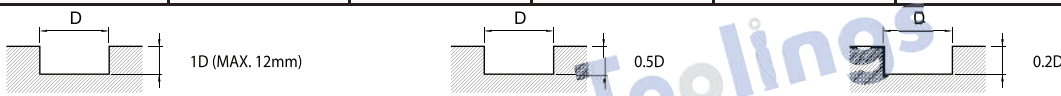


4SLR					Cutting Condition							
Material	Alloy Steels / Pre-hardened Steels NAK80/KP4M				Stainless Steels / Titanium alloy Steels SUS304/SUS316/Ti6A				Heat Resistance Alloys			
	40 ~ 45HRC											
Outside Dia.	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 1	14,300	380	0.5	1.0	9,600	310	0.5	1.0	4,770	80	0.2	1.0
Ø 2	8,500	400	1.0	2.0	9,600	310	1.0	2.0	3,000	100	0.4	2.0
Ø 3	6,900	410	1.5	3.0	7,400	380	1.5	3.0	2,700	110	0.6	3.0
Ø 4	5,600	490	2.0	4.0	5,600	400	2.0	4.0	2,000	120	0.8	4.0
Ø 5	4,500	630	2.5	5.0	4,500	410	2.5	5.0	1,600	130	1.0	5.0
Ø 6	3,700	740	3.0	6.0	3,700	440	3.0	6.0	1,300	160	1.2	6.0
Ø 7	3,200	700	3.5	7.0	3,200	410	3.5	7.0	1,100	140	1.4	7.0
Ø 8	2,800	670	4.0	8.0	2,800	390	4.0	8.0	1,000	130	1.6	8.0
Ø 10	2,200	530	5.0	10.0	2,200	350	5.0	10.0	800	130	2.0	10.0
Ø 11	2,000	530	5.5	11.0	2,000	320	5.5	11.0	720	120	2.2	11.0
Ø 12	1,900	530	6.0	12.0	1,900	300	6.0	12.0	660	110	2.4	12.0
Ø 16	1,400	390	8.0	16.0	1,400	280	8.0	16.0	500	80	3.2	16.0
Ø 20	1,100	350	10.0	20.0	1,100	260	10.0	20.0	400	60	4.0	20.0
Depth of Cut												

- When entering the tool to the workpiece, enter the tool from outside to the workpiece.
- 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 heat resistant alloy, using water-soluble oil is the most effective way.