

PARAMETER SHEET

QT - 15N / 18N

T - 32 - 2

(B Version)

PAGE	PARAMETER NAME
1 ✓	P1-P32. U1-U96. K1-K48. D1-D16.
2 ✓	E1-E64. I1-I72.
3 ✓	A1-A16.
4 Na	B1-B80. C1-C80 (8D-8P).
5 ✓	B1-B80. C1-C80 (12D).
6 Na	B1-B80. C1-C80 (8D-16P)
7 ✓	S1-S32.
8 ✓	S33-S64.
9 ✓	SP1-SP32. T1-T64.
10 ✓	R1-R80. O1-O80.
11 ✓	CUTTING CONDITION

SIGNED : S. BARNES.
 N/C : M/3134430122
 S/N : 107435

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13.3.93

PAGE	REV.
1	1

P1	11011011	P17	1	U1	5000	U17	0	U33	1000	U49	50
P2	00000001	P18	0	U2	20000	U18	1000	U34	1000	U50	1000
P3	00000001	P19	0	U3	2000	U19	100	U35	30000	U51	0
P4	00000000	P20	1	U4	2000	U20	0	U36	500	U52	0
P5	00000000	P21	0	U5	2000	U21	30	U37	0	U53	0
P6	00000000	P22	10	U6	2000	U22	2000	U38	60	U54	0
P7	00000010	P23	8	U7	2000	U23	30	U39	50	U55	0
P8	00000000	P24	3	U8	2000	U24	2000	U40	0	U56	0

P9	00000100	P25	0	U9	1000	U25	2000	U41	100	U57	25
P10	00000100	P26	0	U10	0	U26	100	U42	500	U58	50
P11	10000110	P27	61	U11	1000	U27	1000	U43	1000	U59	1000
P12	00001010	P28	37	U12	0	U28	2000	U44	3000	U60	1000
P13	00001000	P29	0	U13	0	U29	0	U45	200	U61	100
P14	00000000	P30	60	U14	0	U30	0	U46	3000	U62	0
P15	00000000	P31	0	U15	0	U31	0	U47	0	U63	0
P16	00000000	P32	0	U16	0	U32	0	U48	0	U64	0

- USER PARAMETER No.1 -

CODE NUM

U65	0	U81	0	K1	100	K17	100	K33	2000	D1	0	0
U66	0	U82	0	K2	120	K18	200	K34	500	D2	0	0
U67	0	U83	0	K3	140	K19	5	K35	1000	D3	0	0
U68	0	U84	0	K4	50	K20	10	K36	200	D4	0	0
U69	0	U85	0	K5	50	K21	10	K37	2000	D5	0	0
U70	0	U86	0	K6	200	K22	50	K38	200	D6	0	0
U71	0	U87	0	K7	20	K23	100	K39	1000	D7	0	0
U72	0	U88	0	K8	15	K24	6495	K40	100	D8	0	0

CODE NUM

U73	0	U89	0	K9	0	K25	6495	K41	0	D9	0	0
U74	0	U90	0	K10	20	K26	6403	K42	0	D10	0	0
U75	0	U91	0	K11	50	K27	6403	K43	0	D11	0	0
U76	0	U92	0	K12	70	K28	0	K44	0	D12	0	0
U77	0	U93	0	K13	100	K29	100	K45	0	D13	0	0
U78	0	U94	0	K14	0	K30	500	K46	0	D14	0	0
U79	0	U95	0	K15	0	K31	150	K47	0	D15	0	0
U80	0	U96	0	K16	0	K32	100	K48	0	D16	0	0

- USER PARAMETER No.2 -

QT-15N (mm)

PARAMETER

PAGE	REV.
2	1

E1	0	E17	0	E33	0	E43	00000000
E2	0	E18	0	E34	0	E50	00000000
E3	0	E19	0	E35	0	E51	00000000
E4	0	E20	0	E36	0	E52	00000000
E5	0	E21	0	E37	0	E53	00000000
E6	0	E22	0	E38	0	E54	00000000
E7	0	E23	0	E39	0	E55	00000000
E8	0	E24	0	E40	0	E56	00000000
E9	0	E25	0	E41	0	E57	00000000
E10	0	E26	0	E42	0	E58	00000000
E11	0	E27	0	E43	0	E59	00000000
E12	0	E28	0	E44	0	E60	00000000
E13	0	E29	0	E45	0	E61	00000000
E14	0	E30	0	E46	0	E62	00000000
E15	0	E31	0	E47	0	E63	00000000
E16	0	E32	0	E48	0	E64	00000000

