

RECOMMENDED CUTTING CONDITIONS

Work material	Hardened steel (45—55HRC)			Hardened steel (55—62HRC)		
	AISI H13			AISI D2		
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)
0.5	40000	2000	0.03	30000	600	0.02
1	40000	3000	0.05	20000	900	0.03
1.5	40000	5000	0.08	18000	1100	0.05
2	40000	5600	0.10	16000	1300	0.06
3	34000	5600	0.15	13000	1600	0.09

≤Please refer to the list above for depth of cut.

DC:Dia.

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) The above condition are for shoulder milling. For slotting $\phi 3$ or larger diameters, set the revolution, feed rate and depth of cut at 20—40% of the table figures.
- 3) 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.

Slot milling with small diameter tools

Work material	Hardened steel (45—55HRC)			Hardened steel (55—62HRC)		
	AISI H13			AISI D2		
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)
0.5	20000	200	0.05	15000	90	0.03
1	15000	300	0.1	11000	110	0.05
1.5	10000	280	0.15	7500	150	0.07
2	8000	320	0.2	6000	190	0.1

Please refer to the list above for depth of cut.

DC:Dia.

- 1) Air blow or oil mist is recommended for good chip evacuation.