

RECOMMENDED CUTTING CONDITIONS

Work material	Carbon steel, Cast iron, Alloy steel, Pre-hardened steel AISI 1050, AISI No 35 B, AISI P20, AISI P21			Hardened steel (45—55HRC) AISI H13			
	Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut (mm)
2	30000	4500	0.18	24000	3600	0.10	
2.5	24000	3900	0.25	19000	3000	0.13	
3	20000	3500	0.30	16000	2700	0.15	
4	15000	3000	0.40	12000	2400	0.20	
5	12000	2400	0.50	9000	1800	0.25	
6	10000	2100	0.60	7000	1470	0.30	
8	8000	1500	0.80	5600	1050	0.40	
10	6400	1400	1.00	4500	950	0.50	
12	5400	1200	1.00	3800	860	0.50	
16	2400	550	2.00	1200	120	0.80	
20	1900	480	3.00	1000	100	1.00	

Depth of cut

DC: Dia.

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) When slotting with end mills with $\phi 3$ or larger, reduce the revolution to 50—70% and the feed rate to 40—60%.
- 3) When drilling, please set the feed rate at 1/3 or below the values above.
- 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.