

■ DA412 series ▶ High Speed Cutting

MATERIAL	HARDENED STEELS		HARDENED STEELS		HARDENED STEELS	
	HRc45 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc65	
STRENGTH	1500 ~ 1750N/mm ²		1750 ~ 2000N/mm ²		2000 ~ 2080N/mm ²	
DIAMETER(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/16 X 1/8	12700	68,90	12300	65,70	11800	39,90
R3/32 X 3/16	9400	65,00	9050	61,80	8600	29,50
R1/8 X 1/4	8600	68,90	8250	65,70	7850	27,60
R5/32 X 5/16	7000	61,00	6700	57,50	6350	25,60
R3/16 X 3/8	6050	57,10	5800	53,50	5450	24,40
R1/4 X 1/2	5450	55,90	5200	52,40	4900	24,00
R5/16 X 5/8	4350	48,40	4150	44,50	3900	10,40
R3/8 X 3/4	3500	39,40	3300	35,40	3150	8,70
R1/2 X 1	2800	39,40	2640	35,40	2520	8,70

RPM:rev./min.
FEED:inch./min.

Ae: D1/8=.006
D3/16-D5/16=.010
D3/8-D1=.012
Ap: 0.05 X D

■ DA512, DA302 series ▶ High Speed Cutting

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS - CAST IRON		HARDENED STEELS	
	~ HRc45		HRc45 ~ HRc65	
STRENGTH	~ 1500N/mm ²		1500N/mm ²	
DIAMETER(inch)	RPM	FEED	RPM	FEED
R1/64 X 1/32	25000	25,60	25000	15,70
R1/32 X 1/16	23000	27,50	23000	16,90
R3/64 X 3/32	21000	34,60	19000	19,30
R1/16 X 1/8	21000	39,40	17000	20,50
R3/32 X 3/16	21000	70,90	12000	23,60
R1/8 X 1/4	21000	90,90	10500	24,80
R5/32 X 5/16	15760	111,80	7880	29,10
R3/16 X 3/8	13660	120,00	6300	33,00
R1/4 X 1/2	10500	103,50	5260	33,00
R5/16 X 5/8	8200	103,50	3780	28,00
R3/8 X 3/4	6300	99,00	2940	20,80

RPM:rev./min.
FEED:inch./min.

Ae: D1/32-D1/4=.008 inch
D5/16-D3/4=.012 inch
Ap: 0.05 X D

■ DA512, DA302 series ▶ General Speed Cutting

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS - CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		HARDENED STEELS	
	~ HRc30		HRc30 ~ HRc40		HRc45 ~ HRc65	
STRENGTH	~ 1000N/mm ²		1000 ~ 1250N/mm ²		1500N/mm ²	
DIAMETER(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/64 X 1/32	15760	9,80	12720	7,80	5800	3,80
R1/32 X 1/16	15760	13,80	12140	1,60	5320	4,70
R3/64 X 3/32	14400	29,50	10700	19,30	4680	5,90
R1/16 X 1/8	13100	26,70	10000	18,10	4520	5,90
R3/32 X 3/16	9140	32,30	7300	22,80	3680	7,10
R1/8 X 1/4	7780	33,00	6300	24,80	3160	7,50
R5/32 X 5/16	5260	37,50	4420	26,00	2100	7,50
R3/16 X 3/8	4620	40,10	3780	28,00	1780	7,50
R1/4 X 1/2	3780	35,40	2940	26,00	1360	7,50
R5/16 X 5/8	2740	36,20	2320	26,00	1160	7,50
R3/8 X 3/4	2100	33,00	1900	25,00	840	7,50

RPM:rev./min.
FEED:inch./min.

Ae: D1/32-D1/4=.008inch
D5/16-D3/4=.012inch
Ap: 0.2 X D

Ae: D1/32-D1/4=.008inch
D5/16-D3/4=.012inch
Ap: 0.1 X D

■ DA514 series ▶ General Speed Cutting

MATERIAL	CARBON STEELS ALLOY STEELS - CAST IRON		ALLOY STEELS TOOL STEELS		HARDENED STEELS	
	~ HRc30		HRc30 ~ HRc40		HRc55 ~ HRc65	
STRENGTH	~ 1000N/mm ²		1000 ~ 1250N/mm ²		~ 1500N/mm ²	
DIAMETER(inch)	RPM	FEED	RPM	FEED	RPM	FEED
R1/16 X 1/8	13100	40,10	10000	27,00	4520	8,85
R3/32 X 3/16	9140	48,50	7300	34,00	3680	10,50
R1/8 X 1/4	7780	49,50	6300	37,00	3160	11,25
R5/32 X 5/16	5260	56,00	4420	39,00	2100	11,25
R3/16 X 3/8	4620	60,00	3780	42,00	1780	11,25
R1/4 X 1/2	3780	53,00	2940	39,00	1360	11,25
R5/16 X 5/8	2740	54,50	2320	38,50	1160	11,25

RPM:rev./min.
FEED:inch./min.

Ae: D1/8-D1/4=.008 inch
D5/16-D5/8=.012 inch
Ap: 0.02 X D

Ae: D1/8-D1/4=.008 inch
D5/16-D5/8=.012 inch
Ap: 0.1 X D