

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)	
	AISI 1050, AISI No 35 B, AISI P20		AISI H13, AISI W1-10, AISI P21		AISI 304, AISI 306, Ti-6Al-4V		AISI H13	
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)
3	10000	600	7000	400	6000	300	5000	120
4	7500	600	5200	400	4500	300	4000	120
5	6000	600	4200	400	3600	300	3200	120
6	5000	600	3500	400	3000	300	2700	120
7	4500	560	3000	360	2700	280	2300	110
8	4000	520	2800	350	2400	260	2000	110
10	3200	450	2200	300	1900	230	1600	100
12	2700	410	1900	270	1600	210	1300	100

Depth of cut	Carbon steel, Cast iron, Alloy steel (-30HRC)		Alloy steel, Tool steel, Pre-hardened steel		Austenitic stainless steel, Titanium alloy		Hardened steel (45-55HRC)	

D: Dia.

- 1) When cutting austenitic stainless steels, the use of water-soluble cutting fluid is effective.
- 2) If the depth of cut is shall, 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.