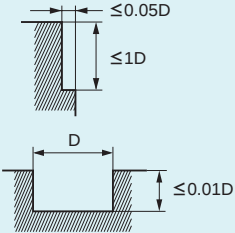
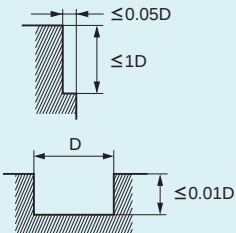


RECOMMENDED CUTTING CONDITIONS

Work material	Carbon steel, Alloy steel (—30HRC) Cast iron		Alloy steel, Tool steel, Pre-hardened steel (30—45HRC)		Stainless steel, Hardened steel (45—55HRC) Heat resistant steel	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
6	20000	8100	14000	5400	12000	4080
8	16000	7200	11200	4680	9600	3540
10	12800	6000	8800	4080	7600	3060
12	10800	5580	7600	3720	6400	2820
16	8000	3600	5600	2520	4800	2160
20	6400	2880	4400	1980	3800	1800
Depth of cut	 D: Dia.					

Work material	Titanium TiAl6V4		Nickel (Heat resistant alloys) Inconel 718	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
6	8000	2700	2100	710
8	6000	2200	1600	590
10	5000	2000	1200	480
12	4000	1760	1000	440
16	3000	1350	800	360
20	2400	1150	640	300
Depth of cut	 D: Dia.			