

▣ LDS series

MATERIAL	S15C-SS400 ~500N/mm ²		S45C		SCM440		SKD61 28HRC		SKD61 34HRC		FC250		AC4D	
V	63~80m/min		40~63m/min		32~50m/min		20~28m/min		16~22m/min		63~100m/min		80~160m/min	
DIAMETER (mm)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)	RPM (mm ⁻¹)	FEED (mm/rev)
3	7,500	0.04-0.08	5,500	0.04-0.08	4,500	0.04-0.08	2,500	0.04-0.08	1,500	0.04-0.08	8,000	0.05-0.09	12,000	0.10-0.22
4	5,700	0.05-0.10	4,100	0.05-0.10	3,300	0.05-0.10	1,900	0.05-0.10	1,100	0.05-0.1	6,500	0.07-0.12	9,500	0.12-0.25
6	3,800	0.06-0.12	2,700	0.06-0.12	2,300	0.06-0.12	1,250	0.06-0.12	750	0.06-0.12	4,300	0.12-0.18	6,400	0.14-0.28
8	2,800	0.08-0.15	2,000	0.08-0.15	1,700	0.08-0.15	950	0.08-0.15	550	0.08-0.15	3,200	0.13-0.20	4,800	0.18-0.32
10	2,300	0.10-0.18	1,700	0.10-0.18	1,400	0.10-0.18	750	0.10-0.18	450	0.1-0.18	2,600	0.17-0.25	3,800	0.22-0.36
12	1,900	0.12-0.21	1,400	0.12-0.21	1,200	0.12-0.21	650	0.12-0.21	370	0.12-0.21	2,200	0.21-0.30	3,200	0.25-0.40
16	1,400	0.16-0.28	1,000	0.16-0.28	900	0.16-0.28	500	0.16-0.28	280	0.16-0.28	1,600	0.24-0.32	2,400	0.32-0.48
20	1,150	0.20-0.34	820	0.20-0.34	700	0.20-0.34	400	0.20-0.34	220	0.2-0.34	1,300	0.26-0.40	1,900	0.40-0.60
25	900	0.25-0.45	650	0.25-0.45	560	0.25-0.45	300	0.25-0.45	180	0.25-0.45	1,000	0.30-0.50	1,500	0.50-0.75

▣ Recommendation of Cutting Conditions in Reamer

Material	WORKPIECE		DIAMETER	CUTTING CONDITIONS		
	Tensile strength(Kg/mm ²)	Hardness(HB)		V (m/min)	f (mm/rev)	
Carbon Steel Alloy Steel	~ 100		~10	8 ~ 12	0.15 ~ 0.25	
			10~25		0.20 ~ 0.40	
			25~40		0.30 ~ 0.50	
Steel Castings	40 ~ 50		~10	8 ~ 12	0.15 ~ 0.25	
			10~25		0.20 ~ 0.40	
				25~40		0.30 ~ 0.50
	50 ~ 70		~10	6 ~ 10	0.12 ~ 0.20	
10~25			0.15 ~ 0.30			
			25~40		0.20 ~ 0.40	
Cast Irons		~ 200	~10	8 ~ 15	0.20 ~ 0.30	
			10~25		0.30 ~ 0.50	
				25~40		0.40 ~ 0.70
	200 ~		~10	6 ~ 12	0.15 ~ 0.25	
10~25			0.20 ~ 0.40			
			25~40		0.30 ~ 0.50	
Aluminum Alloys			~10	15 ~ 25	0.20 ~ 0.30	
			10~25	20 ~30	0.30 ~ 0.50	
			25~40		0.40 ~ 0.70	