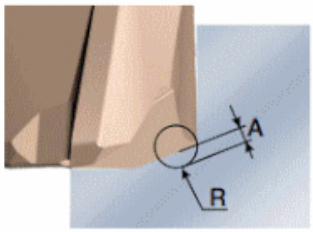
Diameter	Cutting speed (m/min)	Feed (mm/tooth)	Shouldering, profiling	
			ap	ae
Ø6	300-1000	0.1-0.15	-0.05xD	-0.6xD
Ø8	300-1000	0.1-0.2	-0.05xD	-0.6xD
Ø10	300-1000	0.1-0.2	-0.05xD	-0.6xD
Ø12	300-1000	0.1-0.3	-0.05xD	-0.6xD
Ø16	300-1000	0.1-0.3	-0.05xD	-0.6xD

- ap must not exceed a maximum 1 mm
- Apply a 30% reduction in feed during ramping (less 2.5°)

ap: axial direction DOC
ae: radial direction DOC

Programming tip - CRH

Diameter (CRH 4 teeth)	R (Program)	A Un-machined material thickness
Ø6	0.7	0.35
Ø8	0.9	0.47
Ø10	1.0	0.50
Ø12	1.4	0.70
Ø16	1.8	0.95



Optimal conditions for TaeguTec ceramic end mills

Recommendations	Details	Remarks
Down cutting	Down cutting is highly recommended Up cutting can lead to rapid wear of the cutting edge and the possibility of the workpiece material's hardened surface	Finish margin: over 0.3 mm
High cutting speed	By maintaining a high cutting speed, the cutting tool minimizes wear and damage by generating the heat needed to soften the material	
Do not use coolant	To prevent the occurrence of thermal crack, it is recommended not to use coolant or air blowing	Air blowing is only recommended for use when good chip evacuation is required
Tool holder	Recommendation for tool holding is a hydraulic chuck or a precision milling chuck for stable machining	Heating chuck is disabled
Do not remove built-up-edges	Do not manually remove any built-up-edge as this may cause damage to the insert's cutting edge	

CRH High feed 4 flutes end mill type

