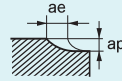


RECOMMENDED CUTTING CONDITIONS

Work material	Hardened steel (45—55HRC)				Hardened steel (55—62HRC)				Hardened steel (62—70HRC)			
	AISI H13				AISI D2				AISI W1, AISI M2			
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ap (mm)	Depth of cut ae (mm)
0.5	50000	750	0.01	0.2	50000	600	0.01	0.1	40000	400	0.005	0.06
1	38000	1100	0.02	0.3	38000	760	0.01	0.2	25000	400	0.01	0.1
1.5	25000	900	0.03	0.5	25000	700	0.02	0.4	17000	340	0.02	0.2
2	20000	800	0.04	0.7	20000	600	0.03	0.6	12000	300	0.02	0.3



DC:Dia.

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) Oil mist coolant 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.