

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Mode	l/d ≤ 3			l/d = 3-4		
			Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P Carbon Steel, Alloy Steel	180-350HB	Medium Cutting	110 (80-140)	0.25 (0.1-0.4)	-5.0	110 (80-140)	0.2 (0.1-0.3)	-4.0
M Stainless Steel	≤200HB	Medium Cutting	80 (60-100)	0.2 (0.1-0.3)	-4.0	70 (50-100)	0.15 (0.1-0.25)	-3.0
K Cast Iron	Tensile Strength ≤350MPa	Medium Cutting	80 (60-100)	0.25 (0.1-0.4)	-5.0	80 (60-100)	0.2 (0.1-0.3)	-4.0