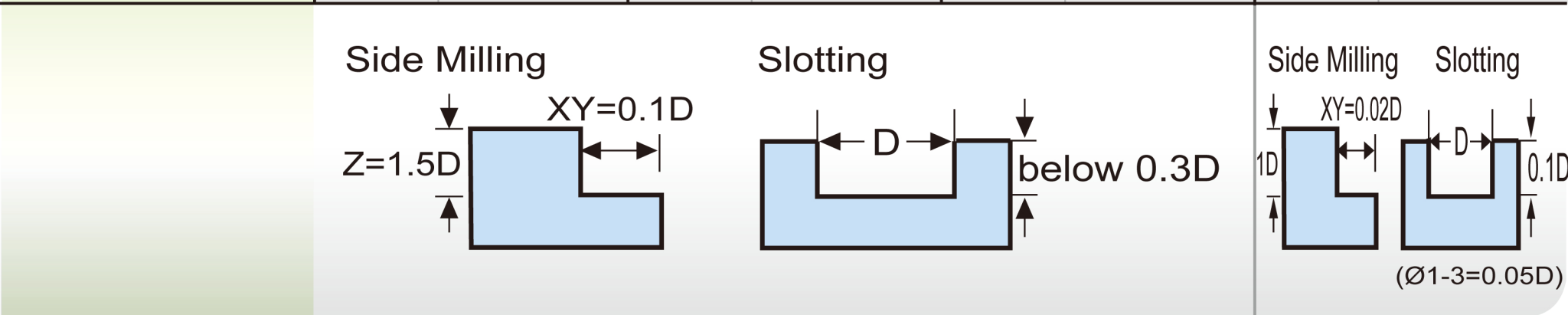


Work Material	Carbon Steels S50C			Alloy Steels SCM.SKD.SUS			Prehardened Steels HPM.NAK			Hardened Steels SKD61 -HRC52		
Velocity	V=60-80m/min			V=50-70m/min			V=30-50m/min			V=20-30m/min		
Diameter	Spindle Speed (mm ⁻¹)	Feed (mm/mim)		Spindle Speed (mm ⁻¹)	Feed (mm/mim)		Spindle Speed (mm ⁻¹)	Feed (mm/mim)		Spindle Speed (mm ⁻¹)	Feed (mm/mim)	
		Side Milling	Slotting		Side Milling	Slotting		Side Milling	Slotting		Side Milling	Slotting
2	12800	400	150	9600	210	70	6400	110	55	3200	80	40
3	8500	450	160	6400	250	80	4300	120	60	2100	100	50
4	6400	450	160	4800	250	80	3200	120	60	1600	100	50
5	5100	600	200	3800	300	90	2600	150	75	1300	120	60
6	2400	170	70	2100	140	55	1600	110	45	1100	80	30
8	1800	170	70	1600	140	55	1200	110	45	800	80	30
10	1400	170	70	1300	140	55	1000	110	45	650	80	30
12	1200	170	70	1100	140	55	800	110	45	530	80	30



- Adjust feed according to inclined angle.
- When corner processing, reduce the feed by approximately 50%-30%.
- When using low speed machine, reduce feed and depth of cut.