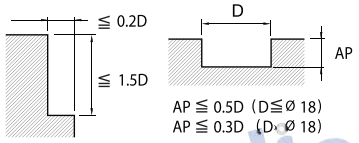
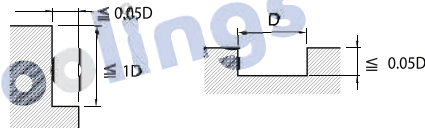


3SEM					Cutting Condition							
Material	Stainless Steels / Titanium alloys Steels SUS304 /SUS316/Ti6A				STAVAX/SKD11				Heat Resistance Alloys			
Hardness					45 ~ 55HRC							
Outside Dia.	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 0.8	6,400	80	1.20	0.16	7,800	210	0.80	0.04	2,000	20	0.80	0.04
Ø 1	5,600	90	1.50	0.20	7,000	210	1.00	0.05	1,700	30	1.00	0.05
Ø 2	4,800	100	3.00	0.40	5,800	238	1.50	0.08	1,400	40	1.50	0.08
Ø 3	4,000	120	4.50	0.60	4,400	315	2.50	0.13	1,400	50	2.50	0.13
Ø 4	3,300	180	6.00	0.80	3,600	490	3.00	0.15	1,200	70	3.00	0.15
Ø 5	2,700	220	7.50	1.00	3,000	630	4.00	0.20	1,000	90	4.00	0.20
Ø 6	2,400	230	9.00	1.20	2,800	630	5.00	0.25	900	90	5.00	0.25
Ø 8	1,800	250	12.00	1.50	2,000	700	7.00	0.35	720	80	7.00	0.35
Ø 10	1,400	250	14.00	1.80	1,800	770	9.00	0.45	600	80	9.00	0.45
Ø 12	1,200	200	17.00	2.00	1,400	630	10.00	0.50	500	70	10.00	0.50
Ø 16	900	150	23.00	2.50	1,100	420	15.00	0.75	360	60	15.00	0.75
Depth of Cut												

- If the effective length is long, reduce the RPM and feed in the same proportion.
- If the diameter or effective length of your tool are not on the table, adjust it compared similarity value on the table
- The edge of the flute precisely grinded. If you want to measure the tool, and to avoid damaging on the flutes, use non-contact measuring method.
- 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