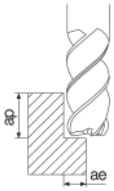


RECOMMENDED CUTTING CONDITIONS

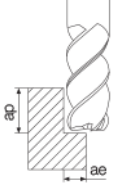

2FESL (Shouldering)

Applications	Workpiece Material	Outside Dia. Dc (mm)	Ø1	Ø2	Ø4	Ø6	Ø8	Ø12	Ø16
 <p>Shouldering</p> <p>(ap×ae) (inch)</p> <p>0.0984Dc×0.0020Dc (Dc<Ø3)</p> <p>0.0984Dc×0.0039Dc (Dc≥Ø3)</p>	Carbon Steel	Spindle RPM	19,000	9,500	4,800	3,200	2,400	1,600	1,200
		Feed Rate (IPM)	8.268	8.268	8.268	8.268	8.268	8.268	8.268
	Alloy Steel	Spindle RPM	14,300	7,200	3,600	2,400	2,000	1,300	1,000
		Feed Rate (IPM)	6.102	6.299	6.299	6.299	6.693	6.693	5.906
	Pre-hardened Steel (30~45HRC)	Spindle RPM	11,200	5,600	2,800	1,900	1,600	1,000	800
		Feed Rate (IPM)	3.346	3.346	3.543	3.543	3.937	3.740	3.150
	Stainless Steel	Spindle RPM	14,300	7,200	3,600	2,400	2,000	1,300	1,000
		Feed Rate (IPM)	3.740	3.740	3.740	3.740	4.134	4.134	3.150

* Cutting with coolant is recommended for stainless steel.

Slotting is not recommended.

2FEKS, 2FEKM

Applications	Workpiece Material	Application	Outside Dia. Dc (mm)	Ø3	Ø4	Ø6	Ø8	Ø10	Ø12	Ø16
 <p>Shouldering</p> <p>(ap×ae) (inch)</p> <p>0.0472Dc×0.0039Dc</p>  <p>Slotting</p> <p>(ae) (inch)</p> <p>0.0197Dc</p>	Carbon Steel	Shouldering	Spindle RPM	9,300	7,000	4,600	3,500	3,000	2,700	2,200
			Feed Rate (IPM)	17.717	17.717	18.504	18.504	18.504	18.504	17.323
		Slotting	Spindle RPM	7,500	6,000	4,400	3,300	2,700	2,300	1,900
			Feed Rate (IPM)	9.449	10.236	13.386	13.386	13.386	13.386	12.598
	Alloy Steel	Shouldering	Spindle RPM	8,800	6,600	4,400	3,300	2,600	2,200	1,800
			Feed Rate (IPM)	14.567	14.567	14.961	14.961	14.961	14.961	14.173
		Slotting	Spindle RPM	7,200	5,400	3,600	2,700	2,200	1,800	1,500
			Feed Rate (IPM)	10.630	10.630	10.630	10.630	10.630	10.630	10.630
	Pre-hardened Steel (30~45HRC)	Shouldering	Spindle RPM	6,400	4,800	3,200	2,400	1,900	1,600	1,200
			Feed Rate (IPM)	5.118	5.118	5.118	5.512	5.512	5.512	5.512
		Slotting	Spindle RPM	5,300	4,000	2,600	2,000	1,600	1,300	1,000
			Feed Rate (IPM)	4.724	4.724	4.724	4.724	4.724	4.724	4.724
Stainless Steel	Shouldering	Spindle RPM	8,000	6,000	4,000	3,000	2,400	2,000	1,500	
		Feed Rate (IPM)	5.512	5.512	5.512	5.512	5.512	5.512	5.512	
	Slotting	Spindle RPM	5,300	4,000	2,600	2,000	1,600	1,300	1,000	
		Feed Rate (IPM)	3.150	3.543	3.937	3.937	3.937	3.543	3.543	

* Cutting with coolant is recommended for stainless steel.

GRADES A
INSERTS B
CBN & PCD C
TURNING E
BORING F
GRINDING G
CUT-OFF H
THREADING J
SOLID END MILLS L
MILLING M
SPARE PARTS P
TECHNICAL R
INDEX T