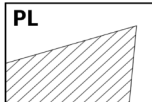
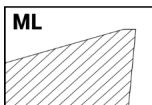
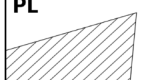
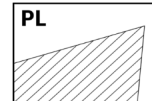
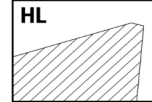
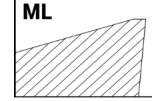
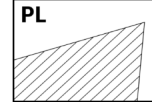


	HSS BLADE	CARBIDE BLADE	HSS or CARBIDE	HSS or CARBIDE		
	Vc cutting speed ⁽¹⁾	Vc cutting speed ⁽¹⁾	Vc cutting speed ⁽¹⁾	fr cutting speed ⁽¹⁾		
ISO	UNCOATED m/min. sfm	COATED m/min. sfm	COATED m/min. sfm	COATED/ UNCOATED m/min. ipr	RECOMMENDED CHIP-FORMER	COOLANT
P	25-45 80-150	45-65 100-165	60-120 200-390	0.08 - 0.20/ 0.003 - 0.008		AIR / WET
	20-45 80-150	35-65 115-165	50-120 165-395	0.08 - 0.20/ 0.003 - 0.008		
	20-40 65-130	35-55 115-180	50-100 165-330			
	15-35 50-115	30-50 100-165	45-90 150-295	0.08 - 0.15/ 0.003 - 0.006		
M	15-30 50-100	30-55 100-180	50-100 165-330	0.08 - 0.15/ 0.003 - 0.006		WET
K	20-35 65-115	35-55 115-180	60-120 200-395	0.08 - 0.25/ 0.003 - 0.012		AIR / WET
	30-70 100-230	40-90 130-295	50-100 165-330	0.08 - 0.20/ 0.005 - 0.008		
N	50-70 165-230	75-120 245-395	100-160 330-525	0.10 - 0.30/ 0.004 - 0.012		WET
	30-60 100-200	45-100 150-330	90-130 295-425			
	60-100 195-330	90-150 295-490	180-305 600-1000			
S	10-15 33-50	15-35 50-115	40-80 130-260	0.10 - 0.20/ 0.005 - 0.008		WET
	NOT RECOMMENDED	10-15 33-50	25-40 80-130			
	10-15 33-50	15-20 50-65	30-60 100-165			
H	NOT RECOMMENDED	10-20 10-20 30-65	30-50 100-165	0.04 - 0.06/ 0.0015 - 0.0024		AIR
		10-15 30-50	30-40 100-130			
		15-20 50-65	45-50 145-165			
		10-20 30-65	30-50 100-165			
C	NOT RECOMMENDED		90-140 295 - 460	0.05 - 0.25 / 0.002 - 0.010	 Recommended with special diamond coating or DLC	AIR/ WET
			90-350 295 - 1150			