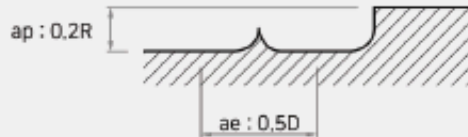


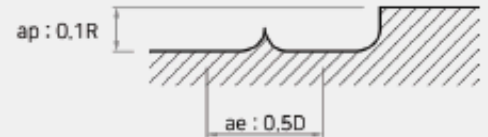
## ESPM4 SERIES ▶ Side Cutting

Workpiece	Hardened Steels									
Hardness	~HRc40		HRc40 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc60		HRc60 ~ HRc65	
D X R (mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3 X R0.5	9,550	6,500	6,900	4,150	4,550	2,750	2,850	1,150	1,900	610
4 X R0.5	7,950	7,000	5,750	4,600	4,000	3,200	2,550	1,350	1,750	700
6 X R0.5	5,800	7,650	4,100	4,900	2,900	3,500	1,850	1,850	1,350	795
6 X R1.0	5,800	7,650	4,100	4,900	2,900	3,500	1,850	1,850	1,350	795
8 X R1.0	4,350	7,650	3,050	4,900	2,200	3,500	1,400	1,850	995	795
8 X R2.0	4,350	7,650	3,050	4,900	2,200	3,500	1,400	1,850	995	795
10 X R1.0	3,500	7,650	2,450	4,900	1,750	3,500	1,100	1,850	795	795
10 X R2.0	3,500	7,650	2,450	4,900	1,750	3,500	1,100	1,850	795	795
12 X R2.0	2,900	7,650	2,050	4,900	1,450	3,500	925	1,850	665	795
12 X R3.0	2,900	7,650	2,050	4,900	1,450	3,500	925	1,850	665	795

RPM = rev/min  
FEED = mm/min



\* $a_e$  shouldn't be over max. 0.5D

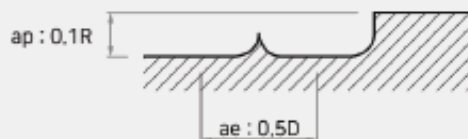


\* $a_e$  shouldn't be over max. 0.5D

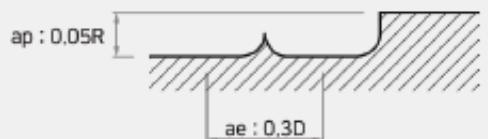
## ESPM4 SERIES ▶ High Speed Cutting

Workpiece	Hardened Steels									
Hardness	~HRc40		HRc40 ~ HRc50		HRc50 ~ HRc55		HRc55 ~ HRc60		HRc60 ~ HRc65	
D X R (mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3 X R0.5	22,000	16,000	17,000	10,000	12,500	8,000	9,500	4,600	6,900	2,500
4 X R0.5	17,000	17,500	13,000	12,000	11,000	9,200	8,000	5,500	5,600	2,900
6 X R0.5	13,500	18,500	10,500	13,800	9,000	11,000	6,400	6,400	4,500	3,600
6 X R1.0	13,500	18,500	10,500	13,800	9,000	11,000	6,400	6,400	4,500	3,600
8 X R1.0	10,000	18,500	8,000	14,000	6,800	11,000	4,800	6,700	3,400	4,100
8 X R2.0	10,000	18,500	8,000	14,000	6,800	11,000	4,800	6,700	3,400	4,100
10 X R1.0	8,000	18,500	6,400	14,000	5,400	11,000	3,800	6,800	2,700	3,800
10 X R2.0	8,000	18,500	6,400	14,000	5,400	11,000	3,800	6,800	2,700	3,800
12 X R2.0	6,600	18,500	5,300	14,000	4,500	11,000	3,200	7,000	2,250	3,600
12 X R3.0	6,600	18,500	5,300	14,000	4,500	11,000	3,200	7,000	2,250	3,600

RPM = rev/min  
FEED = mm/min



\* $a_e$  shouldn't be over max. 0.5D



\* $a_e$  shouldn't be over max. 0.3D