


## RECOMMENDED CUTTING CONDITIONS

### Slotting

Work material	Carbon steel, Cast iron, Alloy steel (—30HRC)			Alloy steel, Tool steel, Pre-hardened steel			Hardened steel (45—55HRC)		
	AISI 1050, AISI No 35 B, AISI P20			AISI H13, AISI W1-10, AISI P21			AISI H13		
Dia. DC (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Depth of cut (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Depth of cut (mm)
<b>0.2</b>	40000	320	0.005	40000	180	0.004	40000	100	0.002
<b>0.3</b>	40000	400	0.006	40000	220	0.005	35000	130	0.003
<b>0.4</b>	40000	450	0.008	40000	270	0.006	31000	150	0.004
<b>0.5</b>	37000	500	0.010	32000	320	0.008	25000	160	0.005
<b>0.6</b>	32000	530	0.013	26000	340	0.010	21000	170	0.006
<b>0.7</b>	27000	560	0.015	23000	380	0.011	18000	180	0.007
<b>0.8</b>	24000	610	0.018	20000	410	0.013	16000	210	0.008
<b>0.9</b>	21000	610	0.020	18000	450	0.015	14000	210	0.009
<b>1</b>	19000	610	0.025	16000	450	0.020	13000	210	0.010
<b>1.5</b>	13000	720	0.040	11000	540	0.030	8500	270	0.015

Depth of cut



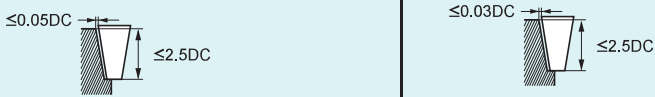
Please refer to the list above for depth of cut.

DC: Dia.

### Side milling

Work material	Carbon steel, Cast iron, Alloy steel (—30HRC)		Alloy steel, Tool steel, Pre-hardened steel		Hardened steel (45—55HRC)	
	AISI 1050, AISI No 35 B, AISI P20		AISI H13, AISI W1-10, AISI P21		AISI H13	
Dia. DC (mm)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)	Revolution (min <sup>-1</sup> )	Feed rate (mm/min)
<b>2</b>	9500	720	8000	540	6400	300
<b>2.5</b>	7800	800	6300	540	5000	300
<b>3</b>	6400	800	5300	540	4200	300
<b>4</b>	4800	800	4000	540	3200	300
<b>5</b>	3800	800	3200	540	2500	300
<b>6</b>	3200	800	2600	540	2100	300
<b>8</b>	2400	700	2000	480	1600	270
<b>10</b>	1900	600	1600	410	1300	240

Depth of cut



DC: Dia.

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