- USER PARAMETER No.3 -

	<DV1>	<DV3>	<DV5>	<DV7>								
I1	2	2	0	0	I9	0	I25	16	I41	3	I57	00000000
I2	0	3	0	0	I10	1	I26	16	I42	66	I58	00000000
I3	0	0	0	0	I11	0	I27	1	I43	0	I59	00000000
I4	0	0	0	0	I12	0	I28	30	I44	0	I60	00000100
I5	0	3	0	0	I13	0	I29	16	I45	0	I61	00000000
I6	0	1	0	0	I14	10	I30	30	I46	0	I62	00000000
I7	0	0	0	0	I15	30	I31	10	I47	0	I63	00000000
I8	0	20	0	0	I16	5	I32	10	I48	0	I64	00000000

	<DV2>	<DV4>	<DV6>	<DV8>								
I1	2	2	0	0	I17	76	I33	3	I43	0	I65	00000010
I2	3	3	0	0	I18	13	I34	250	I50	0	I66	00000010
I3	0	0	0	0	I19	109	I35	0	I51	0	I67	00000010
I4	0	0	0	0	I20	122	I36	0	I52	0	I68	00000001
I5	3	3	0	0	I21	91	I37	10	I53	0	I69	00000000
I6	3	0	0	0	I22	70	I38	10	I54	0	I70	00000000
I7	1	0	0	0	I23	0	I39	0	I55	0	I71	11111111
I8	5	0	0	0	I24	0	I40	0	I56	0	I72	00000000

- USER PARAMETER No.4 -

QT-15N (mm)

PAGE	REV.
3	1

	X-1	Z-1	C-1	4-2	5-1
A1	30000	30000	0	0	0
A2	0	0	0	0	0
A3	5000	5000	0	0	0
A4	0	0	0	0	0
A5	0	0	0	0	0
A6	0	-150000	0	0	0
A7	0	0	0	0	0
A8	0	-387000 (-377000)	0	0	0

	X-1	Z-1	C-1	4-1	5-1
A9	10000	10000	0	0	0
A10	<i>-430000 *</i>	-500000	0	0	0
A11	0	0	0	0	0
A12	5000	5000	0	0	0
A13	0	0	0	0	0
A14	0	0	0	0	0
A15	0	0	0	0	0
A16	0	0	0	0	0

- MACHINE PARAMETER No.1 -

	X-2	Z-2	C-2	4-2	5-2
A1	0	0	0	0	0
A2	0	0	0	0	0
A3	0	0	0	0	0
A4	0	0	0	0	0
A5	0	0	0	0	0
A6	0	0	0	0	0
A7	0	0	0	0	0
A8	0	0	0	0	0

	X-2	Z-2	C-2	4-2	5-2
A9	0	0	0	0	0
A10	0	0	0	0	0
A11	0	0	0	0	0
A12	0	0	0	0	0
A13	0	0	0	0	0
A14	0	0	0	0	0
A15	0	0	0	0	0
A16	0	0	0	0	0

- MACHINE PARAMETER No.2 -

*

- 350000	8D
- 430000	12D
- 350000	8D - 16P

QT-15N (mm)
() : B210 CHUCK

<8D-8P>

PAGE	REV.
4	1

B1	1	B17	0	B33	210000 (254000)	B49	-260000	B65	0
B2	8	B18	0	B34	143000 (153000)	B50	15000	B66	0
B3	0	B19	0	B35	52000 (75000)	B51	100000	B67	0
B4	0	B20	0	B36	0	B52	-260000	B68	0
B5	0	B21	0	B37	110000	B53	95000	B69	0
B6	0	B22	0	B38	400000	B54	100000	B70	0
B7	0	B23	0	B39	80000	B55	-260000	B71	0
B8	0	B24	0	B40	15000	B56	58000	B72	0
B9	0	B25	0	B41	64000	B57	100000	B73	500000
B10	0	B26	0	B42	109300	B58	0	B74	500000
B11	8	B27	0	B43	60000	B59	0	B75	0
B12	0	B28	0	B44	8000	B60	0	B76	0
B13	0	B29	0	B45	130000	B61		B77	0
B14	0	B30	0	B46	360000	B62		B78	0
B15	0	B31	0	B47	660000	B63		B79	0
B16	0	B32	0	B48	630000	B64		B80	0

