RECOMMENDED CUTTING CONDITIONS

Work material		Carbon steel, Cast iron, Alloy steel, Pre-hardened steel Cf53, GG25		
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
1	**4**	40000	3000	0.04
	8	36000	2400	0.03
	12	20000	1000	0.02
	16	10000	500	0.005
1.2	**6**	40000	3000	0.05
	10	36000	2400	0.04
	12	20000	1200	0.03
	16	12000	600	0.01
1.5	**6**	40000	3200	0.06
	12	32000	2400	0.05
	16	16000	1100	0.03
	20	10000	600	0.01
1.8	**6**	40000	3600	0.08
	12	32000	2800	0.06
	20	12000	1000	0.02
	25	7000	600	0.01
2	**6**	40000	4000	0.1
	12	32000	3200	0.07
	16	24000	2400	0.05
	20	12000	1200	0.03
	30	5000	500	0.01
2.5	**8**	32000	4000	0.2
	25	9000	1100	0.04
	50	2500	300	0.005
3	**8**	25000	3600	0.4
	16	18000	2500	0.2
	25	12000	1700	0.1
	30	7000	800	0.05

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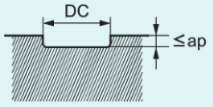
Dia. **DC** (mm)	Neck length **LU** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Depth of cut ap (mm)
3.5	**15**	20000	3000	0.6
	25	11000	1600	0.15
	35	5500	800	0.06
4	**12**	18000	3000	1
	20	12000	2000	0.5
	30	8000	1300	0.2
	40	4200	700	0.08
	50	2400	400	0.03
5	**16**	14000	2700	1
	25	9500	1800	0.5
	35	6400	1200	0.2
	50	3200	600	0.05
6	**20**	11000	2200	1.2
	30	8000	1600	0.6
	40	5400	1100	0.25
	50	3200	640	0.15
8	**30**	8000	1600	1.6
	50	4000	800	0.5
	70	2000	400	0.2
10	**40**	6400	1300	2
	60	3200	640	0.6
	80	1600	320	0.3
Depth of cut				

DC:Dia.
ap:Depth of Cut in the Axial Direction

1) If the depth of cut is shallow, the revolution and feed rate can be increased.
2) Cutting conditions may be considerably different due to the overhang (milling depth), depth of cut, and machine tool. Please see the above table as a standard.