

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)	
					Chamfer Milling	Face Milling
P	Carbon Steel Alloy Steel	180–280HB	UTi20T	80 (60–100)	0.4	0.15
			UP20M	130 (100–160)	0.4	0.2
			NX4545	130 (100–160)	0.4	0.2
		280–350HB	UTi20T	80 (60–100)	0.3	0.15
K	Cast Iron	Tensile Strength ≤450MPa	UTi20T	100 (85–120)	0.5	0.25
			HTi10	100 (85–120)	0.5	0.25

● 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