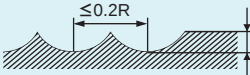
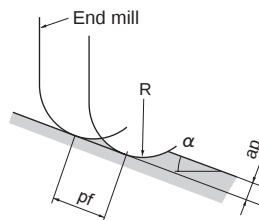


RECOMMENDED CUTTING CONDITIONS

Work material	Copper, Copper alloys				
R (mm)	$\alpha \leq 15^\circ$		$\alpha > 15^\circ$		Depth of cut (mm)
	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	
R0.2	40000	1600	40000	1200	0.02
R0.3	40000	3200	40000	1600	0.03
R0.4	40000	6400	40000	2400	0.05
R0.5	40000	8000	40000	3200	0.06
R0.75	40000	9600	40000	4000	0.09
R1	40000	9600	39000	4700	0.11
R1.25	40000	12000	30000	4500	0.12
R1.5	40000	12000	27000	4300	0.13
R2	32000	11000	20000	3600	0.15
R2.5	25000	9000	16000	2900	0.20
R3	21000	8400	13000	2600	0.25
R4	16000	6400	10000	2000	0.30
R5	13000	5200	8000	1700	0.50
R6	9000	3600	6000	1300	0.50
Depth of cut	 ≤ Please refer to the list above for depth of cut. R:Radius				



- 1) α is the inclination angle of the machined surface.
- 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 3) Water-soluble cutting fluid is recommended.
- 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.