

RECOMMENDED CUTTING CONDITIONS

Work material		Hardened steel (45—55HRC) AISI H13 etc.				Hardened steel (55—62HRC) AISI D2 etc.			
RE (inch)	LU (inch)	Revolution (min ⁻¹)	Table feed		Depth of cut ap (inch)	Revolution (min ⁻¹)	Table feed		Depth of cut ap (inch)
			(mm/min)	(IPM)			(mm/min)	(IPM)	
R .0156	.1250	40000	3000	118	.0016	40000	3000	118	.0012
R .0156	.1875	32000	1700	67	.0012	32000	1700	67	.0004
R .0313	.2500	40000	5000	197	.0031	26000	3300	129	.0028
R .0313	.3750	36000	3900	153	.0024	20000	2200	86	.0012
R .0469	.3750	37000	5200	204	.0047	20000	2600	102	.0043
R .0469	.5625	37000	4800	189	.0031	20000	2200	86.6	.0030
R .0625	.5000	30000	4800	189	.0051	15000	2100	82.6	.0051
R .0625	.7500	30000	4200	165	.0039	13000	1500	59	.0024
R .0938	.7500	20000	3600	142	.0079	10000	1400	55.1	.0071
R .0938	1.1250	20000	3400	134	.0059	8400	1100	43.3	.0055
R .1250	1.0000	15000	3300	130	.0079	7500	950	37.2	.0079
R .1250	1.5000	15000	3000	118	.0059	7500	750	29.5	.0059

Depth of cut	<p style="text-align: center;"> $\leq 0.1RE$ ($RE \leq .0469$) $\leq 0.2RE$ ($RE > .0469$) </p>
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1) If the depth of cut is smaller than this table, feed rate can be increased.

2) Cutting conditions may differ considerably due to the overhang, depth of cut, and machine tool conditions. Please use the above table as a start reference point.