

RECOMMENDED CUTTING CONDITIONS

Workpiece Material		Hardness	Cutting Mode	l/d≤3		
				Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180—350HB	Medium Cutting	110 (80—140)	0.25 (0.1—0.4)	—5.0
M	Stainless Steel	≤200HB	Medium Cutting	80 (60—100)	0.2 (0.1—0.3)	—4.0
K	Gray Cast Iron	Tensile Strength ≤350MPa	Medium Cutting	80 (60—100)	0.25 (0.1—0.4)	—5.0