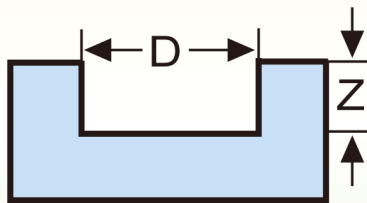


Work Material	Carbon Steels S45C.S50C HB225		Alloy Steels SK.SCM.SUS HB225-325		Prehardened Steels NAK.SKD HRC30-45		Hardened Steels SKD11,61.SKT HBC45-55	
	Diameter	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)
1	20000	125	15000	120	12000	65	7100	30
2	11000	130	8500	120	6400	70	4000	40
3	7400	195	6400	145	4500	80	2800	45
4	5900	230	5000	190	3500	90	2150	50
5	5300	310	4200	230	2950	90	1850	55
6	4400	305	3500	230	2450	100	1500	55
8	3300	290	2600	230	1850	95	1200	50
10	2600	275	2100	225	1450	95	950	50
12	2200	275	1750	225	1200	90	800	45



■ Slot Milling

$$D \leq \varnothing 1, \quad Z = 0.1D$$

$$\varnothing 1 \leq D < \varnothing 3, \quad Z = 0.3D$$

$$\varnothing 3 \leq D, \quad Z = 0.5D$$

$$D < \varnothing 1, \\ Z = 0.01D \\ \varnothing 1 \leq D < \varnothing 3, \\ Z = 0.02D \\ \varnothing 3 \leq D, \\ Z = 0.05D$$