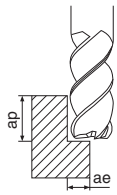
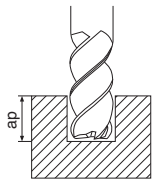
4YEKM, 4YECM, 4YERM

Application	Workpiece Material	Application	Depth of Cut (ap×ae) (mm)	Outside Dia. Dc (mm)	ø4	ø5	ø6	ø8	ø10	ø12	ø16	ø20	ø25
 Shouldering	Carbon steel Alloy steel ~HRC30	Shouldering	1D×0.5D	Spindle Revolution (min^{-1})	8,400	6,700	5,600	4,200	3,300	2,800	2,100	1,700	1,300
				Feed Rate (mm/min)	840	800	890	840	790	720	580	510	390
		Slotting	1D	Spindle Revolution (min^{-1})	8,400	6,700	5,600	4,200	3,300	2,800	2,100	1,700	1,300
				Feed Rate (mm/min)	840	800	890	840	790	720	580	510	390
	Carbon steel Alloy steel 30~40HRC	Shouldering	1D×0.3D	Spindle Revolution (min^{-1})	6,800	5,400	4,500	3,400	2,700	2,300	1,700	1,400	1,100
				Feed Rate (mm/min)	540	540	630	610	540	500	400	360	300
		Slotting	1D	Spindle Revolution (min^{-1})	6,800	5,400	4,500	3,400	2,700	2,300	1,700	1,400	1,100
				Feed Rate (mm/min)	540	540	630	610	540	500	400	360	300
	Stainless steel SUS	Shouldering	1D×0.25D	Spindle Revolution (min^{-1})	6,400	5,100	4,200	3,200	2,600	2,100	1,600	1,300	1,000
				Feed Rate (mm/min)	510	510	580	570	520	460	380	330	280
		Slotting	0.5D	Spindle Revolution (min^{-1})	6,400	5,100	4,200	3,200	2,600	2,100	1,600	1,300	1,000
				Feed Rate (mm/min)	510	510	580	570	520	460	380	330	280
 Slotting	Titanium Alloys	Shouldering	1D×0.25D	Spindle Revolution (min^{-1})	4,000	3,200	2,700	2,000	1,600	1,300	1,000	800	600
				Feed Rate (mm/min)	190	190	210	240	190	200	180	190	160
		Slotting	0.5D	Spindle Revolution (min^{-1})	4,000	3,200	2,700	2,000	1,600	1,300	1,000	800	600
				Feed Rate (mm/min)	190	190	210	240	190	200	180	190	160
	Heat-resistant Alloys	Shouldering	1D×0.25D	Spindle Revolution (min^{-1})	2,400	1,900	1,600	1,200	1,000	800	600	500	400
				Feed Rate (mm/min)	100	80	100	130	100	120	110	110	80
		Slotting	0.3D	Spindle Revolution (min^{-1})	2,400	1,900	1,600	1,200	1,000	800	600	500	400
				Feed Rate (mm/min)	100	80	100	130	100	120	110	110	80

* Cutting with coolant is recommended for stainless steel, titanium alloys and heat-resistant alloys.