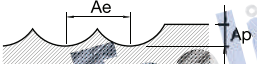


2ARB					Cutting Condition			
Material	Aluminium Alloys AL7075				Copper Alloys C1100			
Radius	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
0.25R	40000	700	0.010	0.025	34000	2000	0.015	0.050
0.3R	40000	800	0.012	0.030	34000	2300	0.018	0.060
0.4R	40000	1050	0.016	0.040	34000	2580	0.024	0.080
0.5R	40000	1200	0.020	0.050	34000	2880	0.030	0.100
0.6R	40000	1650	0.024	0.060	34000	3250	0.036	0.120
0.75R	40000	1950	0.030	0.075	34000	3600	0.045	0.150
1R	40000	2170	0.040	0.100	33150	4230	0.060	0.200
1.25R	37000	2250	0.050	0.125	28500	4100	0.075	0.250
1.5R	33125	2300	0.060	0.150	25500	4050	0.090	0.300
2R	23125	2450	0.080	0.200	22950	3870	0.120	0.400
2.5R	19125	2500	0.100	0.250	17000	3240	0.150	0.500
3R	16250	2500	0.120	0.300	31600	2610	0.180	0.600
4R	11875	2500	0.160	0.400	11050	2340	0.240	0.800
5R	10000	2200	0.200	0.500	8500	2200	0.300	1.000
6R	8125	2170	0.240	0.600	6800	2050	0.360	1.200
8R	7500	2000	0.320	0.800	5100	2000	0.480	1.600
Depth of Cut								

- If the effective length is long, lower RPM and FEED at the same ratio.
- We recommend using a soluble Cutting fluid for smooth chip evacuation.
- If the rotation speed of the applied machine is insufficient, reduce the rotation speed and feed rate at the same ratio.
- Please use a rigid and low-vibration machine (vibration tolerance within 5µm for Ø1 or below).
- For smooth chip evacuation, we recommend using air blow or mist coolant, and for non-ferrous materials, we recommend using wet coolant during machining.
- The above cutting conditions are numerical values, so they may need to be adjusted depending on the actual machining shape, machining purpose and applied machine.