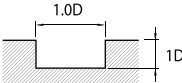
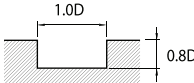
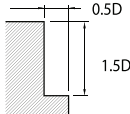
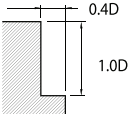


3EHROU/4EHROU									Cutting Conditions							
Slotting																
Material	Mild Steels/Free Cutting Steels HP/SM				Structural steels/Carbon Steels/Gray Cast Iron SS/SC/FC				Tool Steels/Mould Steels SCM/HPM				Alloy Steels / Prehardened Steels NAK80/KP4M			
Hardness	~ 200HB				~ 30HRC				30 ~40HRC				40 ~ 45HRC			
Outside Dia	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 4	4,698	486	4.0	4.0	3,888	243	4.0	4.0	3,321	162	4.0	4.0	2,592	122	3.2	4.0
Ø 5	4,698	486	5.0	5.0	3,888	251	5.0	5.0	2,997	186	5.0	5.0	2,268	138	4.0	5.0
Ø 6	3,888	486	6.0	6.0	3,402	267	6.0	6.0	2,592	203	6.0	6.0	1,944	162	4.8	6.0
Ø 8	2,997	486	8.0	8.0	2,511	307	8.0	8.0	1,944	235	8.0	8.0	1,458	178	6.4	8.0
Ø 10	2,430	486	10.0	10.0	2,025	324	10.0	10.0	1,458	243	10.0	10.0	1,215	203	8.0	10.0
Ø 12	1,944	486	12.0	12.0	1,701	332	12.0	12.0	1,296	251	12.0	12.0	1,053	203	9.6	12.0
Ø 16	1,499	486	16.0	16.0	1,296	356	16.0	16.0	972	267	16.0	16.0	810	203	12.8	16.0
Ø 20	1,215	446	20.0	20.0	1,053	348	20.0	20.0	729	259	20.0	20.0	608	194	16.0	20.0
Depth of cut		 														

Side Cutting																
Material	Mild Steels/Free Cutting Steels HP/SM				Structural steels/Carbon Steels/Gray Cast Iron SS/SC/FC				Tool Steels/Mould Steels SCM/HPM				Alloy Steels / Prehardened Steels NAK80/KP4M			
Hardness	~ 200HB				~ 30HRC				30 ~40HRC				40 ~ 45HRC			
Outside Dia	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 4	5,220	540	6.0	2.0	4,320	270	6.0	2.0	3,690	180	6.0	2.0	2,880	135	4.0	1.6
Ø 5	5,220	540	7.5	2.5	4,320	279	7.5	2.5	3,330	207	7.5	2.5	2,520	153	5.0	2.0
Ø 6	4,320	540	9.0	3.0	3,780	297	9.0	3.0	2,880	225	9.0	3.0	2,160	180	6.0	2.4
Ø 8	3,330	540	12.0	4.0	2,790	342	12.0	4.0	2,160	261	12.0	4.0	1,620	198	8.0	3.2
Ø 10	2,700	540	15.0	5.0	2,250	360	15.0	5.0	1,620	270	15.0	5.0	1,350	225	10.0	4.0
Ø 12	2,160	540	18.0	6.0	1,890	369	18.0	6.0	1,440	279	18.0	6.0	1,170	225	12.0	4.8
Ø 16	1,665	540	24.0	8.0	1,440	396	24.0	8.0	1,080	297	24.0	8.0	900	225	16.0	6.4
Ø 20	1,350	495	30.0	10.0	1,170	387	30.0	10.0	810	288	30.0	10.0	675	216	20.0	8.0
Depth of cut		~ 38HRC  38HRC ~ 														

- Use a rigid precise machine and holder.
- Ap(mm): Axial Depth of cut.
- Ae(mm): Radial Depth of cut.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- Depending on the workpiece and shape, use adequate coolant.
- For stainless and Heat resistance alloy, water soluble oil is the most effective.
- In case of workpiece and machine do not have enough rigidity and make vibration reduce the RPM and feed in the same proportion.
- Air blow or oil mist is recommended for smooth chip emission and wet coolant milling is recommended for copper material.
- The Above condition are only reference. In actual machining conditions adjust these parameters according to the milling shape, machine ability and the operation environment.