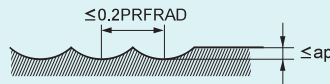


RECOMMENDED CUTTING CONDITIONS

Work material		Copper, Copper alloys			Work material		Copper, Copper alloys		
R PRFRAD (mm)	Neck length LU (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ap(mm)	R PRFRAD (mm)	Neck length LU (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ap(mm)
R0.1	0.5	40000	800	0.003	R0.75	8	40000	8000	0.07
	1.0	40000	600	0.002		12	35000	4500	0.04
	1.5	40000	400	0.001		16	20000	2000	0.03
R0.15	1	40000	1200	0.007		20	12000	900	0.02
	2	40000	800	0.003	R1	8	40000	9600	0.10
R0.2	1	40000	2000	0.015		10	40000	6400	0.08
	2	40000	1300	0.01		12	40000	6000	0.08
	3	40000	800	0.005		16	30000	3000	0.05
R0.25	2	40000	2000	0.02		20	20000	2000	0.04
	4	40000	1200	0.01	30	10000	800	0.02	
	6	36000	600	0.006	R1.5	16	40000	12000	0.10
	10	26000	200	0.002		25	25000	6000	0.08
R0.3	2	40000	3200	0.03	35	6000	700	0.06	
	6	40000	1200	0.008	R2	16	32000	11000	0.15
	10	30000	500	0.003		20	32000	9000	0.15
R0.4	4	40000	4000	0.02		30	20000	4500	0.10
	6	40000	2500	0.02		40	15000	3000	0.08
	10	30000	700	0.008	50	8000	1000	0.05	
R0.5	4	40000	6400	0.05	R2.5	20	25000	9500	0.20
	6	40000	4800	0.03		30	20000	3300	0.15
	8	40000	3000	0.02	R3	30	21000	8400	0.20
	10	33000	2000	0.01		50	20000	3000	0.15
	16	18000	500	0.008					
	20	13000	250	0.005					

Depth of cut



PRFRAD:Radius

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) Water-soluble cutting fluid is recommended.
- 3) Cutting condition may be considerably different due to the overhang (milling depth), depth of cut, and machine tools. Please see the above table as a standard.