

Recommended Cutting Conditions

2FESW

Application	Workpiece Material	Application	Outside Dia. Dc (mm)	ø3	ø4	ø5	ø6	ø8	ø10	ø12	ø13
<p>Shouldering</p> <p>Depth of Cut (apxae) (mm)</p> <p>1Dcx0.2Dc</p> <p>Slotting</p> <p>Depth of Cut (ap) (mm)</p> <p>0.2Dc</p>	Carbon Steel SxxC	Shouldering	Spindle Revolution (min ⁻¹)	11,000	8,000	6,400	5,300	4,000	3,200	2,700	2,500
			Feed Rate (mm/min)	660	640	640	640	520	450	410	350
		Slotting	Spindle Revolution (min ⁻¹)	11,000	8,000	6,400	5,300	4,000	3,200	2,700	2,500
			Feed Rate (mm/min)	660	640	640	640	520	450	410	350
	Alloy Steel SCM, SNCM	Shouldering	Spindle Revolution (min ⁻¹)	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (mm/min)	420	430	430	430	350	300	270	230
		Slotting	Spindle Revolution (min ⁻¹)	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (mm/min)	420	430	430	430	350	300	270	230
	Pre-hardened steel NAK, 30~45HRC	Shouldering	Spindle Revolution (min ⁻¹)	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (mm/min)	420	430	430	430	350	300	270	230
		Slotting	Spindle Revolution (min ⁻¹)	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (mm/min)	420	430	430	430	350	300	270	230
Stainless steel SUS	Shouldering	Spindle Revolution (min ⁻¹)	6,400	4,800	3,800	3,200	2,400	1,900	1,600	1,500	
		Feed Rate (mm/min)	320	320	320	320	260	230	210	180	
	Slotting	Spindle Revolution (min ⁻¹)	6,400	4,800	3,800	3,200	2,400	1,900	1,600	1,500	
		Feed Rate (mm/min)	320	320	320	320	260	230	210	180	

* Cutting with coolant is recommended for stainless steel.

3FESW

Application	Workpiece Material	Application	Outside Dia. Dc (mm)	ø3	ø4	ø5	ø6	ø8	ø10	ø12	ø13
<p>Shouldering</p> <p>Depth of Cut (apxae) (mm)</p> <p>1Dcx0.2Dc</p> <p>Slotting</p> <p>Depth of Cut (ap) (mm)</p> <p>0.2Dc</p>	Carbon Steel SxxC	Shouldering	Spindle Revolution (min ⁻¹)	11,000	8,000	6,400	5,300	4,000	3,200	2,700	2,500
			Feed Rate (mm/min)	810	800	800	800	650	560	510	450
		Slotting	Spindle Revolution (min ⁻¹)	11,000	8,000	6,400	5,300	4,000	3,200	2,700	2,500
			Feed Rate (mm/min)	810	800	800	800	650	560	510	450
	Alloy Steel SCM, SNCM	Shouldering	Spindle Revolution (min ⁻¹)	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (mm/min)	530	530	530	530	430	370	340	300
		Slotting	Spindle Revolution (min ⁻¹)	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (mm/min)	530	530	530	530	430	370	340	300
	Pre-hardened steel NAK, 30~45HRC	Shouldering	Spindle Revolution (min ⁻¹)	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (mm/min)	530	530	530	530	430	370	340	300
		Slotting	Spindle Revolution (min ⁻¹)	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (mm/min)	530	530	530	530	430	370	340	300
Stainless steel SUS	Shouldering	Spindle Revolution (min ⁻¹)	6,400	4,800	3,800	3,200	2,400	1,900	1,600	1,500	
		Feed Rate (mm/min)	400	400	400	400	320	280	260	230	
	Slotting	Spindle Revolution (min ⁻¹)	6,400	4,800	3,800	3,200	2,400	1,900	1,600	1,500	
		Feed Rate (mm/min)	400	400	400	400	320	280	260	230	

* Cutting with coolant is recommended for stainless steel.

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Solid End Mill