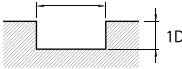
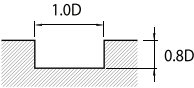
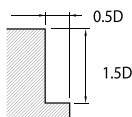
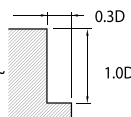


3EROUG/4EROUG									Cutting Conditions							
Slotting																
Material	Mild Steels/Free Cutting Steels HP/SM				Structural Steels/Carbon Steels/Gray Cast Iron SS/SC/FC				Tool Steels/Mould Steels SCM/HPM				Alloy Steels / Prehardened Steels NAK80/KP4M			
Hardness	~ 200HB				~ 30HRC				30 ~40HRC				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	3,870	395	4.0	4.0	3,251	191	4.0	4.0	2,786	170	4.0	4.0	2,167	111	3.2	4.0
Ø 5	3,870	395	5.0	5.0	3,251	218	5.0	5.0	2,477	195	5.0	5.0	1,858	127	4.0	5.0
Ø 6	3,251	395	6.0	6.0	2,786	254	6.0	6.0	2,167	227	6.0	6.0	1,625	148	4.8	6.0
Ø 8	2,477	395	8.0	8.0	2,090	305	8.0	8.0	1,625	273	8.0	8.0	1,238	177	6.4	8.0
Ø 10	2,012	395	10.0	10.0	1,703	343	10.0	10.0	1,238	307	10.0	10.0	1,006	199	8.0	10.0
Ø 12	1,625	395	12.0	12.0	1,393	300	12.0	12.0	1,084	268	12.0	12.0	851	174	9.6	12.0
Ø 16	1,238	395	16.0	16.0	1,084	276	16.0	16.0	774	246	16.0	16.0	619	160	12.8	16.0
Ø 20	1,006	372	20.0	20.0	851	254	20.0	20.0	619	227	20.0	20.0	495	148	16.0	20.0
Depth of cut		~ 38HRC  38HRC ~ 														

Side Cutting																
Material	Mild Steels/Free Cutting Steels HP/SM				Structural Steels/Carbon Steels/Gray Cast Iron SS/SC/FC				Tool Steels/Mould Steels SCM/HPM				Alloy Steels / Prehardened Steels NAK80/KP4M			
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	4,300	439	6.0	2.0	3,612	280	6.0	2.0	3,096	194	6.0	2.0	2,408	140	4.0	1.2
Ø 5	4,300	439	7.5	2.5	3,612	290	7.5	2.5	2,752	215	7.5	2.5	2,064	161	5.0	1.5
Ø 6	3,612	439	9.0	3.0	3,096	312	9.0	3.0	2,408	237	9.0	3.0	1,806	183	6.0	1.8
Ø 8	2,752	439	12.0	4.0	2,322	355	12.0	4.0	1,806	269	12.0	4.0	1,376	204	8.0	2.4
Ø 10	2,236	439	15.0	5.0	1,892	371	15.0	5.0	1,376	280	15.0	5.0	1,118	226	10.0	3.0
Ø 12	1,806	439	18.0	6.0	1,548	387	18.0	6.0	1,204	290	18.0	6.0	946	231	12.0	3.6
Ø 16	1,376	439	24.0	8.0	1,204	414	24.0	8.0	860	312	24.0	8.0	688	237	16.0	4.8
Ø 20	1,118	413	30.0	10.0	946	403	30.0	10.0	688	301	30.0	10.0	550	226	20.0	6.0
Depth of cut		 														

- Use a rigid precise machine and holder.
- Ap(mm): Axial Depth of cut.
- Ae(mm): Radial Depth of cut.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- Depending on the workpiece and shape, use adequate coolant.
- For stainless and Heat resistance alloy, water soluble oil is the most effective.
- In case of workpiece and machine do not have enough rigidity and make vibration reduce the RPM and feed in the same proportion
- Air blow or oil mist is recommended for smooth chip emission and wet coolant milling is recommended for copper material.
- The Above condition are only reference. In actual machining conditions adjust these parameters according to the milling shape, machine ability and the operation environment.