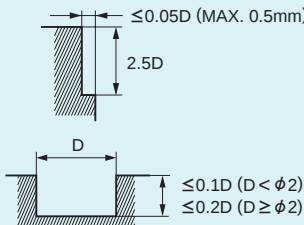
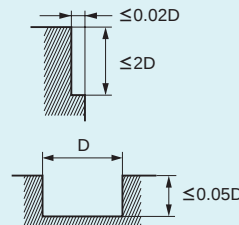


RECOMMENDED CUTTING CONDITIONS

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)
1	13000	90	9500	70	8000	50	6400	40
1.5	8500	90	6400	70	5300	50	4200	40
2	6400	90	4800	70	4000	50	3200	40
3	4200	100	3400	80	2600	60	2100	40
4	3400	120	2700	100	2100	75	1700	50
5	2900	150	2300	120	1800	90	1500	60
6	2500	180	2000	150	1500	110	1300	75
8	1900	200	1500	150	1200	120	1000	75
10	1600	200	1300	150	950	110	800	75
12	1300	180	1100	150	800	110	670	75
Depth of cut	 $\leq 0.05D$ (MAX. 0.5mm) $2.5D$ D $\leq 0.1D$ ($D < \phi 2$) $\leq 0.2D$ ($D \geq \phi 2$)				 $\leq 0.02D$ $\leq 2D$ D $\leq 0.05D$			

D:Dia.