

[E302, E322 series]

	Side Cutting				Slotting			
	DepthofCut : 1.5D		WIDTH : 0.1D		DepthofCut : 0.5D		WIDTH : 1D	
	CARBON STEELS · ALLOY STEELS · TOOLS STEELS		ALLOY STEELS · TOOLS STEELS		CARBON STEELS · ALLOY STEELS · TOOLS STEELS		ALLOY STEELS · TOOLS STEELS	
HARDNESS	~ HB225		HB225~325		~ HB225		HB225~325	
DIAMETER(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1	5,300	60	4,300	50	4,300	40	3,500	20
2	4,500	80	3,800	60	3,800	50	3,100	30
3	3,700	80	3,200	60	3,200	50	2,650	30
4	2,750	110	2,400	60	2,400	50	2,000	30
6	1,850	110	1,600	60	1,600	50	1,320	30
8	1,400	110	1,200	90	1,200	60	1,000	40
10	1,100	110	950	90	950	60	800	40
12	930	110	800	90	800	60	660	40
16	700	110	600	90	600	60	500	40
20	560	110	480	90	480	60	400	40
25	450	110	380	90	380	60	320	40

※ Please reduce cutting speed around 20~30% from the above table or E322 series.

[E304, E324 series]

	Side Cutting				Slotting			
	DepthofCut : 1.5D		WIDTH : 0.1D		DepthofCut : 0.5D		WIDTH : 1D	
	CARBON STEELS · ALLOY STEELS · TOOLS STEELS		ALLOY STEELS · TOOLS STEELS		CARBON STEELS · ALLOY STEELS · TOOLS STEELS		ALLOY STEELS · TOOLS STEELS	
HARDNESS	~ HB225		HB225~325		~ HB225		HB225~325	
DIAMETER(mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1	6,630	90	5,380	75	5,380	60	4,380	30
2	5,630	120	4,750	90	4,750	75	3,880	45
3	4,630	120	4,000	90	4,000	75	3,310	45
4	3,440	165	3,000	90	3,000	75	2,500	45
6	2,310	165	2,000	90	2,000	75	1,650	45
8	1,750	165	1,500	135	1,500	90	1,250	60
10	1,380	165	1,190	135	1,190	90	1,000	60
12	1,160	165	1,000	135	1,000	90	830	60
16	880	165	750	135	750	90	630	60
20	700	165	600	135	600	90	500	60
25	560	165	480	135	480	90	400	60

※ Please reduce cutting speed around 20~30% from the above table or E324 series.