

RECOMMENDED CUTTING CONDITIONS

| Work Material | Hardness | Cutting Mode | l/d ≤ 3 | | | l/d = 3—4 (Shank Diameter ≥ 25mm) | | |
|-----------------------------------|-----------|----------------|-----------------------|------------------|-------------------|-----------------------------------|-----------------|-------------------|
| | | | 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 |