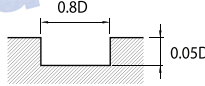
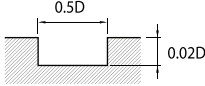
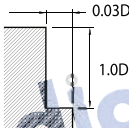
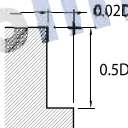


2HPE			Cutting Condition			
Slotting						
Material	Hardened Steels STAVAX/SKD11		Heat-treated Steels / Hardened Steels SKD11 / SKD61		Heat-treated Steels / Hardened Steels YXR7 / SKH51	
Hardness	45 ~ 55HRC		55 ~ 65HRC		62 ~ 70HRC	
Outside Dia	RPM	FEED	RPM	FEED	RPM	FEED
Ø0.5	33,000	140	25000	85	20,000	75
Ø0.6	30,000	160	25000	105	15,200	80
Ø0.8	25,000	185	19000	110	14,000	90
Ø0.9	22,700	205	17500	125	12,500	85
Ø1	20,500	670	16000	340	12,500	160
Ø2	14,500	800	11000	400	9,500	210
Ø3	9,500	800	7500	400	6,400	210
Ø4	7,200	840	5600	425	4,750	220
Ø5	6,400	885	5100	450	4,450	245
Ø6	5,300	870	4200	450	3,700	240
Ø8	4,000	800	3200	400	2,800	220
Ø10	3,200	750	2550	390	2,200	210
Ø12	2,650	750	2100	390	1,860	210
Ø16	1,840	560	1800	250	1,460	185
Ø18	1,840	560	1800	250	1,460	185
Ø20	1,460	560	1400	250	1,100	185
Depth of Cut	 ~ 60HRC		 60HRC ~			

- When milling workpiece HRC below 55(Alloy steel, tool steel), raise up 20% RPM and feed compared to the same diameter.
- Use the table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine or found red heat on the material, adjust RPM and feed in the same proportion.
- Use suitable cutting oil for material and machining geometry.

2HPE			Cutting Condition			
Side Cutting						
Material	Hardened Steels STAVAX/SKD11		Heat-treated Steels / Hardened Steels SKD11 / SKD61		Heat-treated Steels / Hardened Steels YXR7 / SKH51	
Hardness	45 ~ 55HRC		55 ~ 65HRC		62 ~ 70HRC	
Outside Dia	RPM	FEED	RPM	FEED	RPM	FEED
Ø1	20,500	775	16000	340	12,500	323
Ø2	14,500	925	11000	415	9,500	394
Ø3	9,500	925	7500	415	6,400	394
Ø4	7,200	960	5600	430	4,750	409
Ø5	6,400	1020	5100	470	4,450	447
Ø6	5,300	1000	4200	460	3,700	437
Ø8	4,000	910	3200	425	2,800	404
Ø10	3,200	850	2550	400	2,200	380
Ø12	2,650	850	2100	400	1,860	380
Ø16	1,840	750	1800	340	1,800	323
Ø18	1,840	750	1800	340	1,800	323
Ø20	1,460	750	1400	325	1,400	309
Depth of Cut	 ~ 60HRC  60HRC ~					

- When milling workpiece HRC below 55(Alloy steel, tool steel), raise up 20% RPM and feed compared to the same diameter.
- Use the table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine or found red heat on the material, adjust RPM and feed in the same proportion.
- Use suitable cutting oil for material and machining geometry.