

## RECOMMENDED CUTTING CONDITIONS

	Work Material	Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (inch)	l/d	Cutting Edge Preparation	
						* Corner Radius or C	* Honing
<b>P</b>	General Steel	100–165	–.004	.004–.012	5	.004–.020	.0004–.002
<b>M</b>	Stainless Steel	100–165	–.004	.004–.012	5	≤.016	≤.001 (Honing not required)
<b>K</b>	Cast Iron	100–165	–.002	.004–.012	5	.004–.020	.0004–.002
<b>N</b>	Non-Ferrous Material	200–330	–.004	.004–.020	5	.004–.020	≤.001 (Honing not required)

\* Cutting edge is not honed. Please hone according to the workpiece before machining.