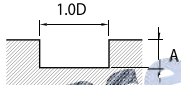


3&4&5SRR		Cutting Condition		
Material	Stainless Steels / Titanium Alloy Steels			
	SUS304 / SUS 316 / Ti6A			
Outside Dia.	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 3	5,000	380	0.90	3.0
Ø 4	4,800	350	1.20	4.0
Ø 5	4,700	350	1.50	5.0
Ø 6	4,400	340	1.50	6.0
Ø 7	3,800	340	1.75	7.0
Ø 8	3,300	340	2.00	8.0
Ø 9	3,000	340	2.25	9.0
Ø 10	2,700	330	2.50	10.0
Ø 12	2,200	330	1.80	12.0
Ø 14	2,000	310	2.10	14.0
Ø 16	1,750	300	2.40	16.0
Ø 20	1,300	210	2.00	20.0
Depth of Cut			<p>Ø3 ~ 5 = 0.3 x D Ø6 ~ 10 = 0.25 x D Ø12 ~ 16 = 0.15 x D Ø18 ~ 20 = 0.1 x D</p>	

- When entering the tool to the workplace, enter the tool from outside to the workplace.
- If the effective length is long, reduce the RPM and feed maximum 30%.
- Use this 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.
- In case of workpiece and machine do not have enough rigidity and make vibration, reduce the RPM and feed in same proportion.
- Depending on the workpiece and shape, use adequate coolant.
- For parting off stainless or hear resistant alloy, using water-soluble oil is the most effective way.