

RECOMMENDED CUTTING CONDITIONS

DC (mm)	Cutting Speed (m/min)	Main spindle speed (min ⁻¹)	Feed per Tooth (mm/tooth)	Table Feed		Depth of Cut ap (mm)	Width of Cut ae (mm)	Cutting Speed (m/min)	Main spindle speed (min ⁻¹)	Feed per Tooth (mm/tooth)	Table Feed		Depth of Cut ap (mm)	Width of Cut ae (mm)
				(mm/min)	(IPM)						(mm/min)	(IPM)		
3	150	16000	0.15	9600	378	0.12	1.5	135	14000	0.15	8400	330	0.12	1.5
4	150	12000	0.20	9600	378	0.16	2.0	135	11000	0.20	8800	346	0.16	2.0
6	150	8000	0.35	11000	433	0.24	3.0	135	7200	0.35	10000	394	0.24	3.0
8	150	6000	0.35	13000	512	0.32	4.8	135	5400	0.35	11000	433	0.32	4.8
10	150	4800	0.40	12000	472	0.40	6.0	135	4300	0.40	10000	393	0.40	6.0
12	150	4000	0.45	11000	433	0.48	7.2	135	3600	0.45	9700	382	0.48	7.2

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				(mm/min)	(IPM)						(mm/min)	(IPM)		
3	120	13000	0.15	7800	308	0.12	1.5	80	8500	0.10	3400	134	0.12	1.5
4	120	9500	0.21	8000	315	0.16	2.0	80	6400	0.15	3800	150	0.16	2.0
6	120	6400	0.35	9000	354	0.24	3.0	80	4200	0.30	5000	197	0.24	3.0
8	120	4800	0.35	10000	394	0.32	4.8	80	3200	0.30	5800	228	0.32	4.8
10	120	3800	0.40	9100	358	0.40	6.0	80	2500	0.35	5300	209	0.40	6.0
12	120	3200	0.45	8600	339	0.48	7.2	80	2100	0.40	5000	197	0.48	7.2

1) When ramping process set the feedrate at 50%. A ramping angle of 1° is recommended.

2) Use at a revolution of 70% and feedrate of 50% when the tool overhang exceeds 5D.