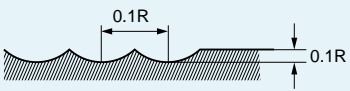


RECOMMENDED CUTTING CONDITIONS

	Finishing		Roughing	
Work material	Aluminium alloy		Aluminium alloy	
R (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
R 1	20000	2000	20000	1600
R 2	20000	4000	20000	2800
R 3	20000	6000	20000	3200
R 4	20000	7000	17000	4000
R 5	20000	8000	15000	3600
R 6	15000	7500	12000	3600
R 8	12000	7200	10000	3600
R 10	10000	7000	8000	3200
Depth of cut	 <p style="text-align: right;">R:Radius</p>			

* When sinking, reduce the feed rate by 50%.