

Work Material	Carbon Steels S45C.S50C HB150-250		Alloy Steels SCM.P20.PDS5.PDS3.SKD11 HRC20-35		Prehardened Steels NAK80 HRC35-45		Hardened Steels SKD61 HBC45-55	
Velocity	V=80-120 m/min		V=60-100 m/min		V=40-80 m/min		V=40 m/min	
Diameter	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
0.2	30000	90	30000	80	30000	40	20000	25
0.3	30000	100	30000	80	30000	60	16500	25
0.4	25000	110	25000	90	25000	65	12500	25
0.5	25000	110	25000	90	25000	65	10000	25
0.6	25000	110	25000	90	25000	65	8500	25
0.7	25000	110	25000	90	25000	65	6500	25
0.8	25000	110	25000	90	25000	65	6500	25
1	20000	120	15000	100	13000	70	6000	30
1.2	20000	120	15000	100	13000	70	5000	30
1.5	15000	120	10000	100	8500	70	4500	35
1.6	15000	120	10000	100	8500	70	4500	35
1.8	11000	120	7500	110	6800	80	4000	35
2	11000	130	7500	110	6800	80	4000	40
2.5	9000	150	6500	110	6000	80	3500	40
3	7500	195	6000	110	5500	80	2800	40
■ D:Diameter	D ≤ Ø1 Z=0.1D Ø1 ≤ D < Ø3 Z=0.3D				D ≤ Ø1 Z=0.1D Ø1 ≤ D < Ø3 Z=0.3D			
								