RECOMMENDED CUTTING CONDITIONS

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Work material		Copper, Copper alloys			
Dia. (mm)	Corner radius (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut	
				ap (mm)	ae (mm)
6	R0.2, R0.3, R0.5	10000	1400	6	0.6
	R1	10000	1700	6	0.6
8	R0.3, R0.5	8000	1000	8	0.8
	R1	8000	1200	8	0.8
10	R0.3, R0.5	6400	900	10	1.0
	R1	6400	1100	10	1.0
12	R0.3, R0.5	5400	800	12	1.0
	R1	5400	1000	12	1.0
Depth of cut		≤ae → → → ≤ap			

1) If the depth of cut is shallow, the revolution and feed rate can be increased.

2) Water-soluble cutting fluid is recommended.3) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.