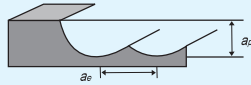


[B302, BL422 series]

WORKPIECE	CARBON STEELS · ALLOY STEELS · TOOLS STEELS		ALLOY STEELS · TOOLS STEELS	
HARDNESS	~ HB225		HB225~325	
DIAMETER(mm)	RPM	FEED	RPM	FEED
R0.5	31,800	572	27,900	502
R1	31,800	1,910	27,900	1,670
R2	15,900	1,910	13,900	1,670
R3	10,600	1,910	9,280	1,670
R4	7,960	1,910	6,960	1,670
R5	6,370	1,780	5,570	1,560
R6	5,310	1,590	4,640	1,390
R8	4,000	1,300	3,500	1,050
R10	3,200	1,000	2,800	840
R12.5	2,400	800	2,100	650

RPM = rev. / min.
FEED = mm / min.



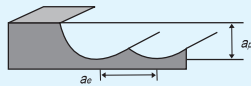
R	ap	ae
$R \leq 1,0$	0,05 x up to R	0,2 x up to R
$1,0 < R$	0,1 x up to R	0,2 x up to R

※ Please reduce cutting speed around 20~30% from the above table or BL422 series.

[B304 series]

WORKPIECE	CARBON STEELS · ALLOY STEELS · TOOLS STEELS		ALLOY STEELS · TOOLS STEELS	
HARDNESS	~ HB225		HB225~325	
DIAMETER(mm)	RPM	FEED	RPM	FEED
R0.5	39,750	718.25	34,875	6,275
R1	39,750	2,387.5	34,875	2,087.5
R2	19,875	2,387.5	17,375	2,087.5
R3	13,250	2,387.5	11,600	2,087.5
R4	9,950	2,387.5	8,700	2,087.5
R5	7,962.5	2,225	6,962.5	1,950
R6	6,637.5	1,987.5	5,800	1,737.5
R8	5,000	1,625	4,375	1,312.5
R10	4,000	1,250	3,500	1050
R12.5	3,000	1,000	2,625	812.5

RPM = rev. / min.
FEED = mm / min.



R	ap	ae
$R \leq 1,0$	0,05 x up to R	0,2 x up to R
$1,0 < R$	0,1 x up to R	0,2 x up to R