RECOMMENDED CUTTING CONDITIONS

Dry cutting

	Work Material	Hardness	Grade	Cutting Speed **vc** (m/min)	Feed per Tooth **fz** (mm/t.)
M	Austenitic Stainless Steel	≤200HB	**MC7020**	220 (170—270)	0.2 (0.1—0.35)
			MP7130	200 (150—250)	0.2 (0.1—0.35)
	Austenitic Stainless Steel	>200HB	**MC7020**	190 (140—240)	0.2 (0.1—0.35)
			MP7130	170 (120—220)	0.2 (0.1—0.35)
	Two-phase Stainless Steel	≤280HB	**MC7020**	180 (130—230)	0.2 (0.1—0.35)
			MP7130	160 (110—210)	0.2 (0.1—0.35)
	Ferritic and Martensitic Stainless Steel	≤200MPa	**MC7020**	240 (190—290)	0.2 (0.1—0.35)
			MP7130	200 (150—250)	0.2 (0.1—0.35)
	Ferritic and Martensitic Stainless Steel	>200HB	**MC7020**	240 (190—290)	0.2 (0.1—0.35)
			MP7130	200 (150—250)	0.2 (0.1—0.35)
	Ferritic and Martensitic Stainless Steel	<450HB	**MC7020**	170 (120—220)	0.2 (0.1—0.35)
			MP7130	150 (100—200)	0.2 (0.1—0.35)

Wet cutting

	Work Material	Hardness	Grade	Cutting Speed **vc** (m/min)	Feed per Tooth **fz** (mm/t.)
M	Austenitic Stainless Steel	≤200HB	**MC7020**	150 (100—200)	0.2 (0.1—0.35)
			MP7130	130 (80—180)	0.2 (0.1—0.35)
	Austenitic Stainless Steel	>200HB	**MC7020**	120 (70—170)	0.2 (0.1—0.35)
			MP7130	100 (80—150)	0.2 (0.1—0.35)
	Two-phase Stainless Steel	≤280HB	**MC7020**	120 (70—170)	0.2 (0.1—0.35)
			MP7130	100 (80—150)	0.2 (0.1—0.35)
	Ferritic and Martensitic Stainless Steel	≤200MPa	**MC7020**	170 (120—220)	0.2 (0.1—0.35)
			MP7130	130 (80—180)	0.2 (0.1—0.35)
	Ferritic and Martensitic Stainless Steel	>200HB	**MC7020**	170 (120—220)	0.2 (0.1—0.35)
			MP7130	130 (80—180)	0.2 (0.1—0.35)
	Ferritic and Martensitic Stainless Steel	<450HB	**MC7020**	110 (60—160)	0.2 (0.1—0.35)
			MP7130	90 (50—140)	0.2 (0.1—0.35)
S	Titanium Alloy	—	**MP9130**	45 (30—55)	0.1 (0.05—0.15)
	Heat Resistant Alloy	—	**MP9130**	35 (15—45)	0.1 (0.05—0.15)

* Actual cutting conditions are estimated to avoid chatter vibration with high rigidity of a machine or workpiece.
  Make appropriate adjustments when chatter and/or insert chipping occurs during cutting.
  Use with lowered conditions when there is a big overhang and/or when pocket-cutting.
* The setting level for feeding 1 blade is ap = 2.5mm with ARP5 axial cutting. With ARP6, use ap = 3mm.
  Use while matching the ap fluctuation and correction value F of the respective table.
  Ex. Feed for the recommended 1 blade when ARP5,SUS304, MP7130,ap=1: 0.2 mm/t.×1.5 (correction value F)=0.3 mm/t.
* On entry, reduce the feed at 70%. For ramping, drilling, and plunging, use 50% level.
* Internal coolant is recommended in titanium alloy and heat resistant alloy cutting.
  When the coolant nozzle of separately sold is used, it is more effective.

Correction level F feed amount for 1 blade, based on axial cutting ap fluctuation

Holder	ap=0.5mm	ap=1mm	ap=1.5mm	ap=2mm	ap=2.5mm	ap=3mm	ap=3.5mm	ap=4mm	ap=5mm	ap=6mm
ARP5	2.3	1.5	1.2	1.1	1.0	0.9	0.8	0.8	0.8	–
ARP6	2.5	1.7	1.3	1.1	1.0	1.0	0.9	0.9	0.8	0.8