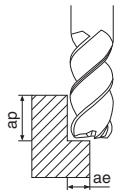
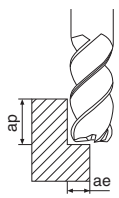
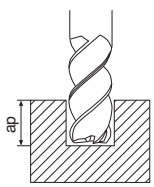
4YFSM, 6YFSM (Shouldering)

Application	Workpiece Material	Depth of Cut (ap×ae) (mm)	Outside Dia. Dc (mm)	ø4	ø5	ø6	ø8	ø10	ø12	ø16	ø20
 Shouldering	Carbon Steel < 20HRC	1.5Dc×0.1Dc	Spindle Revolution (min^{-1})	10,000	8,000	6,600	5,000	4,000	3,300	2,500	2,000
			Feed Rate (mm/min)	800	800	1,340	1,340	1,340	1,350	1,490	1,610
	Alloy Steel < 30HRC		Spindle Revolution (min^{-1})	8,000	6,400	5,300	4,000	3,200	2,700	2,000	1,600
			Feed Rate (mm/min)	570	570	960	960	960	960	1,080	1,150
	Pre-hardened steel 30~45HRC		Spindle Revolution (min^{-1})	6,000	4,800	4,000	3,000	2,400	2,000	1,500	1,200
			Feed Rate (mm/min)	360	360	620	660	660	660	740	790
	Stainless steel SUS		Spindle Revolution (min^{-1})	5,200	4,100	3,500	2,600	2,100	1,700	1,300	1,000
			Feed Rate (mm/min)	270	280	520	540	550	550	620	650
	Titanium Alloys	1Dc×0.05Dc	Spindle Revolution (min^{-1})	3,600	2,900	2,400	1,800	1,400	1,200	900	700
			Feed Rate (mm/min)	160	170	340	360	360	360	410	410
	Heat-resistant Alloys		Spindle Revolution (min^{-1})	3,600	2,900	2,400	1,800	1,400	1,200	900	700
			Feed Rate (mm/min)	160	170	340	360	360	360	410	410

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

Slotting is not recommended.

3RDSM, 4RDSM, 5RDSM

Application	Workpiece Material		Application	Depth of Cut (ap×ae) (mm)	Outside Dia. Dc (mm)	ø6	ø8	ø10	ø12	ø16	ø20	ø25
 Shouldering	Steel	< 22HRC	Shouldering	1.5Dc×0.5Dc	Spindle Revolution (min^{-1})	11,100	8,400	6,700	5,600	4,200	3,300	2,700
					Feed Rate (mm/min)	1,000	1,000	1,320	1,340	1,340	1,340	1,380
			Slotting	1Dc	Spindle Revolution (min^{-1})	9,300	6,900	5,600	4,600	3,500	2,800	2,200
					Feed Rate (mm/min)	800	800	1,000	1,030	1,040	1,050	1,110
		22~32HRC	Shouldering	1.5Dc×0.4Dc	Spindle Revolution (min^{-1})	9,600	7,200	5,700	4,800	3,600	2,900	2,300
					Feed Rate (mm/min)	720	720	860	860	860	920	1,030
			Slotting	0.75Dc	Spindle Revolution (min^{-1})	7,900	5,900	4,800	4,000	3,000	2,400	1,900
					Feed Rate (mm/min)	550	550	740	740	740	760	860
		32~40HRC	Shouldering	1.5Dc×0.4Dc	Spindle Revolution (min^{-1})	6,400	4,800	3,800	3,200	2,400	1,900	1,500
					Feed Rate (mm/min)	320	320	410	410	400	400	400
			Slotting	0.6Dc	Spindle Revolution (min^{-1})	5,300	4,000	3,200	2,600	2,000	1,600	1,300
					Feed Rate (mm/min)	260	260	340	340	330	330	330
		40~45HRC	Shouldering	1Dc×0.4Dc	Spindle Revolution (min^{-1})	4,800	3,600	2,900	2,400	1,800	1,400	1,100
					Feed Rate (mm/min)	220	220	260	260	250	250	250
			Slotting	0.5Dc	Spindle Revolution (min^{-1})	4,300	3,200	2,600	2,200	1,600	1,300	1,000
					Feed Rate (mm/min)	180	180	240	230	230	220	220
 Slotting		45~50HRC	Shouldering	1Dc×0.3Dc	Spindle Revolution (min^{-1})	4,200	3,200	2,500	2,100	1,600	1,300	1,000
					Feed Rate (mm/min)	150	150	180	180	170	170	170
			Slotting	0.4Dc	Spindle Revolution (min^{-1})	3,800	2,900	2,300	1,900	1,400	1,100	900
					Feed Rate (mm/min)	140	140	170	160	160	150	150
	Stainless steel SUS		Shouldering	1.5Dc×0.4Dc	Spindle Revolution (min^{-1})	3,700	2,800	2,200	1,900	1,400	1,100	900
					Feed Rate (mm/min)	190	230	310	300	340	310	360
			Slotting	0.5Dc	Spindle Revolution (min^{-1})	2,700	2,000	1,600	1,300	1,000	800	600
					Feed Rate (mm/min)	110	130	180	170	190	180	190
	Cast Iron		Shouldering	1.5Dc×0.5Dc	Spindle Revolution (min^{-1})	9,600	7,200	5,700	4,800	3,600	2,900	2,300
					Feed Rate (mm/min)	850	850	1,030	1,030	1,030	1,100	1,380
			Slotting	1Dc	Spindle Revolution (min^{-1})	7,900	5,900	4,800	4,000	3,000	2,400	1,900
					Feed Rate (mm/min)	700	700	900	900	900	910	1,140

* Cutting with coolant is recommended for stainless steel.