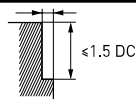


VFRSDRB

RECOMMENDED CUTTING CONDITIONS

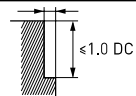
Material	DC	n	f	ap
H Hardened steel (45 – 55 HRC)	3	32000	3800	0.2
	4	24000	4400	0.2
	6	16000	5800	0.3
	8	12000	5800	0.4
	10	9600	5800	0.5
	12	8000	4800	0.6

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Material	DC	n	f	ap
H Hardened steel (55 – 62 HRC)	3	16000	1900	0.1
	4	12000	2200	0.1
	6	8000	2900	0.2
	8	6000	2900	0.2
	10	4800	2900	0.3
	12	4000	2400	0.3
H Hardened steel (62 – 70 HRC)	3	11000	1200	0.05
	4	8000	1300	0.05
	6	5300	1800	0.10
	8	4000	1800	0.10
	10	3200	1800	0.20
	12	2700	1500	0.20

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1. If the depth of cut is shallow, the revolution and feed rate can be increased.
2. If the machine or workpiece material is not rigid, vibration or abnormal noises may occur.
In this case, please adjust the spindle speed, feed rate and depth of cut according to the table above.