- MACHINE PARAMETER No.3 -

C1	0	C17	0	C33	0	C49	0	C65	0
C2	0	C18	0	C34	0	C50	0	C66	0
C3	0	C19	0	C35	0	C51	0	C67	0
C4	0	C20	0	C36	0	C52	0	C68	0
C5	0	C21	0	C37	0	C53	0	C69	0
C6	0	C22	0	C38	0	C54	0	C70	0
C7	0	C23	0	C39	0	C55	0	C71	0
C8	0	C24	0	C40	0	C56	0	C72	0
C9	0	C25	0	C41	0	C57	0	C73	0
C10	0	C26	0	C42	0	C58	0	C74	0
C11	0	C27	0	C43	0	C59	0	C75	0
C12	0	C28	0	C44	0	C60	0	C76	0
C13	0	C29	0	C45	0	C61	0	C77	0
C14	0	C30	0	C46	0	C62	0	C78	0
C15	0	C31	0	C47	0	C63	0	C79	0
C16	0	C32	0	C48	0	C64	0	C80	0

- MACHINE PARAMETER No.4 -

<8D - 8P>
QT-15N (mm)

() : B210 CHUCK

<12D>

PAGE	REV.
5	1

B1	1	B17	0	B33	210000 (254000)	B49	-260000	B65	0
B2	12	B18	0	B34	103000 <i>40600</i>	B50	55000	B66	0
B3	0	B19	0	B35	52000 (75000)	B51	100000	B67	0
B4	0	B20	0	B36	0	B52	-260000	B68	0
B5	0	B21	0	B37	110000	B53	64000	B69	0
B6	0	B22	0	B38	400000	B54	100000	B70	0
B7	0	B23	0	B39	80000	B55	-260000	B71	0
B8	0	B24	0	B40	15000	B56	90000	B72	0
B9	0	B25	0	B41	64000	B57	100000	B73	500000
B10	0	B26	0	B42	109300	B58	0	B74	500000
B11	12	B27	0	B43	60000	B59	0	B75	0
B12	0	B28	0	B44	8000	B60	0	B76	0
B13	0	B29	0	B45	130000	B61	<i>31695</i>	B77	0
B14	0	B30	0	B46	360000	B62	<i>39651</i>	B78	0
B15	0	B31	0	B47	660000	B63	<i>130471</i>	B79	0
B16	0	B32	0	B48	<i>590000</i>	B64	<i>-283220</i>	B80	0

- MACHINE PARAMETER No.3 -

C1	0	C17	0	C33	0	C49	0	C65	0
C2	0	C18	0	C34	0	C50	0	C66	0
C3	0	C19	0	C35	0	C51	0	C67	0
C4	0	C20	0	C36	0	C52	0	C68	0
C5	0	C21	0	C37	0	C53	0	C69	0
C6	0	C22	0	C38	0	C54	0	C70	0
C7	0	C23	0	C39	0	C55	0	C71	0
C8	0	C24	0	C40	0	C56	0	C72	0
C9	0	C25	0	C41	0	C57	0	C73	0
C10	0	C26	0	C42	0	C58	0	C74	0
C11	0	C27	0	C43	0	C59	0	C75	0
C12	0	C28	0	C44	0	C60	0	C76	0
C13	0	C29	0	C45	0	C61	0	C77	0
C14	0	C30	0	C46	0	C62	0	C78	0
C15	0	C31	0	C47	0	C63	0	C79	0
C16	0	C32	0	C48	0	C64	0	C80	0

- MACHINE PARAMETER No.4 -

 <12D>
 QT-15N (mm)

() : B210 CHUCK

<8D-16P>

PAGE	REV.
6	1

B1	1	B17	0	B33	210000 (254000)	B49	-260000	B65	0
B2	16	B18	0	B34	143000 (153000)	B50	35000	B66	0
B3	0	B19	0	B35	52000 (75000)	B51	125000	B67	0
B4	0	B20	0	B36	0	B52	-260000	B68	0
B5	0	B21	0	B37	110000	B53	96000	B69	0
B6	0	B22	0	B38	400000	B54	95000	B70	0
B7	0	B23	0	B39	80000	B55	-260000	B71	0
B8	0	B24	0	B40	15000	B56	58000	B72	0
B9	0	B25	0	B41	64000	B57	120000	B73	500000
B10	0	B26	0	B42	109300	B58	0	B74	500000
B11	16	B27	0	B43	60000	B59	0	B75	0
B12	0	B28	0	B44	8000	B60	0	B76	0
B13	0	B29	0	B45	130000	B61		B77	0
B14	0	B30	0	B46	340000	B62		B78	0
B15	0	B31	0	B47	660000	B63		B79	0
B16	0	B32	0	B48	630000	B64		B80	0

