

RECOMMENDED CUTTING CONDITIONS

Work material		Hardened steel (45—55HRC) AISI H13 etc.		
RE (inch)	LU (inch)	Revolution (min ⁻¹)	Table feed (IPM)	Depth of cut _{ap} (inch)
.0078	.0938	40000	21.2	.0002
	.1290	30000	17.7	.0002
	.1875	20000	10.6	.0001
.0156	.1875	40000	70.8	.0008
	.2500	25000	44.3	.0008
	.3750	15000	26.6	.0004
.0313	.3750	40000	113.4	.0028
	.5000	30000	85.1	.0016
	.7500	10000	28.4	.0008
.0469	.5625	40000	141.8	.003
	.7500	20000	70.8	.002
	1.1250	10000	35.5	.001
.0625	.7500	30000	124.0	.004
.0938	1.1250	20000	106.3	.006
.1250	1.5000	15000	106.3	.008
Depth of cut	<p> $\leq 0.1RE$ ($RE \leq 3/64$) $\leq 0.2RE$ ($RE > 3/64$) </p>			

1) If the depth of cut is smaller than this table, feed rate can be increased.

2) Cutting conditions may differ considerably due to the overhang, depth of cut, and machine tool conditions. Please use the above table as a start reference point.