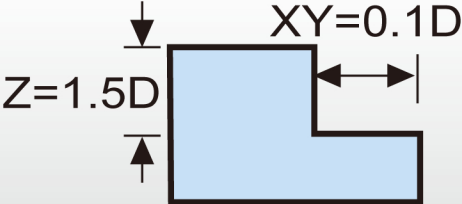


Work Material	Carbon Steels S45C.S50C HRC20-40		Alloy Steels NAK80 HRC40-50		Prehardened Steels SKD61 HRC50-60		Hardened Steels SKD11 UP HRC60	
Diameter	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
6	4300	780	3200	580	2200	380	1100	160
8	3200		2400		1600		800	
10	2600		1900		1300		650	
12	2100		1600		1000		530	
	Side Milling below HRC45 				Side Milling up HRC45 