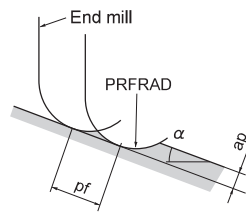
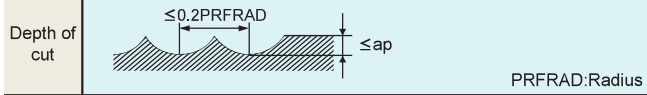


## RECOMMENDED CUTTING CONDITIONS

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



- 1)  $\alpha$  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.