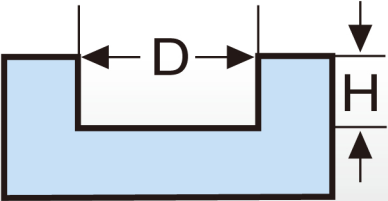


| Work Material |                  | Alloy Steels.Tool Steels.Hardened Steels<br>S45C, SCM, S50C, SCr, SNCM, SKD11, SKD61, NAK80 |                  |                       |
|---------------|------------------|---------------------------------------------------------------------------------------------|------------------|-----------------------|
| Diameter      | Effective Length | Speed<br>(mm <sup>-1</sup> )                                                                | Feed<br>(mm/mim) | Depth of Cut<br>H(mm) |
| 1             | 4                | 30000                                                                                       | 2200             | 0.15                  |
|               | 6                |                                                                                             | 2200             | 0.12                  |
|               | 8                |                                                                                             | 2200             | 0.12                  |
|               | 10               |                                                                                             | 2200             | 0.12                  |
| 1.5           | 4                | 25000                                                                                       | 1800             | 0.20                  |
|               | 6                |                                                                                             | 1800             | 0.18                  |
|               | 8                |                                                                                             | 1800             | 0.15                  |
|               | 10               |                                                                                             | 1800             | 0.15                  |
|               | 12               |                                                                                             | 1800             | 0.15                  |
| 2             | 8                | 20000                                                                                       | 1500             | 0.30                  |
|               | 10               |                                                                                             | 1500             | 0.30                  |
|               | 12               |                                                                                             | 1500             | 0.25                  |
|               | 16               |                                                                                             | 1500             | 0.25                  |
| 3             | 8                | 12000                                                                                       | 900              | 0.40                  |
|               | 12               |                                                                                             | 900              | 0.40                  |
|               | 16               |                                                                                             | 900              | 0.30                  |
|               | 20               |                                                                                             | 900              | 0.30                  |
| 4             | 10               | 9000                                                                                        | 850              | 0.50                  |
|               | 16               |                                                                                             | 850              | 0.40                  |
| Depth of Cut  |                  |        |                  |                       |