

RECOMMENDED CUTTING CONDITIONS

Workpiece Material	Hardness	Cutting Mode	$l/d \leq 3$		
			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
		Medium Cutting	90 (60–120)	0.25 (0.15–0.35)	–3.0
M Stainless Steel	≤ 200 HB	Light Cutting	140 (100–180)	0.1 (0.05–0.15)	0.2
		Medium Cutting	70 (50–90)	0.2 (0.15–0.25)	–2.0
N Aluminium Alloy	–	Light Cutting	300 (200–400)	0.1 (0.05–0.15)	0.2
		Medium Cutting	200 (150–250)	0.1 (0.05–0.15)	–2.0