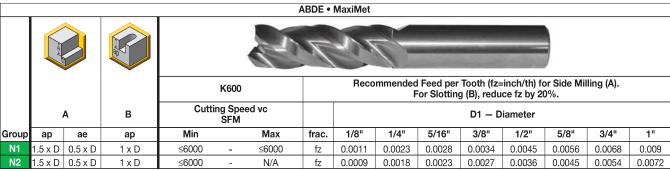


Lower value of cutting speed is used for high-stock removal applications or for higher hardness (machinability) within group

Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.

Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters on diameters greater than 1/2". For long lengths, reduce fz by 20%.



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