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