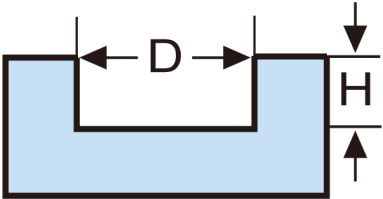
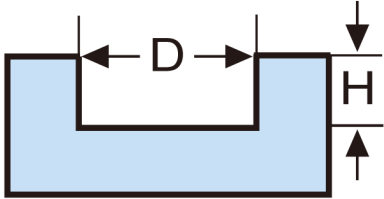


Work Material	Carbon Steels.Alloy Steels S45C, FC, FCD, SCM, S50C, SKS...		Alloy Steels.Tool Steels SCr, SNCM, SKD11, SKD61, NAK80...		Hardened Steels SKD11	
Hardness	~HRC30		~HRC50		~HRC60	
Diameter	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
3	7600	180	4800	120	2900	50
4	6500	260	4000	160	2500	55
5	5500	270	3200	160	2000	60
6	4800	300	2900	170	1800	70
8	3700	325	2200	170	1500	85
10	2900	280	1700	140	1100	70
12	2400	230	1400	120	1000	65
16	1800	170	1100	90	700	45
Depth of Cut	 $H \leq 0.3D$ HRC45 ↓					
	 $H \leq 0.15D$ HRC45 ↑					