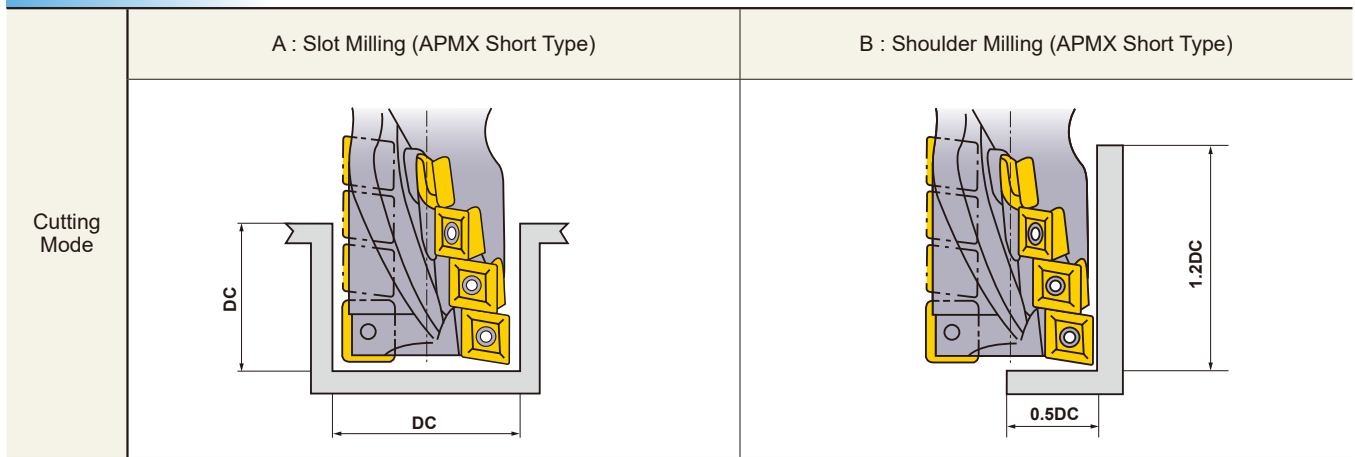


RECOMMENDED CUTTING CONDITIONS



Work Material	Hardness	Grade	Cutting Mode	Cutting Speed (m/min)	Table Feed (mm/min)			
					φ25	φ32	φ40	φ50
P Mild Steel	≤180HB	F7030	A	200 (160–240)	120 (100–140)	120 (100–140)	120 (100–140)	120 (100–140)
		F7030	B	200 (160–240)	200 (180–220)	200 (180–220)	230 (200–250)	230 (200–250)
Carbon Steel Alloy Steel	180–280HB	F7030	A	160 (130–180)	120 (100–140)	120 (100–140)	140 (120–150)	140 (120–150)
		F7030	B	160 (130–180)	150 (120–180)	150 (120–180)	180 (150–200)	180 (150–200)
	280–350HB	F7030	A	160 (130–180)	100 (80–120)	100 (80–120)	130 (100–150)	130 (100–150)
		F7030	B	160 (130–180)	120 (100–140)	120 (100–140)	150 (120–180)	150 (120–180)
M Stainless Steel	≤200HB	F7030	A	80 (60–100)	70 (50–90)	70 (50–90)	70 (50–90)	70 (50–90)
		F7030	B	130 (100–160)	100 (80–120)	100 (80–120)	120 (100–140)	120 (100–140)
K Cast Iron	Tensile Strength ≤450MPa	UT120T	A	120 (100–140)	200 (180–220)	200 (180–220)	230 (200–250)	230 (200–250)
		UT120T	B	120 (100–140)	230 (200–250)	230 (200–250)	260 (240–280)	260 (240–280)

● Revolution (min⁻¹)=(1000 x Cutting Speed)÷(3.14 x DC)

● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution