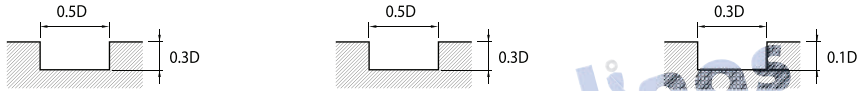


4SRR					Cutting Condition							
Material	Alloy Steels / Pre-hardened Steels NAK80/KP4M				Stainless Steels / Titanium alloy Steels SUS304/SUS316/Ti6A				Heat Resistance Alloys			
	40 ~ 45HRC											
Outside Dia.	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 1	13,210	357	0.3	0.5	10,836	339	0.3	0.5	5,820	78	0.1	0.3
Ø 2	11,270	518	0.6	1.0	9,391	339	0.6	1.0	4,840	109	0.2	0.6
Ø 3	8,054	588	0.9	1.5	7,112	515	0.9	1.5	4,239	155	0.3	0.9
Ø 4	5,904	657	1.2	2.0	5,366	585	1.2	2.0	3,230	178	0.4	1.2
Ø 5	5,155	887	1.5	2.5	4,291	608	1.5	2.5	2,522	202	0.5	1.5
Ø 6	4,301	1,037	1.8	3.0	3,552	608	1.8	3.0	2,115	202	0.6	1.8
Ø 8	3,216	749	2.4	4.0	2,683	573	2.4	4.0	1,610	202	0.8	2.4
Ø 10	2,573	657	3.0	5.0	2,150	468	3.0	5.0	1,310	171	1.0	3.0
Ø 12	2,150	576	3.6	6.0	1,806	468	3.6	6.0	1,106	140	1.2	3.6
Ø 16	1,613	541	4.8	8.0	1,342	339	4.8	8.0	805	109	1.6	4.8
Ø 20	1,286	404	6.0	10.0	1,075	304	6.0	10.0	601	78	2.0	6.0
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.
- Consider the corner radius value when you set up the Ae value.
- 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.
- Use a machine with low vibration and good rigidity (Ø1 or less, the vibration tolerance management should be within 5µm).