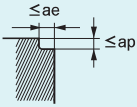


## RECOMMENDED CUTTING CONDITIONS

Work material		Copper, Copper alloys			
Dia. DC (mm)	Corner radius RE (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Depth of cut	
				ap (mm)	ae (mm)
6	<b>R0.2, R0.3, R0.5</b>	10000	1400	6	0.6
	<b>R1</b>	10000	1700	6	0.6
8	<b>R0.3, R0.5</b>	8000	1000	8	0.8
	<b>R1</b>	8000	1200	8	0.8
10	<b>R0.3, R0.5</b>	6400	900	10	1.0
	<b>R1</b>	6400	1100	10	1.0
12	<b>R0.3, R0.5</b>	5400	800	12	1.0
	<b>R1</b>	5400	1000	12	1.0
Depth of cut					

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) Water-soluble cutting fluid is recommended.
- 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.