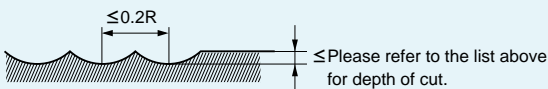


RECOMMENDED CUTTING CONDITIONS

| Work material | | Copper, Copper alloys | | |
|---------------|------------------|---------------------------------|--------------------|-------------------|
| R (mm) | Neck length (mm) | Revolution (min ⁻¹) | Feed rate (mm/min) | Depth of cut (mm) |
| RO.1 | 0.5 | 40000 | 800 | 0.003 |
| | 1.0 | 40000 | 600 | 0.002 |
| | 1.5 | 40000 | 400 | 0.001 |
| RO.15 | 1 | 40000 | 1200 | 0.007 |
| | 2 | 40000 | 800 | 0.003 |
| RO.2 | 1 | 40000 | 2000 | 0.015 |
| | 2 | 40000 | 1300 | 0.01 |
| | 3 | 40000 | 800 | 0.005 |
| RO.25 | 2 | 40000 | 2000 | 0.02 |
| | 4 | 40000 | 1200 | 0.01 |
| | 6 | 36000 | 600 | 0.006 |
| | 10 | 26000 | 200 | 0.002 |
| RO.3 | 2 | 40000 | 3200 | 0.03 |
| | 6 | 40000 | 1200 | 0.008 |
| | 10 | 30000 | 500 | 0.003 |
| RO.4 | 4 | 40000 | 4000 | 0.02 |
| | 6 | 40000 | 2500 | 0.02 |
| | 10 | 30000 | 700 | 0.008 |
| RO.5 | 4 | 40000 | 6400 | 0.05 |
| | 6 | 40000 | 4800 | 0.03 |
| | 8 | 40000 | 3000 | 0.02 |
| | 10 | 33000 | 2000 | 0.01 |
| | 16 | 18000 | 500 | 0.008 |
| | 20 | 13000 | 250 | 0.005 |

| Work material | | Copper, Copper alloys | | |
|---------------|------------------|---------------------------------|--------------------|-------------------|
| R (mm) | Neck length (mm) | Revolution (min ⁻¹) | Feed rate (mm/min) | Depth of cut (mm) |
| RO.75 | 8 | 40000 | 8000 | 0.07 |
| | 12 | 35000 | 4500 | 0.04 |
| | 16 | 20000 | 2000 | 0.03 |
| | 20 | 12000 | 900 | 0.02 |
| R1 | 8 | 40000 | 9600 | 0.10 |
| | 10 | 40000 | 6400 | 0.08 |
| | 12 | 40000 | 6000 | 0.08 |
| | 16 | 30000 | 3000 | 0.05 |
| | 20 | 20000 | 2000 | 0.04 |
| R1.5 | 30 | 10000 | 800 | 0.02 |
| | 16 | 40000 | 12000 | 0.10 |
| | 25 | 25000 | 6000 | 0.08 |
| R2 | 35 | 6000 | 700 | 0.06 |
| | 16 | 32000 | 11000 | 0.15 |
| R2.5 | 20 | 32000 | 9000 | 0.15 |
| | 30 | 20000 | 4500 | 0.10 |
| | 40 | 15000 | 3000 | 0.08 |
| | 50 | 8000 | 1000 | 0.05 |
| R3 | 20 | 25000 | 9500 | 0.20 |
| | 30 | 20000 | 3300 | 0.15 |
| R3 | 30 | 21000 | 8400 | 0.20 |
| | 50 | 20000 | 3000 | 0.15 |

| | |
|--------------|---|
| Depth of cut |  <p style="text-align: right;">R:Radius</p> |
|--------------|---|

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) Water-soluble cutting fluid is recommended.
- 3) Cutting conditions may be considerably different due to the overhang (milling depth), depth of cut, and machine tool. Please see the above table as a standard.