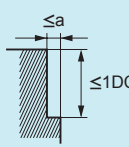
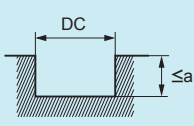


## RECOMMENDED CUTTING CONDITIONS

DC (mm)	Revolution (min <sup>-1</sup> )	Table feed		Depth of cut a (mm)	Revolution (min <sup>-1</sup> )	Table feed		Depth of cut a (mm)
		(mm/min)	(IPM)			(mm/min)	(IPM)	
<b>0.1</b>	40000	40	1.6	0.001	40000	40	1.6	0.001
<b>0.2</b>	40000	100	3.9	0.002	40000	100	3.9	0.002
<b>0.3</b>	40000	200	7.9	0.005	40000	200	7.9	0.005
<b>0.4</b>	40000	600	23.6	0.01	40000	600	23.6	0.01
<b>0.5</b>	40000	1000	39.4	0.015	40000	960	37.8	0.015
<b>0.6</b>	40000	1200	47.2	0.02	40000	1200	47.2	0.02
<b>0.7</b>	40000	1400	55.1	0.02	40000	1400	55.1	0.02
<b>0.8</b>	40000	1600	63.0	0.03	40000	1600	63.0	0.03
<b>0.9</b>	40000	1800	70.9	0.04	40000	1600	63.0	0.04
<b>1</b>	40000	2000	78.7	0.06	32000	1600	63.0	0.06
<b>1.5</b>	40000	3000	118.1	0.12	32000	1900	74.8	0.08
<b>2</b>	30000	3000	118.1	0.18	24000	1900	74.8	0.10
<b>2.5</b>	24000	2600	102.4	0.25	19000	1600	63.0	0.13
<b>3</b>	20000	2300	90.6	0.30	16000	1400	55.1	0.15
<b>4</b>	15000	2000	78.7	0.40	12000	1200	47.2	0.20
<b>5</b>	12000	1600	63.0	0.50	9000	900	35.4	0.25
<b>6</b>	10000	1400	55.1	0.60	7000	700	27.6	0.30
<b>8</b>	8000	1000	39.4	0.80	5600	550	21.7	0.40
<b>10</b>	6400	900	35.4	1.00	4500	500	19.7	0.50
<b>12</b>	5400	820	32.3	1.00	3800	450	17.7	0.50
<b>16</b>	2400	380	15.0	≤3	1200	100	3.9	≤0.8
<b>20</b>	1900	320	12.6	≤4	1000	80	3.1	≤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) When drilling, please set the feed rate at 1/3 or below of the above value.
- 4) 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.