

RECOMMENDED CUTTING CONDITIONS

Work material		Copper, Copper alloys		
R (mm)	Neck length (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut (mm)
R0.1	0.5	40000	800	0.003
	1.0	40000	600	0.002
	1.5	40000	400	0.001
R0.15	1	40000	1200	0.007
	2	40000	800	0.003
R0.2	1	40000	2000	0.015
	2	40000	1300	0.01
	3	40000	800	0.005
R0.25	2	40000	2000	0.02
	4	40000	1200	0.01
	6	36000	600	0.006
	10	26000	200	0.002
R0.3	2	40000	3200	0.03
	6	40000	1200	0.008
	10	30000	500	0.003
R0.4	4	40000	4000	0.02
	6	40000	2500	0.02
	10	30000	700	0.008
R0.5	4	40000	6400	0.05
	6	40000	4800	0.03
	8	40000	3000	0.02
	10	33000	2000	0.01
	16	18000	500	0.008
	20	13000	250	0.005

Work material		Copper, Copper alloys		
R (mm)	Neck length (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut (mm)
R0.75	8	40000	8000	0.07
	12	35000	4500	0.04
	16	20000	2000	0.03
	20	12000	900	0.02
R1	8	40000	9600	0.10
	10	40000	6400	0.08
	12	40000	6000	0.08
	16	30000	3000	0.05
	20	20000	2000	0.04
	30	10000	800	0.02
R1.5	16	40000	12000	0.10
	25	25000	6000	0.08
	35	6000	700	0.06
R2	16	32000	11000	0.15
	20	32000	9000	0.15
	30	20000	4500	0.10
	40	15000	3000	0.08
	50	8000	1000	0.05
R2.5	20	25000	9500	0.20
	30	20000	3300	0.15
R3	30	21000	8400	0.20
	50	20000	3000	0.15

Depth of cut				
		R:Radius		

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) Water-soluble cutting fluid is recommended.
- 3) Cutting conditions may be considerably different due to the overhang (milling depth), depth of cut, and machine tool. Please see the above table as a standard.