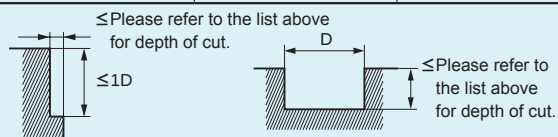


RECOMMENDED CUTTING CONDITIONS

Work material	Copper, Copper alloys		
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut (mm)
0.2	40000	600	0.01
0.3	40000	600	0.01
0.4	40000	800	0.01
0.5	40000	960	0.015
0.6	40000	1200	0.02
0.7	40000	1400	0.02
0.8	40000	1600	0.03
0.9	40000	1800	0.04
1	40000	2000	0.06
1.5	40000	3000	0.12
2	30000	3000	0.18
2.5	24000	2600	0.25
3	20000	2300	0.30
4	15000	2000	0.40
5	12000	1600	0.50
6	10000	1400	0.60
8	8000	1000	0.80
10	6400	900	1.00
12	5400	820	1.00
Depth of cut	 ≤ Please refer to the list above for depth of cut. ≤ 1D D ≤ Please refer to the list above for depth of cut. D: Dia.		

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) Water-soluble cutting fluid is recommended.
- 3) When drilling, please set the feed rate at 1/3 or below of the table value.
- 4) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.