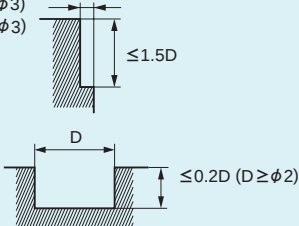
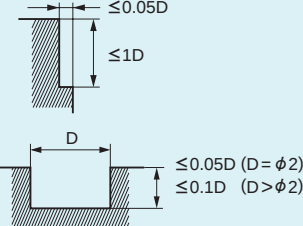
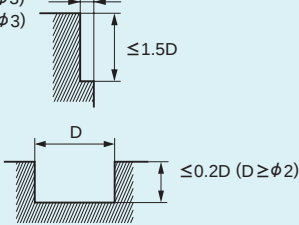


RECOMMENDED CUTTING CONDITIONS

Work material	Carbon steel, Alloy steel (—30HRC) Cast iron		Alloy steel, Tool steel, Pre-hardened steel (30—45HRC)		Stainless steel		Hardened steel (45—55HRC)	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
2	15000	600	10000	400	9100	300	8000	120
3	10000	600	7000	400	6000	300	5000	120
4	7500	600	5200	400	4500	300	4000	120
5	6000	600	4200	400	3600	300	3200	120
6	5000	600	3500	400	3000	300	2700	120
8	4000	520	2800	350	2400	260	2000	110
10	3200	450	2200	300	1900	230	1600	100
12	2700	410	1900	270	1600	210	1300	100
Depth of cut	$\leq 0.1D$ ($D \leq \phi 3$) $\leq 0.2D$ ($D > \phi 3$) 				$\leq 0.05D$ $\leq 1D$ 			

D:Dia.

Work material	Titanium		High Nickel Inconel	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
2	6400	210	3200	50
3	4200	210	2100	50
4	3200	210	1600	50
5	2500	210	1300	50
6	2100	210	1000	45
8	1600	170	800	45
10	1300	160	600	40
12	1000	130	530	40
Depth of cut	$\leq 0.1D$ ($D \leq \phi 3$) $\leq 0.2D$ ($D > \phi 3$) 			

D:Dia.

1) When using high efficiency conditions, the surface speeds/feeds can be increased by 2-3 times the above values.

