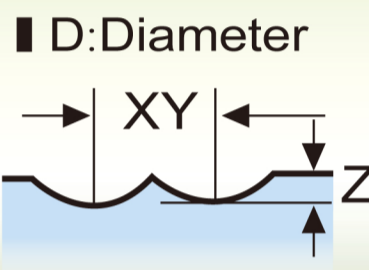
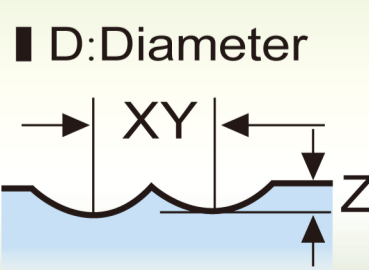


Work Material	Carbon Steels S45C.S50C HB150-250		Alloy Steels SCM.PDS5.PDS3 HRC20-35		Prehardened Steels NAK80.SKD11 HRC35-45		Hardened Steels SKD61 HBC45-55	
Velocity	V=80-120m/min		V=60-100m/min		V=40-80m/min		V=40m/min	
Radius	Speed (mm <sup>-1</sup> )	Feed (mm/mim)	Speed (mm <sup>-1</sup> )	Feed (mm/mim)	Speed (mm <sup>-1</sup> )	Feed (mm/mim)	Speed (mm <sup>-1</sup> )	Feed (mm/mim)
R0.1	30000	500-700	30000	450-600	25000	300-600	20000	200-400
R0.15	30000	500-700	30000	450-600	25000		20000	
R0.2	30000	600-800	30000	500-700	25000		20000	
R0.25	30000	600-800	30000	500-700	25000		20000	
R0.3	25000	800-1000	25000	600-1000	20000		18000	
R0.35	25000	800-1000	25000	600-1000	20000		18000	
R0.4	20000	800-1000	20000	600-1000	20000		18000	
R0.5	20000	800-1000	20000	600-1000	20000		18000	
 D: Diameter (Z) HRC45 below 0.05-0.15R HRC50 below 0.05-0.15R					(Z) HRC45 below 0.05-0.15R HRC50 below 0.05-0.08R			

Work Material	Copper		HRC20-30		HRC30-48	
Velocity	V=230m/min		V=100m/min		V=70m/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)
R0.15	60000	600	60000	600	60000	500
R0.2	60000	600	60000	600	45000	500
R0.25	60000	600	45000	600	45000	500
R0.3	60000	1000	45000	900	32000	600
R0.35	60000	1200	45000	950	32000	650
R0.4	60000	1200	36000	950	25000	650
R0.5	60000	1800	32000	950	18500	650
R0.75	49000	1800	21000	850	15000	550
R1	36500	1800	16000	850	11000	550
R1.5	24000	1800	10000	850	7400	550
R2	18000	1800	8000	850	5500	550
 D: Diameter XY=0.1D Z=0.01D			XY=0.1D Z=0.01D		XY=0.1D Z=0.01D	