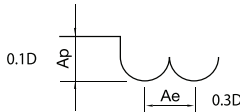
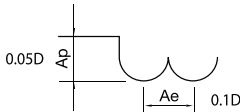
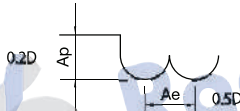
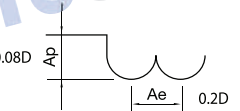


3SRB					Cutting Condition							
Material	Tool Steels / Mould Steels SCM/HPM				Stainless Steels SUS304/SUS316				Hardened Steels STAVAX/SKD11			
Hardness	30 ~ 40HRC								45 ~ 55HRC			
Corner Radius	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
R0.5	42,000	500	0.10	0.30	25,000	220	0.10	0.30	9,000	130	0.05	0.10
R0.75	38,000	520	0.15	0.45	17,000	250	0.15	0.45	7,600	185	0.08	0.15
R1	24,000	550	0.20	0.60	12,700	300	0.20	0.60	6,400	225	0.10	0.20
R1.5	16,000	600	0.30	0.90	8,500	310	0.30	0.90	5,460	272	0.15	0.30
R2	12,000	530	0.40	1.20	6,400	290	0.40	1.20	4,160	208	0.20	0.40
R3	8,000	350	0.60	1.80	4,200	240	0.60	1.80	2,730	168	0.30	0.60
R4	5,900	270	0.80	2.40	3,190	240	0.80	2.40	2,080	152	0.40	0.80
R5	4,700	200	1.00	3.00	2,550	230	1.00	3.00	1,690	144	0.50	1.00
R6	4,000	180	1.20	3.60	2,100	230	1.20	3.60	1,430	100	0.60	1.20
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.
- When milling workpiece, HRC over 55 hardened steel, reduce 20% of the RPM and feed compared to the same diameter.
- 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
- Air blow or oil mist is recommended for smooth chip emission.

4SPB					Cutting Condition							
Material	Tool Steels / Mould Steels SCM/HPM				Stainless Steels SUS304/SUS316				Hardened Steels STAVAX/SKD11			
Hardness	30 ~ 40HRC								45 ~ 55HRC			
Corner Radius	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
R1.5	13,860	707	0.30	0.90	9,600	387	0.30	0.90	5,040	376	0.15	0.30
R2	10,560	619	0.40	1.20	7,200	354	0.40	1.20	3,840	287	0.20	0.40
R2.5	8,382	575	0.50	1.50	5,760	309	0.50	1.50	3,000	276	0.25	0.50
R3	6,996	464	0.60	1.80	4,800	287	0.60	1.80	2,520	232	0.30	0.60
R4	5,280	420	0.80	2.40	3,600	287	0.80	2.40	1,920	210	0.40	0.80
R5	4,224	398	1.00	3.00	2,880	276	1.00	3.00	1,560	199	0.50	1.00
R6	3,498	398	1.20	3.60	2,400	276	1.20	3.60	1,320	186	0.60	1.20
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
- When milling workpiece, HRC over 55 hardened steel, reduce 20% of the RPM and feed compared to the same diameter
- 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, reduce the RPM and feed in the same proportion
- Air blow or oil mist is recommended for smooth chip emission.