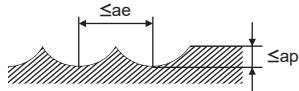


RECOMMENDED CUTTING CONDITIONS

(mm)

Workpiece Material	Nickel-Based Heat Resistant Super Alloy					
	Inconel718, Inconel713C, Waspaloy etc.					
R RE	$\alpha \leq 15^\circ$		$\alpha > 15^\circ$		Depth of cut ap	Depth of cut ae
	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)		
1.0	6300	380	6300	510	0.2	0.50
1.5	4200	340	4200	420	0.3	0.75
2.0	3100	320	3100	380	0.4	1.00
2.5	2500	250	2500	310	0.5	1.25
3.0	2100	210	2100	250	0.6	1.50
4.0	1500	160	1500	190	0.8	2.00
5.0	1200	150	1200	200	1.0	2.50
6.0	1000	150	1000	170	1.2	3.00
Depth of cut						

- Note 1) The use of water-soluble coolant is effective for heat resistant super alloys.
- Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
- Note 3) If the machine or workpiece material is not rigid, vibration or abnormal noises may occur. In this case, please adjust the spindle speed, feed rate, and depth of cut according to the table above.
- Note 4) α is the inclination angle of the machined surface.

