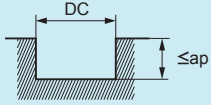


RECOMMENDED CUTTING CONDITIONS

Work material		Carbon steel, Cast iron, Alloy steel, Pre-hardened steel		
		AISI 1050, AISI No 35 B, AISI P20, AISI P21 etc.		
DC (inch)	LU (inch)	Revolution (min ⁻¹)	Table feed (IPM)	Depth of cut _{ap} (inch)
.0156	.0938	40000	17.0	.0002
	.1250	30000	10.6	.0002
	.1875	20000	5.6	.0001
.0313	.1875	40000	56.7	.0008
	.2500	25000	26.6	.0008
	.3750	15000	10.6	.0004
.0625	.3750	40000	90.7	.0028
	.5000	30000	51.0	.0016
	.7500	10000	10.6	.0008
.0938	.5625	33000	81.8	.003
	.7500	20000	42.5	.002
	1.1250	10000	14.1	.001
.1250	.7500	25000	72.4	.004
.1875	1.1250	17000	54.2	.006
.2500	1.5000	13000	55.3	.008
Depth of cut				

- 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.