

Work Material		S50C. PX5. SKD11. HPM-1. NAK55					
Radius	Effective Length	Speed (mm ⁻¹)	Feed (mm/mim)	Long Neck Milling (mm/per time)	Feed (mm/mim)	3D Milling (mm/per time)	
R0.5	6L	12800-30000	300-800	0.01-0.05	800-1200	0.1-0.3	
	8L						
	10L						
	12L						
R0.75	8L	8500-30000		300-800	0.02-0.10	800-1200	0.1-0.4
	12L						
	16L						
	20L						
R1	8L	6400-30000	300-800		0.02-0.30	800-2000	0.1-0.4
	12L						
	16L						
	20L						
R1.5	8L	4200-20000		300-800	0.02-0.30	800-2000	0.1-0.4
	10L						
	16L						
	20L						
	25L						
R2	10L	3200-15000	300-800		0.02-0.30	800-1500	0.1-0.5
	15L						
	20L						
	25L						
	30L						