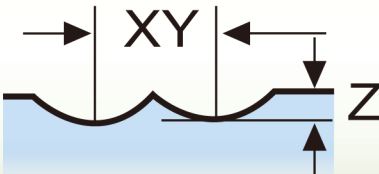


Work Material	Carbon Steels S45C.S50C HB150-250		Alloy Steels SCM.P20.PDS5.PDS3.SKD11 HRC20-35		Prehardened Steels NAK80 HRC35-45		Hardened Steels SKD61 HBC45-55	
Velocity	V=100m/min		V=80m/min		V=70m/min		V=40m/min	
Radius	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
R1	16000	400-1000	12700	300-800	11000	200-400	6400	80-250
R1.5	10600		8500		7430		4250	
R2	8000		6400		5650		3200	
R3	5300		4200		3750		2100	
R4	4000		3200		2800		1600	
R5	3200		2500		2250		1200	
R6	2700		2100		1900		1000	
<div>■ D:Diameter</div> <div></div>	XY=0.2D Z=0.1-0.3D				XY=0.2D (Z) HRC45 below 0.1-0.3D HRC50 below 0.05-0.02D			