

# OFKR & OFKT

| Workpiece | Cutting Condition |             | Grades |
|-----------|-------------------|-------------|--------|
|           | vc(m/min)         | fz(mm/t)    |        |
| P         | 190 ~ 320         | 0.05 ~ 0.20 | NCM325 |
|           | 161 ~ 270         | 0.05 ~ 0.20 | PC3500 |
|           | 80 ~ 140          | 0.05 ~ 0.20 | ST30A  |
| M         | 90 ~ 150          | 0.05 ~ 0.20 | PC9530 |
| K         | 140 ~ 230         | 0.05 ~ 0.30 | PC6510 |
|           | 50 ~ 90           | 0.05 ~ 0.30 | G10    |