

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/tooth)	
				Chamfer Milling	Face Milling
P Carbon Steel Alloy Steel	180–280HB	UTi20T	180 (130–220)	0.4	0.15
		UP20M	180 (130–220)	0.4	0.2
		NX4545	180 (130–220)	0.4	0.2
	280–350HB	UTi20T	100 (70–120)	0.3	0.15
K Cast Iron	Tensile Strength ≤450MPa	UTi20T	140 (100–170)	0.5	0.25
		HTi10	140 (100–170)	0.5	0.25

● Revolution (min⁻¹)=(1000×Cutting Speed)÷(3.14×φD1)

● Table Feed (mm/min)=Feed per Tooth×Number of Teeth×Cutter Revolution