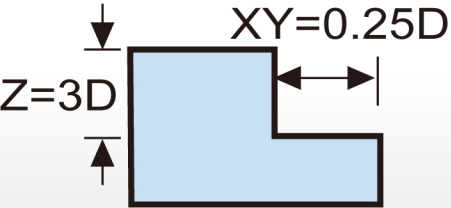


Work Material	Carbon Steels S45C.S50C HB150-250		Alloy Steels SCM(HPM) HRC20-35		Prehardened Steels NAK(HPM) HRC40		Hardened Steels SKD61 HBC50	
Diameter	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
2	4800	60	2850	30	2250	20	1650	15
3	3700	60	2250	40	2000	30	1800	20
4	3200	80	1900	50	1700	40	1500	30
5	2850	100	1700	65	1550	50	1350	45
6	2650	120	1600	70	1450	60	1250	55
8	2000	120	1200	70	1100	60	950	55
10	1600	120	950	70	850	60	750	55
12	1300	120	800	70	700	60	600	55
	Side Milling 				Side Milling 