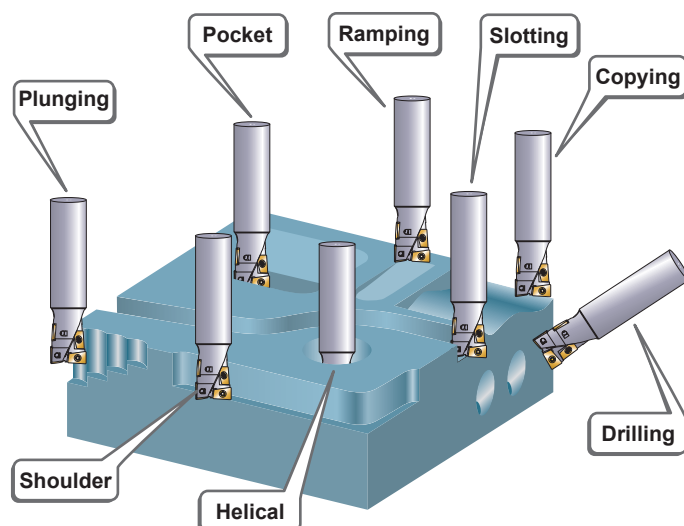


CUTTING MODES



	φ25, φ26			φ32, φ33			φ35			φ40			φ50		
	Depth of Cut (mm)	Width of Cut (mm)	Feed (mm/rev)	Depth of Cut (mm)	Width of Cut (mm)	Feed (mm/rev)	Depth of Cut (mm)	Width of Cut (mm)	Feed (mm/rev)	Depth of Cut (mm)	Width of Cut (mm)	Feed (mm/rev)	Depth of Cut (mm)	Width of Cut (mm)	Feed (mm/rev)
	-7.5	-12.5	0.35	-9.5	-16	0.40	-11	-17.5	0.45	-12	-20	0.50	-15	-25	0.60
	7.5-17	-8	0.28	9.5-22	-11	0.32	11-25	-12	0.35	12-28	-13	0.40	15-35	-16	0.50
	17-27	-5	0.20	22-35	-6	0.25	25-40	-6.5	0.28	28-44	-7	0.30	35-55	-10	0.35
	-7.5	-12.5	0.30	-9.5	-16	0.35	-11	-17.5	0.37	-12	-20	0.40	-15	-25	0.50
	7.5-17	-7	0.25	9.5-22	-10	0.28	11-25	-11	0.30	12-28	-12	0.32	15-35	-14	0.40
	17-27	-4	0.18	22-35	-5	0.20	25-40	-5.5	0.22	28-44	-6	0.25	35-55	-8	0.30
	-7.5	-12.5	0.30	-9.5	-16	0.35	-11	-17.5	0.37	-12	-20	0.40	-15	-25	0.50
	7.5-17	-7	0.25	9.5-22	-10	0.28	11-25	-12	0.30	12-28	-12	0.32	15-35	-14	0.40
	17-27	-4	0.18	22-35	-5	0.20	25-40	-6.5	0.22	28-44	-6	0.25	35-55	-8	0.30
	-7.5	-12.5	0.35	-9.5	-16	0.40	-11	-17.5	0.45	-12	-20	0.50	-15	-25	0.60
	7.5-17	-8	0.28	9.5-22	-11	0.32	11-25	-12	0.35	12-28	-13	0.40	15-35	-16	0.50
	17-27	-5	0.20	22-35	-6	0.25	25-40	-6.5	0.28	28-44	-7	0.30	35-55	-10	0.35
	-7.5	-17.5	0.40	-9.5	-23	0.45	-11	-24.5	0.50	-12	-28	0.55	-15	-35	0.65
	7.5-17	-12.5	0.33	9.5-22	-16	0.37	11-25	-17.5	0.40	12-28	-20	0.45	15-35	-25	0.55
	17-27	-7.5	0.25	22-35	-10	0.30	25-40	-10.5	0.32	28-44	-12	0.35	35-55	-15	0.40
	-7.5	-7	0.22	-9.5	-8	0.25	-11	-9	0.28	-12	-10	0.30	-15	-14	0.35
	7.5-17	-4	0.18	9.5-22	-5	0.20	11-25	-5.5	0.22	12-28	-6	0.24	15-35	-8	0.30
	17-27	-2	0.14	22-35	-2	0.16	25-40	-2	0.17	28-44	-2	0.18	35-55	-4	0.22

	φ25, φ26		φ32, φ33		φ35		φ40		φ50	
	Depth of Cut (mm)	Feed (mm/rev)	Depth of Cut (mm)	Feed (mm/rev)	Depth of Cut (mm)	Feed (mm/rev)	Depth of Cut (mm)	Feed (mm/rev)	Depth of Cut (mm)	Feed (mm/rev)
	-7.5	0.20	-9.5	0.25	-11	0.27	-12	0.30	-15	0.35
	7.5-17	0.16	9.5-22	0.20	11-25	0.22	12-28	0.25	15-35	0.30
	17-27	0.12	22-35	0.14	25-40	0.16	28-44	0.18	35-55	0.22
	-7.5	0.18	-9.5	0.20	-11	0.22	-12	0.25	-15	0.30
	7.5-17	0.14	9.5-22	0.16	11-25	0.18	12-28	0.20	15-35	0.25
	17-27	0.10	22-35	0.12	25-40	0.13	28-44	0.14	35-55	0.16
	-7.5	0.18	-9.5	0.20	-11	0.22	-12	0.25	-15	0.30
	7.5-17	0.14	9.5-22	0.16	11-25	0.18	12-28	0.20	15-35	0.25
	17-27	0.10	22-35	0.12	25-40	0.13	28-44	0.14	35-55	0.16
	-7.5	0.20	-9.5	0.25	-11	0.27	-12	0.30	-15	0.35
	7.5-17	0.16	9.5-22	0.20	11-25	0.22	12-28	0.25	15-35	0.30
	17-27	0.12	22-35	0.14	25-40	0.16	28-44	0.18	35-55	0.22
	-7.5	0.22	-9.5	0.27	-11	0.30	-12	0.32	-15	0.37
	7.5-17	0.18	9.5-22	0.22	11-25	0.25	12-28	0.27	15-35	0.32
	17-27	0.14	22-35	0.16	25-40	0.18	28-44	0.20	35-55	0.25
	-7.5	0.14	-9.5	0.16	-11	0.17	-12	0.18	-15	0.22
	7.5-17	0.12	9.5-22	0.12	11-25	0.13	12-28	0.14	15-35	0.16