

Work Material	Alloy Steels <HRC50		Prehardened Steels HRC50-60		Hardened Steels >HRC60	
Velocity	V=170m/min		V=110m/min		V=80m/min	
Diameter	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
6	9000	800	5800	525	4250	380
8	6800	1000	4400	660	3200	480
10	5400	980	3500	630	2500	460
12	4500	950	2900	615	2100	450
16	3400	1200	2200	790	1600	570

■ D:Diameter

