

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Mode	l/d ≤ 3			3 < l/d ≤ 4		
			Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (inch)	Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (inch)
P Carbon Steel, Alloy Steel	180–280HB	Medium Cutting	260–460	.004–.016	–.20	260–460	.004–.012	–.16
M Stainless Steel	≤200HB	Medium Cutting	200–330	.008–.012	–.16	165–330	.004–.015	–.12
K Cast Iron	Tensile Strength ≤350MPa	Medium Cutting	200–330	.004–.016	–.20	200–330	.004–.012	–.16