

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel	180–280HB	UTi20T	130 (100–160)	0.15 (0.1–0.2)
	Alloy Steel	280–350HB	UTi20T	80 (60–100)	0.1 (0.05–0.15)
K	Cast Iron	Tensile Strength ≤450MPa	UTi20T	100 (80–120)	0.15 (0.1–0.2)

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

CAUTION FOR USE

- When T slot machining steel, the workpiece must be pre-machined as shown in the drawing, so as to ensure smooth chip evacuation.
- Slots to be machined must be free from chips for smooth machining.

