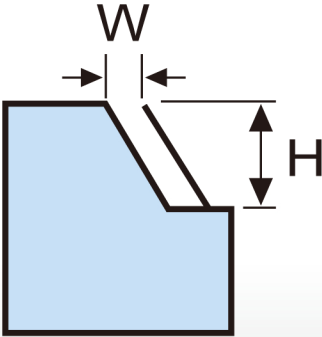
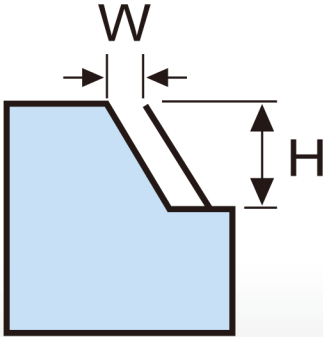


Work Material	Carbon Steels.Alloy Steels S45C, FC, FCD, SCM, S50C, SKS...		Alloy Steels.Tool Steels SCr, SNCM, SKD11, SKD61, NAK80...		Hardened Steels SKD11	
Hardness	~HRC30		~HRC50		~HRC60	
Diameter	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
1	12000	65	6800	40	2500	15
1.5	9600	70	5200	45	2000	15
2	7500	85	4000	48	1500	18
2.5	6800	100	3700	60	1700	20
4	3500	120	1800	60	600	20
6	2500	150	1600	80	550	25
8	2000	150	1200	80	450	25
10	1500	150	1000	80	350	25
Depth of Cut	 $H \leq 2.5D$ $W \leq 0.02D$ HRC45 ↓  $H \leq 2.5D$ $W \leq 0.01D$ HRC45 ↑					