

Work Material	Carbon Steels Alloy Steels <HRC50		Hardened Steels HRC50-60		Hardened Steels >HRC60	
	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
Diameter						
6	16000	5800	8000	2900	4000	1400
8	12000	5800	6000	2900	3000	1400
10	9500	5700	4800	2900	2400	1400
12	8000	4800	4000	2400	2000	1200
16	6000	3600	3000	1800	1500	900
D: Diameter						