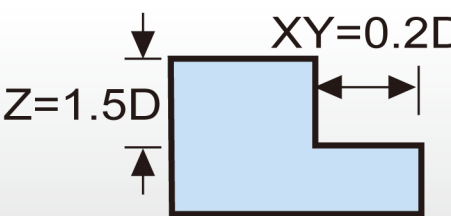
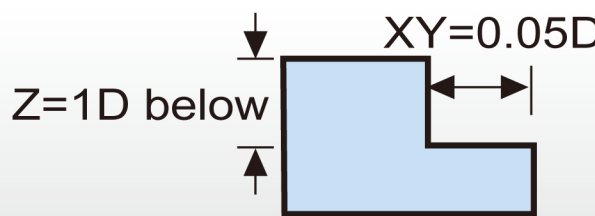
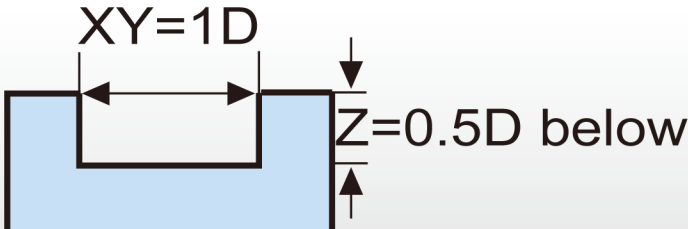


Work Material	Carbon Steels S50C.SCM.SS below HRC30		Alloy Steels SUS304.SUS316		Prehardened Steels NAK80.SKD61 HRC35-45		Hardened Steels SKD61.SKD11 HRC45-55	
Diameter	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
2	9500	150	8000	120	6400	80	3200	25
3	6400	150	5300	100	4200	80	2100	30
4	4800	180	4000	150	3200	100	1600	40
5	3800	240	3200	180	2550	100	1300	40
6	3200	260	2700	200	2100	130	1000	50
8	2400	260	2000	200	1600	130	800	45
10	1900	260	1600	200	1300	130	650	45
12	1600	260	1300	200	1000	130	530	40
16	1200	180	1000	140	800	90	400	30
	Side Milling 				Side Milling 			

Work Material	Carbon Steels S50C.SCM.SS below HRC30		Alloy Steels SUS304.SUS316		Prehardened Steels NAK80.SKD61 HRC35-45		Hardened Steels SKD61.SKD11 HRC45-55	
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	8000	90	6400	40	6400	30	3200	20
3	5300	100	4200	50	4200	40	2100	20
4	4000	120	3200	60	3200	50	1600	25
5	3200	170	2550	75	2550	65	1300	30
6	2700	180	1500	85	1500	70	1100	35
8	2000	190	1100	95	1100	80	800	35
10	1600	190	960	90	960	85	650	35
12	1300	190	800	90	800	70	530	25
16	1000	120	600	60	600	50	400	20
	Neck Milling-Front Milling 				Neck Milling-Front Milling 