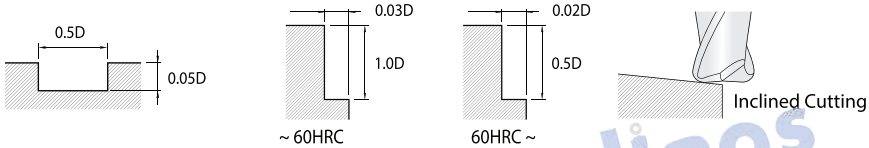
RPM : rev./min FEED : mm/min

4&6HHR							Cutting Condition					
	Slotting						Side Cutting					
Material	Alloy Steels/Prehardened Steels **NAK80/KP4M**		Hardened Steels **STAVAX/SKD11**		Heat–treated Steels / Hardened Steels **SKD11 / SKD61**		Alloy Steels/Prehardened Steels **NAK80/KP4M**		Hardened Steels **STAVAX/SKD11**		Heat–treated Steels / Hardened Steels **SKD11 / SKD61**	
Hardness	40 ~ 45HRC		45 ~ 55HRC		55 ~ 62HRC		40 ~ 45HRC		45 ~ 55HRC		55 ~ 62HRC	
Outside Dia	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
Ø 1	28,000	500	25500	300	18,500	150	30000	500	28,000	430	24500	300
Ø 2	14,820	700	13500	400	9,500	200	16500	700	14,300	600	12500	450
Ø 3	7,800	800	6900	400	6,000	220	11500	1100	10,500	860	9500	650
Ø 4	7,150	800	6100	450	5,750	250	9200	1100	7,600	900	7100	680
Ø 5	6,500	900	5700	510	5,100	300	7200	1200	6,400	950	6000	720
Ø 6	6,100	1000	5150	520	4,850	320	6200	1300	5,300	1040	4950	810
Ø 8	5,800	1100	4810	520	4,150	330	4800	1400	4,100	1120	3900	820
Ø 10	5,500	1200	4200	500	3,850	310	3700	1300	3,000	1030	2600	810
Ø 12	5,100	1100	3950	450	3,500	290	3000	1200	2,700	980	2100	780
Ø 16	4,750	1100	3700	430	3,200	290	2750	1200	2,450	980	1950	760
Depth of Cut												

- For stable cutting, set the ae value by paying attention to the corner radius during grooving machining.
- In case of long effective length, reduce the RPM and feed by 30% or less.
- In case the material of HRC over 60,reduce the RPM and feed by 20%.
- 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.
- Air blow or mist coolants are recommended and note for chip emmision,heat or ignition.

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