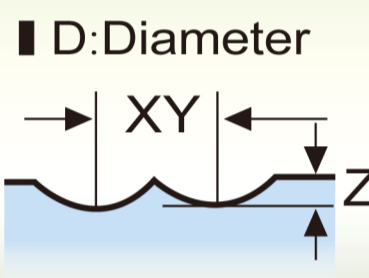
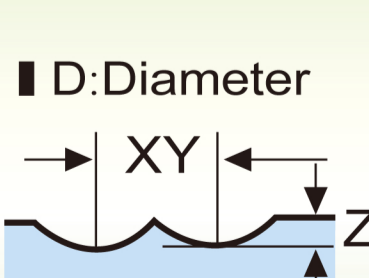


Work Material	NAK80 HRC40					
Velocity	V=376m/min		V=250m/min		V=188m/min	
Radius	Speed (mm <sup>-1</sup> )	Feed (mm/mim)	Speed (mm <sup>-1</sup> )	Feed (mm/mim)	Speed (mm <sup>-1</sup> )	Feed (mm/mim)
R1	40000	2000	40000	2000	30000	2000
R1.5	30000	2000	26000	2000	20000	2000
R2	25000	4800	20000	3200	15000	2400
R3	20000	6000	13000	4800	10000	4000
R4	15000	4500	10000	4000	7500	3300
R5	12000	4000	8000	3600	6000	2200
R6	10000	3500	6600	2400	5000	1800
 <p>D: Diameter</p>	XY=0.3D Z=0.05D		XY=0.5D Z=0.1D		XY=0.6D Z=0.1D	

Work Material	Hardened Steels SKD61 HRC52					
Velocity	V=376m/min		V=250m/min		V=188m/min	
Radius	Speed (mm <sup>-1</sup> )	Feed (mm/mim)	Speed (mm <sup>-1</sup> )	Feed (mm/mim)	Speed (mm <sup>-1</sup> )	Feed (mm/mim)
R1	20000	2000	15000	1200	10000	1000
R1.5	20000	2000	15000	1200	10000	1000
R2	20000	2000	15000	1200	10000	1000
R3	20000	6000	13000	4500	6400	1500
R4	15000	4000	10000	3600	4800	1500
R5	12000	4000	8000	3200	3800	1500
R6	10000	3600	6600	1800	3200	1500
 <p>D: Diameter</p>	XY=0.1D Z=0.02D		XY=0.15D Z=0.04D		XY=0.2D Z=0.04D	