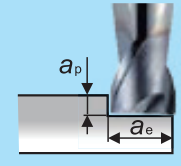


Flute	Cutting diameter $\varphi D_c$ (mm)	Carbon steel S45C		Alloy steel SCM435		Stainless steel SUS304		 $a_e = \varphi D_c \times 0.2$		 $a_e = \varphi D_c \times 0.5$		 $a_e = \varphi D_c \times 0.75$		 $a_e = \varphi D_c \times 0.9$		 $a_e = \varphi D_c$
		RPM ( $\text{min}^{-1}$ )	Feed (mm/min)	RPM ( $\text{min}^{-1}$ )	Feed (mm/min)	RPM ( $\text{min}^{-1}$ )	Feed (mm/min)	$a_p$ (mm)	$a_e$ (mm)	$a_p$ (mm)	$a_e$ (mm)	$a_p$ (mm)	$a_e$ (mm)	$a_p$ (mm)	$a_e$ (mm)	$a_p$ (mm)
2 flutes	2.0	6,000	100	6,000	100	6,000	90	$\leq 2.0$	0.4	$\leq 0.8$	1.0	$\leq 0.6$	1.5	$\leq 0.5$	1.8	$\leq 0.4$
	3.0	6,000	210	6,000	240	6,000	180	$\leq 3.0$	0.6	$\leq 1.2$	1.5	$\leq 0.9$	2.3	$\leq 0.7$	2.7	$\leq 0.6$
	4.0	6,000	320	5,600	300	5,200	240	$\leq 4.0$	0.8	$\leq 1.6$	2.0	$\leq 1.2$	3.0	$\leq 1.0$	3.6	$\leq 0.8$
	5.0	5,000	370	4,500	330	4,100	260	$\leq 5.0$	1.0	$\leq 2.0$	2.5	$\leq 1.5$	3.8	$\leq 1.2$	4.5	$\leq 1.0$
	6.0	4,200	380	3,700	340	3,400	270	$\leq 6.0$	1.2	$\leq 2.4$	3.0	$\leq 1.8$	4.5	$\leq 1.5$	5.4	$\leq 1.2$
	7.0	3,600	370	3,200	330	3,000	270	$\leq 6.0$	1.4	$\leq 2.8$	3.5	$\leq 2.1$	5.3	$\leq 1.7$	6.3	$\leq 1.4$
	8.0	3,200	360	2,800	320	2,600	250	$\leq 6.0$	1.6	$\leq 3.2$	4.0	$\leq 2.4$	6.0	$\leq 2.0$	7.2	$\leq 1.6$
	10.0	2,500	320	2,200	280	2,100	230	$\leq 6.0$	2.0	$\leq 4.0$	5.0	$\leq 3.0$	7.5	$\leq 2.5$	9.0	$\leq 2.0$
3 flutes	3.0	6,000	250	6,000	250	6,000	220	$\leq 3.0$	0.6	$\leq 1.2$	1.5	$\leq 0.9$	2.3	$\leq 0.7$	2.7	$\leq 0.6$
	4.0	6,000	390	5,600	360	5,200	290	$\leq 4.0$	0.8	$\leq 1.6$	2.0	$\leq 1.2$	3.0	$\leq 1.0$	3.6	$\leq 0.8$
	5.0	5,000	440	4,500	400	4,100	310	$\leq 5.0$	1.0	$\leq 2.0$	2.5	$\leq 1.5$	3.8	$\leq 1.2$	4.5	$\leq 1.0$
	6.0	4,200	460	3,700	410	3,400	330	$\leq 6.0$	1.2	$\leq 2.4$	3.0	$\leq 1.8$	4.5	$\leq 1.5$	5.4	$\leq 1.2$
	7.0	3,600	450	3,200	400	3,000	320	$\leq 6.0$	1.4	$\leq 2.8$	3.5	$\leq 2.1$	5.3	$\leq 1.7$	6.3	$\leq 1.4$
	8.0	3,200	430	2,800	380	2,600	310	$\leq 6.0$	1.6	$\leq 3.2$	4.0	$\leq 2.4$	6.0	$\leq 2.0$	7.2	$\leq 1.6$
	10.0	2,500	380	2,200	330	2,100	280	$\leq 6.0$	2.0	$\leq 4.0$	5.0	$\leq 3.0$	7.5	$\leq 2.5$	9.0	$\leq 2.0$
4 flutes	3.0	6,000	290	6,000	290	6,000	250	$\leq 3.0$	0.6	$\leq 1.2$	1.5	$\leq 0.9$	2.3	$\leq 0.7$	2.7	$\leq 0.6$
	4.0	6,000	450	5,500	410	5,200	340	$\leq 4.0$	0.8	$\leq 1.6$	2.0	$\leq 1.2$	3.0	$\leq 1.0$	3.6	$\leq 0.8$
	5.0	5,000	520	4,500	460	4,100	370	$\leq 5.0$	1.0	$\leq 2.0$	2.5	$\leq 1.5$	3.8	$\leq 1.2$	4.5	$\leq 1.0$
	6.0	4,200	540	3,700	480	3,400	380	$\leq 6.0$	1.2	$\leq 2.4$	3.0	$\leq 1.8$	4.5	$\leq 1.5$	5.4	$\leq 1.2$
	7.0	3,600	520	3,200	460	3,000	380	$\leq 6.0$	1.4	$\leq 2.8$	3.5	$\leq 2.1$	5.3	$\leq 1.7$	6.3	$\leq 1.4$
	8.0	3,200	500	2,800	440	2,600	360	$\leq 6.0$	1.6	$\leq 3.2$	4.0	$\leq 2.4$	6.0	$\leq 2.0$	7.2	$\leq 1.6$
	10.0	2,500	440	2,200	390	2,100	320	$\leq 6.0$	2.0	$\leq 4.0$	5.0	$\leq 3.0$	7.5	$\leq 2.5$	9.0	$\leq 2.0$

• Cutting conditions (machine, work material...) affect surface finish and burr generation.

If cutting performance is not good with above cutting condition, please adjust speed and feed by same %.