

RECOMMENDED CUTTING CONDITIONS

Steel Shank			$l/d \leq 3$			$3 < l/d \leq 4$ (Shank Diameter ≥ 1.000 inch)			
Heavy Metal Shank			$l/d \leq 3$			$3 < l/d \leq 6$			
Carbide Shank			$l/d \leq 5$			$5 < l/d \leq 7$			
Work Material	Hardness	Cutting Mode	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	Light Cutting	295–525	.002–.006	.008	260–490	.002–.006	.008
			Medium Cutting	195–395	.006–.014	–.118	165–360	.004–.008	.059
M	Stainless Steel	≤ 200 HB	Light Cutting	330–590	.002–.006	.008	330–590	.002–.006	.008
			Medium Cutting	165–295	.006–.010	–.079	130–260	.004–.008	.039
N	Aluminum Alloy	–	Light Cutting	655–1310	.002–.006	.008	655–1310	.002–.006	.008
			Medium Cutting	490–820	.002–.006	–.079	490–820	.002–.006	.059