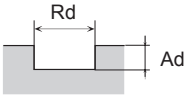
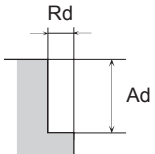


SAE4000R (Milling Condition)



Danger of fire by spark incidence or heat caused by tool breakage can happen during processing.
Confirm fire prevention countermeasure beforehand necessarily before use.

Work Material	CAST IRON		STAINLESS STEEL 300 SERIES		STAINLESS STEEL 400 SERIES	
Outside Diameter	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)
6	5,850	600	4,250	370	5,040	550
8	4,380	700	3,190	430	3,780	650
10	3,500	700	2,550	430	3,030	650
12	2,920	700	2,120	430	2,520	650
16	2,190	550	1,600	350	1,590	500
18	1,950	530	1,420	340	1,680	480
20	1,750	530	1,270	310	1,510	450
DEPTH OF CUT	 $Ad=1.0D$ $Rd=1.0D(Max.)$  $Ad=1.0D(Max.)$ $Rd=0.5D(Max.)$					

1. Use a rigid and precise machine and holder.