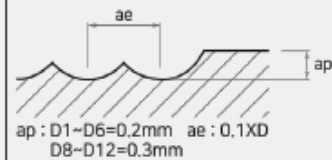
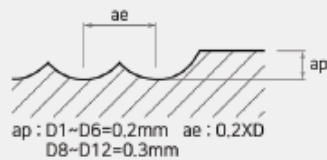


## DB312, DB342 SERIES ▶ General Cutting

Workpiece	NON-Alloy Steels, Alloy Steels, Cast Iron		Alloy Steels, Heat Resistant Steels		Hardened Steels	
Hardness	~ HRC30		HRC30 ~ HRC40		HRC40 ~ HRC55	
Strength	~ 1000N/mm <sup>2</sup>		1000 ~ 1250N/mm <sup>2</sup>		1500N/mm <sup>2</sup>	
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED
1	16,500	290	13,300	230	6,100	105
1.5	16,500	405	12,700	310	5,590	140
2	15,100	865	11,200	565	4,900	175
2.5	15,100	865	11,200	565	4,900	175
3	13,800	780	10,500	530	4,750	175
4	11,000	850	8,800	610	4,410	205
5	9,600	945	7,600	665	3,860	205
6	8,900	1,150	7,200	955	3,340	220
8	7,500	1,500	6,050	1,060	2,590	255
10	6,700	1,750	5,300	1,170	2,140	260
12	6,150	2,000	4,900	1,280	1,840	280
16	5,000	1,950	3,900	1,220	1,420	280
20	4,350	1,900	3,400	1,200	1,170	290

RPM = rev/min  
FEED = mm/min

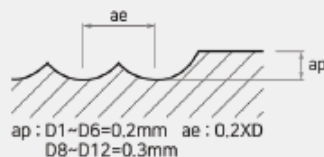


※ Please reduce cutting speed around 20~30% from the above table or DB522 series.

## DB312, DB342 SERIES ▶ High Speed Cutting

Workpiece	NON-Alloy Steels, Alloy Steels, Cast Iron		Alloy Steels, Heat Resistant Steels	
Hardness	~ HRC45		HRC30 ~ HRC40	
Strength	~ 1000N/mm <sup>2</sup>		1500 ~ 2000N/mm <sup>2</sup>	
Diameter (mm)	RPM	FEED	RPM	FEED
1	26,000	1,500	26,000	920
1.5	24,000	1,600	24,000	990
2	22,000	1,700	22,000	1,080
2.5	22,000	2,000	20,000	1,130
3	22,000	2,300	17,800	1,200
4	22,000	3,350	14,300	1,300
5	22,000	4,150	12,600	1,380
6	22,000	4,600	11,000	1,440
8	17,500	4,600	8,800	1,440
10	14,700	4,450	7,350	1,380
12	12,800	4,450	6,400	1,330
16	10,000	4,000	5,000	1,150
20	8,350	3,650	4,150	1,060

RPM = rev/min  
FEED = mm/min



※ Please reduce cutting speed around 20~30% from the above table or DB522 series.