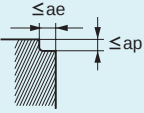


RECOMMENDED CUTTING CONDITIONS

Work material		Copper, Copper alloys			
Dia. (mm)	Corner radius (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut	
				ap (mm)	ae (mm)
6	R0.2, R0.3, R0.5	10000	1400	6	0.6
	R1	10000	1700	6	0.6
8	R0.3, R0.5	8000	1000	8	0.8
	R1	8000	1200	8	0.8
10	R0.3, R0.5	6400	900	10	1.0
	R1	6400	1100	10	1.0
12	R0.3, R0.5	5400	800	12	1.0
	R1	5400	1000	12	1.0
Depth of cut					

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