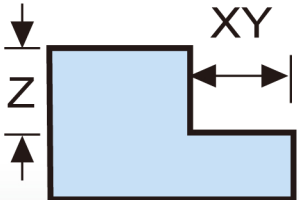


Work Material	Cast iron, FC, FCD		Mild Steels, Carbon Steels, SS400, S55C, (-750N/mm²)		Alloy Steels, Tool Steels, SCM.SKT, SKS, SKD(-30HRC)		Prehardened Steels SKT, SKD, NAK55 HPM(30-38HRC)		Stainless Steels, SUS304, SKD (38-45HRC)	
Velocity	100-140m/min		80-120m/min		70-100m/min		50-80m/min		35-65m/min	
Diameter	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
6	6350	760	5300	640	4500	360	3450	280	2650	210
8	4750	760	4000	640	3400	410	2600	310	2000	240
10	3800	760	3200	640	2700	430	2050	330	1600	260
12	3200	770	2650	640	2250	450	1700	340	1350	270
14	2750	770	2250	650	1950	470	1500	360	1150	280
16	2400	770	2000	640	1700	780	1300	360	1000	280
18	2100	760	1750	630	1500	480	1150	350	900	270
20	1900	760	1600	610	1350	470	1050	350	800	260
Depth of Cut	 XY=0.4D Z=1.5D						XY=0.3D Z=1.5D			

- Use an air blow. When using cutting fluids, use high-quality fluid with high smoke retardant properties.
- When chattering occurs, reduce the speed and feed simultaneously.
- Use a rigid and precise machine and holder.

(Slotting)

Work Material	Cast iron, FC, FCD		Mild Steels, Carbon Steels, SS400, S55C, (-750N/mm²)		Alloy Steels, Tool Steels, SCM.SKT, SKS, SKD(-30HRC)		Prehardened Steels SKT, SKD, NAK55 HPM(30-38HRC)		Stainless Steels, SUS304, SKD (38-45HRC)	
Velocity	80+120m/min		70-100m/min		55-85m/min		40-70m/min		30-60m/min	
Diameter	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
6	5300	640	4500	540	3700	300	2900	230	2400	190
8	4000	640	3400	540	2800	340	2200	260	1800	220
10	3200	640	2700	540	2250	360	1750	280	1450	230
12	2650	640	2250	540	1850	370	1450	290	1200	240
14	2250	630	1950	570	1600	380	1250	300	1000	240
16	2000	640	1700	540	1400	390	1100	310	900	250
18	1750	630	1500	540	1250	400	950	290	800	240
20	1600	640	1350	510	1100	390	900	300	700	230
Depth of Cut	XYmax=12mm Z=0.75D						Z=0.5D			

- Use an air blow. When using cutting fluids, use high-quality fluid with high smoke retardant properties.
- When chattering occurs, reduce the speed and feed simultaneously.
- Use a rigid and precise machine and holder.