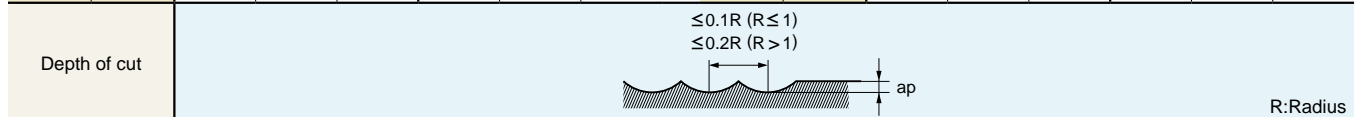


RECOMMENDED CUTTING CONDITIONS

Work material		Carbon steel, Cast iron, Alloy steel, Pre-hardened steel			Hardened steel (45–55HRC)		
		Cf53, GG25			X40CrMoV51		
R (mm)	Neck length (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ap (mm)
R 0.1	0.5	50000	400	0.003	50000	320	0.003
	1	50000	400	0.002	50000	320	0.002
	1.5	40000	300	0.001	40000	240	0.001
	2	40000	200	0.001	40000	160	0.001
	2.5	40000	100	0.001	40000	80	0.001
3	30000	50	0.001	30000	40	0.001	
R 0.15	1	50000	600	0.007	50000	480	0.007
	1.5	50000	600	0.005	50000	480	0.005
	2	50000	600	0.003	50000	480	0.003
	2.5	40000	400	0.003	40000	320	0.003
	3	40000	300	0.002	40000	240	0.002
4	30000	200	0.002	30000	160	0.002	
R 0.2	1	50000	1800	0.015	50000	1400	0.015
	2	50000	1300	0.01	50000	1000	0.01
	3	50000	900	0.005	50000	700	0.005
	4	40000	600	0.004	40000	480	0.004
	5	40000	400	0.003	40000	320	0.003
6	30000	200	0.002	30000	160	0.002	
R 0.25	2	50000	2500	0.02	50000	2000	0.02
	3	50000	1500	0.015	50000	1200	0.015
	4	45000	1200	0.01	45000	950	0.01
	5	45000	900	0.007	45000	700	0.007
	6	36000	600	0.006	36000	480	0.006
	7	32000	400	0.005	32000	320	0.005
	8	32000	300	0.003	32000	240	0.003
10	26000	200	0.002	26000	160	0.002	
R 0.3	2	50000	3500	0.03	50000	2800	0.03
	3	50000	3500	0.03	50000	2800	0.03
	4	44000	2500	0.02	44000	2000	0.02
	5	37000	1200	0.01	37000	950	0.01
	6	37000	1000	0.008	37000	800	0.008
	7	35000	750	0.008	35000	600	0.008
	8	35000	600	0.006	35000	480	0.006
	9	30000	500	0.004	30000	400	0.004
	10	30000	500	0.003	30000	400	0.003
	11	22000	300	0.002	22000	240	0.002
	12	22000	200	0.002	22000	160	0.002
R 0.4	2	50000	4400	0.04	50000	3500	0.04
	3	50000	4000	0.04	50000	3200	0.04
	4	50000	4000	0.02	50000	3200	0.02
	5	35000	2400	0.02	35000	1900	0.02
	6	35000	2400	0.02	35000	1900	0.02
	7	30000	1500	0.015	30000	1200	0.015
	8	30000	1500	0.01	30000	1200	0.01
	10	30000	700	0.008	30000	560	0.008
12	22000	500	0.006	22000	400	0.006	
R 0.5	3	40000	4000	0.05	40000	3200	0.05
	4	40000	4000	0.05	40000	3200	0.05
	6	35000	3000	0.03	35000	2400	0.03
	8	30000	2000	0.02	30000	1600	0.02

Work material		Carbon steel, Cast iron, Alloy steel, Pre-hardened steel			Hardened steel (45–55HRC)		
		Cf53, GG25			X40CrMoV51		
R (mm)	Neck length (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ap (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ap (mm)
R 0.5	10	20000	1000	0.01	20000	800	0.01
	12	20000	1000	0.01	20000	800	0.01
	14	18000	600	0.008	18000	480	0.008
	16	18000	500	0.008	18000	400	0.008
	18	13000	300	0.005	13000	240	0.005
	20	13000	250	0.005	13000	200	0.005
R 0.6	3.6	40000	4400	0.06	40000	3500	0.06
	6	40000	4400	0.04	40000	3500	0.04
	8	40000	4000	0.04	40000	3200	0.04
	10	27000	1900	0.02	27000	1500	0.02
	12	16000	1400	0.02	16000	1100	0.02
	18	15000	700	0.008	15000	560	0.008
24	11000	300	0.006	11000	240	0.006	
R 0.75	6	40000	6000	0.07	36000	4300	0.07
	8	40000	6000	0.07	36000	4300	0.07
	10	40000	5000	0.06	36000	3600	0.06
	12	32000	3400	0.04	29000	2400	0.04
	16	15000	1400	0.03	15000	1100	0.03
20	12000	900	0.02	12000	720	0.02	
30	9000	400	0.01	9000	320	0.01	
R 1	4	40000	8000	0.1	32000	5000	0.1
	6	40000	8000	0.1	32000	5000	0.1
	8	40000	6000	0.1	32000	3800	0.1
	10	40000	5000	0.08	32000	3200	0.08
	12	40000	5000	0.08	32000	3200	0.08
	16	32000	3500	0.05	26000	2200	0.05
	20	10000	1000	0.04	10000	800	0.04
	25	10000	1000	0.04	10000	800	0.04
	30	10000	800	0.02	10000	640	0.02
35	10000	600	0.02	10000	480	0.02	
R 1.5	8	32000	7000	0.15	26000	4500	0.15
	10	32000	7000	0.15	26000	4500	0.15
	16	32000	5000	0.1	26000	3200	0.1
	20	27000	3800	0.1	22000	2400	0.1
	25	21000	2700	0.08	17000	1700	0.08
	30	6000	700	0.08	6000	560	0.08
	35	6000	700	0.06	6000	560	0.06
	40	6000	600	0.04	6000	480	0.04
R 2	10	24000	6000	0.2	19000	3800	0.2
	20	24000	3800	0.15	19000	2400	0.15
	30	20000	3000	0.1	16000	1900	0.1
	40	12000	1700	0.1	12000	1400	0.1
	50	8000	1000	0.05	8000	800	0.05
R 2.5	20	22000	6000	0.2	18000	3800	0.2
	25	22000	4400	0.2	18000	2800	0.2
	30	22000	3800	0.15	18000	2400	0.15
	35	22000	3600	0.1	18000	2300	0.1
R 3	30	20000	6000	0.2	16000	3800	0.2
	50	20000	3000	0.15	16000	1900	0.15



- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) 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.