

RECOMMENDED CUTTING CONDITIONS

Steel Shank			l/d ≤ 3			l/d = 3–4 (Shank Diameter ≥ 25mm)			
Carbide Shank			l/d ≤ 5			l/d = 6–7			
Work Material	Hardness	Cutting Mode	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	Light Cutting	130 (90–160)	0.1 (0.05–0.15)	0.2	120 (80–150)	0.1 (0.05–0.15)	0.2
			Medium Cutting	90 (60–120)	0.25 (0.15–0.35)	–3.0	80 (50–110)	0.15 (0.1–0.2)	–1.5
M	Stainless Steel	≤200HB	Light Cutting	140 (100–180)	0.1 (0.05–0.15)	0.2	140 (100–180)	0.1 (0.05–0.15)	0.2
			Medium Cutting	70 (50–90)	0.2 (0.15–0.25)	–2.0	60 (40–80)	0.15 (0.1–0.2)	–1.0
N	Aluminium Alloy	—	Light Cutting	300 (200–400)	0.1 (0.05–0.15)	0.2	300 (200–400)	0.1 (0.05–0.15)	0.2
			Medium Cutting	200 (150–250)	0.1 (0.05–0.15)	–2.0	200 (150–250)	0.1 (0.05–0.15)	–1.5