

RECOMMENDED CUTTING CONDITIONS

| Steel Shank | | | l/d ≤ 3 | | | l/d = 3–4 (Shank Diameter ≥ 25mm) | | | |
|--------------------|-----------------------------|--------------|-----------------------|---------------|-------------------|-----------------------------------|---------------|-------------------|------|
| Carbide Shank | | | l/d ≤ 5 | | | l/d = 6–7 | | | |
| Workpiece Material | Hardness | Cutting Mode | Cutting Speed (m/min) | Feed (mm/rev) | Depth of Cut (mm) | Cutting Speed (m/min) | Feed (mm/rev) | Depth of Cut (mm) | |
| P | Carbon Steel Alloy Steel | 180–350HB | Light Cutting | 130 (90–160) | 0.1 (0.05–0.15) | 0.2 | 120 (80–150) | 0.1 (0.05–0.15) | 0.2 |
| | | | Medium Cutting | 90 (60–120) | 0.25 (0.15–0.35) | –3.0 | 80 (50–110) | 0.15 (0.1–0.2) | –1.5 |
| M | Stainless Steel | ≤200HB | Light Cutting | 140 (100–180) | 0.1 (0.05–0.15) | 0.2 | 140 (100–180) | 0.1 (0.05–0.15) | 0.2 |
| | | | Medium Cutting | 70 (50–90) | 0.2 (0.15–0.25) | –2.0 | 60 (40–80) | 0.15 (0.1–0.2) | –1.0 |
| N | Aluminium Alloy | – | Light Cutting | 300 (200–400) | 0.1 (0.05–0.15) | 0.2 | 300 (200–400) | 0.1 (0.05–0.15) | 0.2 |
| | | | Medium Cutting | 200 (150–250) | 0.1 (0.05–0.15) | –2.0 | 200 (150–250) | 0.1 (0.05–0.15) | –1.5 |