

ATL Cutting Guidelines

Material	Milling	Rough Turning	Finish Turning	Threading	Cut off	Drill
545C		160~180	180~220	120	100	25
SCM		130~150	200	100	100	25
FC		100~130	180	100	80	25
Copper		220~225	220~250	130	13	30
Aluminum		300	300	150	150	60
SUS		70~80	90~100	60	50	15

$$\text{surface speed} = \frac{(3.14) \pi \times (\text{Diameter}) D \times (\text{RPM}) N}{1000} \text{ ----- G96S}$$

$$(\text{RPM}) N = \frac{\text{surface speed} \times 10000}{(3.14) \pi (\text{Diameter}) D} \text{ ----- G97S}$$

$$\text{Maximum speed RPM} \text{ ----- G50S}$$