- MACHINE PARAMETER No.3 -

C1	0	C17	0	C33	0	C49	0	C65	0
C2	0	C18	0	C34	0	C50	0	C66	0
C3	0	C19	0	C35	0	C51	0	C67	0
C4	0	C20	0	C36	0	C52	0	C68	0
C5	0	C21	0	C37	0	C53	0	C69	0
C6	0	C22	0	C38	0	C54	0	C70	0
C7	0	C23	0	C39	0	C55	0	C71	0
C8	0	C24	0	C40	0	C56	0	C72	0
C9	0	C25	0	C41	0	C57	0	C73	0
C10	0	C26	0	C42	0	C58	0	C74	0
C11	0	C27	0	C43	0	C59	0	C75	0
C12	0	C28	0	C44	0	C60	0	C76	0
C13	0	C29	0	C45	0	C61	0	C77	0
C14	0	C30	0	C46	0	C62	0	C78	0
C15	0	C31	0	C47	0	C63	0	C79	0
C16	0	C32	0	C48	0	C64	0	C80	0

- MACHINE PARAMETER No.4 -

<8D - 16P>
QT-15N (mm)

() : B210 CHUCK

PAGE	REV.
7	1

	X-1	Z-1	C-1	4-1	5-1	X-2	Z-2	C-2	4-2	5-2
S1	&A020	&8000	&0000	&0000	&0000	&0000	&0000	&0000	&0000	&0000
S2	&0021	&0021	&0000	&0000	&0000	&0000	&0000	&0000	&0000	&0000
S3	80	90	0	0	0	0	0	0	0	0
S4	10	10	0	0	0	0	0	0	0	0
S5	80	90	0	0	0	0	0	0	0	0
S6	0	0	0	0	0	0	0	0	0	0
S7	10	10	0	0	0	0	0	0	0	0
S8	1	1	0	0	0	0	0	0	0	0

	X-1	Z-1	C-1	4-1	5-1	X-2	Z-2	C-2	4-2	5-2
S9	80	90	0	0	0	0	0	0	0	0
S10	100	100	0	0	0	0	0	0	0	0
S11	0	0	0	0	0	0	0	0	0	0
S12	10	20	0	0	0	0	0	0	0	0
S13	(2093) (79)		0	0	0	0	0	0	0	0
S14	(8) (10)		0	0	0	0	0	0	0	0
S15	(8) (10)		0	0	0	0	0	0	0	0
S16	10	10	0	0	0	0	0	0	0	0

- MACHINE PARAMETER No.5 -

	X-1	Z-1	C-1	4-1	5-1	X-2	Z-2	C-2	4-2	5-2
S17	1	1	0	0	0	0	0	0	0	0
S18	1	1	0	0	0	0	0	0	0	0
S19	132	132	0	0	0	0	0	0	0	0
S20	0	0	0	0	0	0	0	0	0	0
S21	160	200 (180)	0	0	0	0	0	0	0	0
S22	0	0	0	0	0	0	0	0	0	0
S23	10000	10000	0	0	0	0	0	0	0	0
S24	1024	1364	0	0	0	0	0	0	0	0

	X-1	Z-1	C-1	4-1	5-1	X-2	Z-2	C-2	4-2	5-2
S25	2048	1024	0	0	0	0	0	0	0	0
S26	2048	2048	0	0	0	0	0	0	0	0
S27	256	256	0	0	0	0	0	0	0	0
S28	512	512	0	0	0	0	0	0	0	0
S29	1364	1364	0	0	0	0	0	0	0	0
S30	-1364	-1364	0	0	0	0	0	0	0	0
S31	0	0	0	0	0	0	0	0	0	0
S32	0	0	0	0	0	0	0	0	0	0

- MACHINE PARAMETER No.6 -

QT-15N (mm)

PAGE	REV.
8	1

	X-1	Z-1	C-1	4-1	5-1	X-2	Z-2	C-2	4-2	5-2
S33	&0800 (&0820)	&0000 (&0820)	&0000	&0000	&0000	&0000	&0000	&0000	&0000	&0000
S34	10	12	0	0	0	0	0	0	0	0
S35	20	20	0	0	0	0	0	0	0	0
S36	4680	4680	0	0	0	0	0	0	0	0
S37	600	600	0	0	0	0	0	0	0	0
S38	150	150	0	0	0	0	0	0	0	0
S39	31000	31000	0	0	0	0	0	0	0	0
S40	100	100	0	0	0	0	0	0	0	0

