

## RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Mode	l/d ≤ 3			3 < l/d ≤ 4		
			Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (inch)	Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (inch)
<b>P</b> Carbon Steel, Alloy Steel	180—280HB	Medium Cutting	360 (260—460)	.010 (.004—.016)	—.197	360 (260—460)	.008 (.004—.012)	—.157
<b>M</b> Stainless Steel	≤200HB	Medium Cutting	260 (195—330)	.008 (.004—.012)	—.157	230 (165—330)	.006 (.004—.015)	—.118
<b>K</b> Cast Iron	Tensile Strength ≤350MPa	Medium Cutting	260 (195—330)	.010 (.004—.016)	—.197	260 (195—330)	.008 (.004—.012)	—.157