

RECOMMENDED CUTTING CONDITIONS

	Work Material	Cutting Speed (m/min)	Recommended Tool Overhang (mm)
P	Carbon Steel Alloy Steel	50 (30–80)	
M	Stainless Steel	50 (30–80)	
K	Cast Iron	50 (30–80)	
N	Non-Ferrous Metal	80 (50–100)	

(Note 1) Wet cutting is recommended.

(Note 2) Pay special attention to machining of small diameters at high revolutions as the feed rate cannot keep up with the speed.