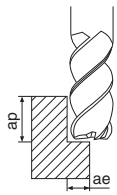
Recommended Cutting Conditions

2FESL (Shouldering)

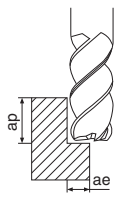
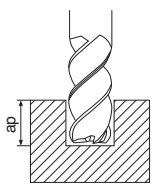
Application	Workpiece Material	Outside Dia. Dc (mm)	ø1	ø2	ø4	ø6	ø8	ø12	ø16
 Shouldering	Carbon Steel SxxC	Spindle Revolution (min^{-1})	19,000	9,500	4,800	3,200	2,400	1,600	1,200
		Feed Rate (mm/min)	210	210	210	210	210	210	210
	Alloy Steel SCM, SNCM	Spindle Revolution (min^{-1})	14,300	7,200	3,600	2,400	2,000	1,300	1,000
		Feed Rate (mm/min)	155	160	160	160	170	170	150
	Pre-hardened steel NAK, 30~45HRC	Spindle Revolution (min^{-1})	11,200	5,600	2,800	1,900	1,600	1,000	800
		Feed Rate (mm/min)	85	85	90	90	100	95	80
	Stainless steel SUS	Spindle Revolution (min^{-1})	14,300	7,200	3,600	2,400	2,000	1,300	1,000
		Feed Rate (mm/min)	95	95	95	95	105	105	80

Depth of Cut (ap×ae) (mm)
2.5Dc×0.05Dc (Dc<ø3) 2.5Dc×0.1Dc (Dc ≧ ø3)

* Cutting with coolant is recommended for stainless steel.

Slotting is not recommended.

2FEKS, 2FEKM

Application	Workpiece Material	Application	Outside Dia. Dc (mm)	ø3	ø4	ø6	ø8	ø10	ø12	ø16
 Shouldering	Carbon Steel SxxC	Shouldering	Spindle Revolution (min^{-1})	9,300	7,000	4,600	3,500	3,000	2,700	2,200
			Feed Rate (mm/min)	450	450	470	470	470	470	440
		Slotting	Spindle Revolution (min^{-1})	7,500	6,000	4,400	3,300	2,700	2,300	1,900
			Feed Rate (mm/min)	240	260	340	340	340	340	320
	Alloy Steel SCM, SNCM	Shouldering	Spindle Revolution (min^{-1})	8,800	6,600	4,400	3,300	2,600	2,200	1,800
			Feed Rate (mm/min)	370	370	380	380	380	380	360
		Slotting	Spindle Revolution (min^{-1})	7,200	5,400	3,600	2,700	2,200	1,800	1,500
			Feed Rate (mm/min)	270	270	270	270	270	270	270
 Slotting	Pre-hardened steel NAK, 30~45HRC	Shouldering	Spindle Revolution (min^{-1})	6,400	4,800	3,200	2,400	1,900	1,600	1,200
			Feed Rate (mm/min)	130	130	130	140	140	140	140
		Slotting	Spindle Revolution (min^{-1})	5,300	4,000	2,600	2,000	1,600	1,300	1,000
			Feed Rate (mm/min)	120	120	120	120	120	120	120
	Stainless steel SUS	Shouldering	Spindle Revolution (min^{-1})	8,000	6,000	4,000	3,000	2,400	2,000	1,500
			Feed Rate (mm/min)	140	140	140	140	140	140	140
		Slotting	Spindle Revolution (min^{-1})	5,300	4,000	2,600	2,000	1,600	1,300	1,000
			Feed Rate (mm/min)	80	90	100	100	100	90	90

Depth of Cut (ap×ae) (mm)
1.2Dc×0.1Dc

Depth of Cut (ap) (mm)
0.5Dc

* Cutting with coolant is recommended for stainless steel.