

RECOMMENDED CUTTING CONDITIONS

Work Material	CB Type				CR Type		
	Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (inch)	Overhang (l/d)	Cutting Speed (SFM)	Feed (IPR)	
						03RS/04RS	05RS
P General Steel	130–395	.0004–.002	.004–.012	3–5	130–395	.0004–.001	.0004–.002
M Stainless Steel	130–395	.0004–.002	.004–.012	3–5	130–395	.0004–.001	.0004–.002
K Cast Iron	130–395	.0004–.002	.004–.012	3–5	130–395	.0004–.002	.0004–.002
N Non Ferrous Materials	260–525	.0004–.003	.004–.020	3–5	260–525	.0004–.002	.0004–.003

(Note) Recommend wet machining.