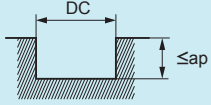


## RECOMMENDED CUTTING CONDITIONS

Work material		Carbon steel, Cast iron, Alloy steel, Pre-hardened steel		
		AISI 1050, AISI No 35 B, AISI P20, AISI P21 etc.		
DC (inch)	Neck length (inch)	Revolution (min <sup>-1</sup> )	Table feed (IPM)	Depth of cut <sub>ap</sub> (inch)
<b>.0625</b>	<b>.3750</b>	40000	121.0	.0028
	<b>.5000</b>	30000	68.0	.0016
	<b>.7500</b>	10000	14.2	.0008
<b>.0938</b>	<b>.5625</b>	33000	109.1	.003
	<b>.7500</b>	20000	56.6	.002
	<b>1.1250</b>	10000	18.8	.001
<b>.1250</b>	<b>.7500</b>	25000	96.5	.004
<b>.1875</b>	<b>1.1250</b>	17000	72.2	.006
<b>.2500</b>	<b>1.5000</b>	13000	73.7	.008
Depth of cut				

- 1) If the depth of cut is smaller than this table, feed rate can be increased.
- 2) Cutting conditions may differ considerably due to the overhang, depth of cut, and machine tool conditions.  
Please use the above table as a start reference point.