

## Recommended cutting data

### HN60VS4

Workpiece material	STAINLESS 304		Moderately Difficults SUS		STAINLESS 316L		TITANIUM(ALLOYS)		SOFT STEEL		SG CAST IRON		High Temperature ALLOYS	
Vc	72-90m/min		56-70m/min		48-60m/min		40-56m/min		120-160m/min		96-120m/min		20-25m/min	
Diameter, mm	Rotating RPM	Feed mm/min	Rotating RPM	Feed mm/min	Rotating RPM	Feed mm/min	Rotating RPM	Feed mm/min	Rotating RPM	Feed mm/min	Rotating RPM	Feed mm/min	Rotating RPM	Feed mm/min
1	10000	170	15380	120	13800	72	13600	60	10000	170	9500	200	8600	50
2	7500	266	8570	170	7960	95	7920	85	7500	266	6860	320	5600	45
3	7000	455	5769	240	5357	132	4860	120	7000	455	6550	545	3100	45
4	5732	458	4459	286	3822	183	3185	122	9554	764	7643	611	1592	56
5	4586	440	3567	286	3057	245	2548	122	7643	734	6115	587	1274	45
6	3822	489	2972	333	2548	245	2123	136	6369	518	5096	652	1062	58
8	2866	458	2229	321	1911	245	1592	153	4777	917	3822	734	796	69
10	2293	440	1783	286	1529	220	1274	124	3822	734	3057	587	637	55
12	1911	398	1486	262	1274	204	1062	136	3185	714	2548	570	531	65
14	1638	351	1274	232	1092	185	910	126	2730	637	2184	510	455	65
16	1433	321	1115	214	955	168	796	114	2389	574	1911	458	398	62

1. Please select high piecise machine and tool holder.
2. Please use air blow or cutting liquid with high mist retardant property.
3. Vibration and unusual noise may be generated if the machine rigidity and workpiece fixture stability is low, Please reduce the rotating speed and feed rate like mentioned above
4. Make overhang as short as possible if no interference.