

RECOMMENDED CUTTING CONDITIONS

DC (mm)	Revolution (min ⁻¹)	Table feed		Depth of cut a (mm)	Revolution (min ⁻¹)	Table feed		Depth of cut a (mm)
		(mm/min)	(IPM)			(mm/min)	(IPM)	
1	40000	3000	118.1	0.06	32000	2400	94.5	0.06
1.5	40000	4500	177.2	0.12	32000	3600	141.7	0.08
2	30000	4500	177.2	0.18	24000	3600	141.7	0.10
2.5	24000	3900	153.5	0.25	19000	3000	118.1	0.13
3	20000	3500	137.8	0.30	16000	2700	106.3	0.15
4	15000	3000	118.1	0.40	12000	2400	94.5	0.20
5	12000	2400	94.5	0.50	9000	1800	70.9	0.25
6	10000	2100	82.7	0.60	7000	1500	59.1	0.30
8	8000	1500	59.1	0.80	5600	1100	43.3	0.40
10	6400	1400	55.1	1.00	4500	950	37.4	0.50
12	5400	1200	47.2	1.00	3800	860	33.9	0.50
16	2400	550	21.7	≤3	1200	120	4.7	≤0.8
20	1900	480	18.9	≤4	1000	100	3.9	≤1

Depth of cut	
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- 1) If the depth of cut is smaller than this table, feed rate can be increased.
- 2) In case of slotting with over 3 mm endmill, please reduce revolution to 50–70% of above value, and reduce feed rate to 40–60% of above value.
- 3) If the rigidity of the machine or the workpiece installation is very low, or chattering is generated, please reduce the revolution and the feed rate proportionately.