

● SFUMIE 2 Flutes Cutting Condition 切削條件表				
Working material hardness 被切削材硬度	HRC30° ~ 50°		HRC50° ~ 60°	
Diameter D	Rotational speed 轉速	Feeding speed 進給	Rotational speed 轉速	Feeding speed 進給
	RPM 轉/分	mm/min. mm/分	RPM 轉/分	mm/min. mm/分
D0.2	25000	144	22500	130
D0.3	25000	171	22500	154
D0.4	25000	189	22500	170
D0.5	25000	216	22500	194
D0.6	25000	216	22500	194
D0.7	23000	252	20700	227
D0.8	21500	270	19350	134
D0.9	20000	324	18000	292