	X-1	Z-1	C-1	4-1	5-1	X-2	Z-2	C-2	4-2	5-2
S41	&1181	&1182	&0000	&0000	&0000	&0000	&0000	&0000	&0000	&0000
S42	31000	31000	0	0	0	0	0	0	0	0
S43	&0000	&0000	&0000	&0000	&0000	&0000	&0000	&0000	&0000	&0000
S44	0	0	0	0	0	0	0	0	0	0
S45	0	0	0	0	0	0	0	0	0	0
S46	0	0	0	0	0	0	0	0	0	0
S47	0	0	0	0	0	0	0	0	0	0
S48	0	0	0	0	0	0	0	0	0	0

- MACHINE PARAMETER No.7 -

	X-1	Z-1	C-1	4-1	5-1	X-2	Z-2	C-2	4-2	5-2
S49	&0000	&0000	&0000	&0000	&0000	&0000	&0000	&0000	&0000	&0000
S50	0	0	0	0	0	0	0	0	0	0
S51	0	0	0	0	0	0	0	0	0	0
S52	0	0	0	0	0	0	0	0	0	0
S53	0	0	0	0	0	0	0	0	0	0
S54	0	0	0	0	0	0	0	0	0	0
S55	0	0	0	0	0	0	0	0	0	0
S56	0	0	0	0	0	0	0	0	0	0

	X-1	Z-1	C-1	4-1	5-1	X-2	Z-2	C-2	4-2	5-2
S57	0	0	0	0	0	0	0	0	0	0
S58	0	0	0	0	0	0	0	0	0	0
S59	0	0	0	0	0	0	0	0	0	0
S60	0	0	0	0	0	0	0	0	0	0
S61	0	0	0	0	0	0	0	0	0	0
S62	0	0	0	0	0	0	0	0	0	0
S63	0	0	0	0	0	0	0	0	0	0
S64	0	0	0	0	0	0	0	0	0	0

- MACHINE PARAMETER No.8 -

QT-15N (mm)

PAGE	REV.
9	1

	SPDL-1	M-SP1	SPDL-2	M-SP2		SPDL-1	M-SP1	SPDL-2	M-SP2
SP1	200	0	0	0	SP17	(5170)	0	0	0
SP2	40	0	0	0	SP18	25	0	0	0
SP3	40	0	0	0	SP19	300	0	0	0
SP4	14	0	0	0	SP20	10	0	0	0
SP5	150	0	0	0	SP21	10	0	0	0
SP6	35	0	0	0	SP22	63	0	0	0
SP7	2048	0	0	0	SP23	60	0	0	0
SP8	0	0	0	0	SP24	&0000	&0000	&0000	&0000

	SPDL-1	M-SP1	SPDL-2	M-SP2		SPDL-1	M-SP1	SPDL-2	M-SP2
SP9	0	0	0	0	SP25	(5170)	0	0	
SP10	0	0	0	0	SP26	6000	0	0	0
SP11	&0000	&0000	&0000	&0000	SP27	6000	0	0	0
SP12	(4200) 0	0	0	0	SP28	6000	0	0	0
SP13	0	0	0	0	SP29	(4500)	0	0	0
SP14	1	0	0	0	SP30	4500	0	0	0
SP15	&6900	&0000	&0000	&0000	SP31	4500	0	0	0
SP16	&0001	&0000	&0000	&0000	SP32	4500	0	0	0

- MACHINE PARAMETER No.9 -

T1	15	T17	10	T33	0	T49	0
T2	200	T18	5	T34	0	T50	0
T3	100	T19	30	T35	0	T51	100
T4	0	T20	0	T36	0	T52	100
T5	50	T21	30	T37	0	T53	0
T6	20	T22	10	T38	0	T54	0
T7	80	T23	6	T39	0	T55	0
T8	4	T24	10	T40	0	T56	0
T9	0	T25	10	T41	0	T57	0
T10	0	T26	0	T42	0	T58	0
T11	0	T27	4800	T43	0	T59	0
T12	0	T28	30	T44	0	T60	0
T13	0	T29	30	T45	0	T61	0
T14	50	T30	30	T46	0	T62	0
T15	50	T31	30	T47	5	T63	0
T16	0	T32	30	T48	0	T64	0

- MACHINE PARAMETER No.10 -

QT-15N (mm)

