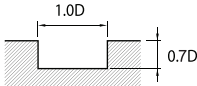
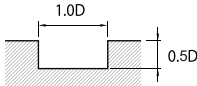
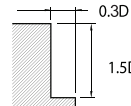
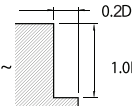


3&4WROU					Cutting Conditions											
Slotting																
Material	Mild Steel/Free Cutting Steel HP/SM				Structural Steels/Carbon Steels/Gray Cast Iron SS/SC/FC				Tool Steels/Mould Steels SCM/HPM				Alloy Steels / Pre-hardened Steels/Stainless Steels NAK80/KP4M/SUS304/SUS316			
Hardness	~ 200HB				~30HRC				30 ~ 40HRC				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	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 4	4,000	211	0.25	4	4,000	430	2.8	4	3,800	200	2.8	4	2,800	110	2	4
Ø 5	4,000	242	0.35	5	4,000	430	3.5	5	3,400	220	3.5	5	2,500	130	2.5	5
Ø 6	3,600	281	0.4	6	3,600	430	4.2	6	3,000	240	4.2	6	2,300	150	3	6
Ø 8	2,700	338	0.55	8	2,700	430	5.6	8	2,200	270	5.6	8	1,800	180	4	8
Ø 10	2,200	380	0.7	10	2,200	430	7	10	1,800	290	7	10	1,400	185	5	10
Ø 12	1,800	332	0.85	12	1,800	430	8.4	12	1,500	300	8.4	12	1,200	190	6	12
Ø 16	1,400	305	1.1	16	1,400	430	11.2	16	1,100	310	11.2	16	900	200	8	16
Ø 20	1,100	281	1.4	20	1,100	430	14	20	900	310	14	20	700	185	10	20
Depth of cut	 															

Side Cutting																
Material	Mild Steel/Free Cutting Steel HP/SM				Structural Steels/Carbon Steels/Gray Cast Iron SS/SC/FC				Tool Steels/Mould Steels SCM/HPM				Alloy Steels / Pre-hardened Steels/Stainless Steels NAK80/KP4M/SUS304/SUS316			
Hardness	~ 200HB				~30HRC				30 ~ 40HRC				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	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 4	5,000	469	6	0.12	4,200	398	6	0.12	3,800	359	6	0.12	2,800	305	4	0.08
Ø 5	5,000	538	7.5	0.15	4,200	457	7.5	0.15	3,200	411	7.5	0.15	2,400	350	5	0.10
Ø 6	4,200	625	9	0.18	3,600	531	9	0.18	2,800	478	9	0.18	2,100	406	6	0.12
Ø 8	3,200	750	12	0.24	2,700	638	12	0.24	2,100	574	12	0.24	1,600	488	8	0.16
Ø 10	2,600	844	15	0.30	2,200	717	15	0.30	1,600	645	15	0.30	1,300	549	10	0.20
Ø 12	2,100	738	18	0.36	1,800	627	18	0.36	1,400	564	18	0.36	1,100	480	12	0.24
Ø 16	1,800	678	21	0.48	1,400	576	21	0.48	1,000	519	21	0.48	800	441	16	0.32
Ø 20	1,300	625	30	0.60	1,100	531	30	0.60	800	478	30	0.60	640	406	20	0.40
Depth of cut	 															

- If the effective length is long, reduce the RPM and feed maximum 30%.
- Use laser tool measurement instead of hydraulic measurement when measuring tool length as possible.
- When entering the tool to the workpiece, enter the tool from outside to the workpiece.
- In the 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 stainless and heat resistant alloy, water-soluble oil is the most effective.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.