

C-Cutter Mini - CUTTING CONDITIONS

Table A (Standard Models)

Material	Insert Grade	Cutting Speed (SFM)	Feed (IPT)		Coolant
			Chamfering	Face Milling	
Carbon Steel	ACP200 ACP300	330 - 1,155	.002 - .016	.002 - .008	Dry
Pre-hardened Steel <HRC40		198 - 330	.002 - .004	.002 - .004	Wet
Stainless Steel		330 - 825	.003 - .012	.003 - .008	Dry/Wet
Cast Iron		330 - 1,155	.004 - .020	.002 - .010	Dry
Aluminum/Unalloyed Steel	DS20, ACP300	330 - 2,640	.004 - .020	.002 - .012	Dry/Wet

1. The table is just a reference to determine cutting conditions. It should be adjusted according to the condition of the machine tool and workpiece.
2. Wet cutting is recommended to obtain a good surface finish.
3. In case built-up edge occurs cutting aluminum and stainless steel, use soluble oil.

Table B (Bolt Hole & Tap Hole Long Type)

Material	Insert Grade	Cutting Speed (SFM)	Feed (IPT)	Coolant
Carbon Steel	ACP200 ACP300	66 - 330	.001 - .005	Wet
Cast Iron		165 - 528	.002 - .008	Dry
Aluminum/Unalloyed Steel		99 - 330	.001 - .005	Wet

1. The table is just a reference to determine cutting conditions. It should be adjusted according to the condition of the machine tool and workpiece.
2. For stainless and pre-hardened steels, Standard Model, not Long Type, is recommended.