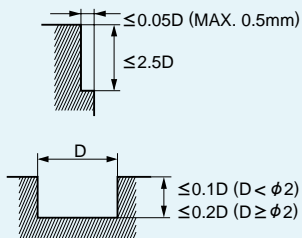
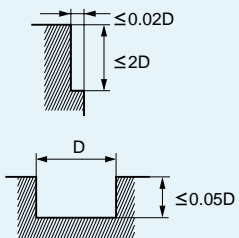


RECOMMENDED CUTTING CONDITIONS

Work material	Carbon steel, Cast iron, Alloy steel (-30HRC)		Alloy steel, Tool steel, Pre-hardened steel		Austenitic stainless steel, Titanium alloy		Hardened steel (45-55HRC)	
	Cf53, GG25		X40CrMoV51		X5CrNi1810, X5CrNiMo17122, Ti6Al4V		X40CrMoV51	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
1	11100	85	9500	65	8000	50	6400	35
1.5	7400	85	6400	90	5300	50	4200	35
2	5600	85	4800	90	4000	50	3200	35
2.5	4500	85	3800	90	3200	55	2500	35
3	3700	90	3400	90	2600	60	2100	35
4	3000	110	2700	90	2100	70	1700	50
5	2600	140	2300	110	1800	85	1500	55
6	2300	170	2000	140	1500	110	1300	70
8	1700	180	1500	140	1200	110	1000	70
10	1400	180	1300	140	950	110	800	70
12	1200	170	1100	140	800	110	670	70
Depth of cut								

- 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
- 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 3) When drilling, please set the feed rate at 1/3 or below the values above.
- 4) 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.