() : B210 CHUCK

PAGE	REV.
10	1

R1	45	R17	0	R33	0	R49	00000101	R65	00000000
R2	0	R18	0	R34	0	R50	00001001	R66	00000000
R3	45	R19	0	R35	0	R51	00000000	R67	00000000
R4	0	R20	0	R36	0	R52	00000000	R68	00000000
R5	5	R21	0	R37	0	R53	00000000	R69	00000000
R6	15	R22	0	R38	0	R54	00000001	R70	00000000
R7	0	R23	0	R39	0	R55	00010000	R71	00000000
R8	0	R24	0	R40	0	R56	00000000	R72	00000000

R9	0	R25	0	R41	0	R57	00000000	R73	00000000
R10	0	R26	0	R42	0	R58	00000001	R74	00000000
R11	0	R27	0	R43	0	R59	10010001	R75	00000000
R12	0	R28	0	R44	0	R60	01010000	R76	00000000
R13	0	R29	0	R45	0	R61	00001000	R77	00000000
R14	0	R30	45	R46	0	R62	00000000	R78	00000000
R15	0	R31	0	R47	0	R63	00000100	R79	00000000
R16	0	R32	0	R48	0	R64	00000000	R80	00000000

- MACHINE PARAMETER No.11 -

O1	00101010	O17	10000000	O33	0	O49	88 <X>	O65	0 < >
O2	01000110	O18	00110010	O34	0	O50	90 <Z>	O66	0 < >
O3	00110100	O19	01000000	O35	1	O51	0 < >	O67	0 < >
O4	10101110	O20	00000000	O36	0	O52	0 < >	O68	0 < >
O5	00000111	O21	00000000	O37	0	O53	0 < >	O69	0 < >
O6	00001100	O22	00000000	O38	4	O54	0 < >	O70	0 < >
O7	00000111	O23	00000000	O39	4	O55	0 < >	O71	0 < >
O8	11001111	O24	00000000	O40	1	O56	0 < >	O72	0 < >
O9	00001010	O25	00000000	O41	16	O57	0 < >	O73	0 < >
O10	00000000	O26	00000000	O42	2	O58	0 < >	O74	0 < >
O11	00000000	O27	00000000	O43	0	O59	0 < >	O75	0 < >
O12	00000000	O28	00000000	O44	1	O60	0 < >	O76	0 < >
O13	00100000	O29	00000000	O45	20	O61	0 < >	O77	0 < >
O14	00000000	O30	00000000	O46	0	O62	0 < >	O78	0 < >
O15	00000101	O31	00000000	O47	0	O63	0 < >	O79	0 < >
O16	00000001	O32	00000000	O48	0	O64	0 < >	O80	0 < >

- MACHINE PARAMETER SYSTEM -

QT-15N (mm)

PAGE	REV.
11	1

MODE	R-SPD	F-SPD	R-FEED	R-DEPTH	MODE	R-SPD	F-SPD	R-FEED	R-DEPTH
BAR OUT	150	280	0.4	4.5	THR OUT	*	180	*	*
IN	130	200	0.35	3.5	IN	*	150	*	*
FCE	150	250	0.35	4.0	FCE	*	130	*	*
BAK	150	250	0.3	3.0	BAK	*	130	*	*
CPY OUT	150	280	0.4	4.5	GRV OUT	120	150	0.1	2
IN	120	200	0.35	3.5	IN	90	110	0.08	2
FCE	130	250	0.35	4.0	FCE	100	120	0.08	2
BAK	130	250	0.3	3.0	BAK	90	110	0.08	2
CNR OUT	150	280	0.4	4.5	DPL FCE	30	*	0.25	*
IN	120	200	0.35	3.5	BAK	*	*	*	*
FCE	130	250	0.35	4.0	TAP FCE	*	8	*	*
BAK	130	250	0.3	3.0	BAK	*	*	*	*
EDG FCE	130	250	0.35	4.0					
BAK	*	*	*	*					

No.	MATL	R-SPD%	F-SPD%	R-FEED%	R-DEP%
1	S45C	100	100	100	100
2	SCM	90	90	100	100
3	FC	80	80	100	100
4	AL	250	250	100	100
5	SUS	70	70	100	100
6		0	0	0	0
7		0	0	0	0
8		0	0	0	0
9		0	0	0	0
10		0	0	0	0
11		0	0	0	0
12		0	0	0	0
13		0	0	0	0
14		0	0	0	0
15		0	0	0	0
16		0	0	0	0

- CUTTING CONDITION (MATERIAL) -

QT-15N (mm)

CUTTING1