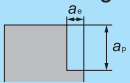
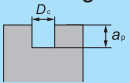
Flute	ϕD_c (mm)	Carbon Steel		Alloy steel		Stainless steel		Side Milling 		Slotting 
		rpm	IPM	rpm	IPM	rpm	IPM	DOC a_p (Inch)	Width of cut a_e (Inch)	DOC a_p (Inch)
2	2	14,300	9.1	11,100	7.1	10,300	5.5	−.079	−.016	−.016
	3	9,500	13.0	7,400	10.2	6,900	8.3	−.118	−.024	−.024
	4	7,200	15.4	5,600	11.8	5,200	9.4	−.157	−.031	−.031
	5	5,700	16.5	4,500	13.0	4,100	10.2	−.197	−.039	−.039
	6	4,800	17.3	3,700	13.4	3,400	10.6	−.236	−.047	−.047
	7	4,100	16.5	3,200	13.0	3,000	10.6	−.236	−.055	−.055
	8	3,600	16.1	2,800	12.6	2,600	9.8	−.236	−.063	−.063
	10	2,900	14.6	2,200	11.0	2,100	9.1	−.236	−.079	−.079
3	3	9,500	15.4	7,400	12.2	6,900	9.8	−.118	−.024	−.024
	4	7,200	18.5	5,600	14.2	5,200	11.4	−.157	−.031	−.031
	5	5,700	19.7	4,500	15.7	4,100	12.2	−.197	−.039	−.039
	6	4,800	20.9	3,700	16.1	3,400	13.0	−.236	−.047	−.047
	7	4,100	20.1	3,200	15.7	3,000	12.6	−.236	−.055	−.055
	8	3,600	19.3	2,800	15.0	2,600	12.2	−.236	−.063	−.063
	10	2,900	17.3	2,200	13.0	2,100	11.0	−.236	−.079	−.079
4	3	9,500	18.1	7,400	14.2	6,900	11.4	−.118	−.024	−.024
	4	7,200	21.3	5,600	16.5	5,200	13.4	−.157	−.031	−.031
	5	5,700	23.2	4,500	18.1	4,100	14.6	−.197	−.039	−.039
	6	4,800	24.4	3,700	18.9	3,400	15.0	−.236	−.047	−.047
	7	4,100	23.2	3,200	18.1	3,000	15.0	−.236	−.055	−.055
	8	3,600	22.4	2,800	17.3	2,600	14.2	−.236	−.063	−.063
	10	2,900	20.1	2,200	15.4	2,100	12.6	−.236	−.079	−.079

※Please adjust speed and table feed by same ratio.