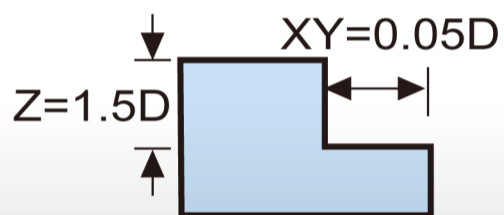
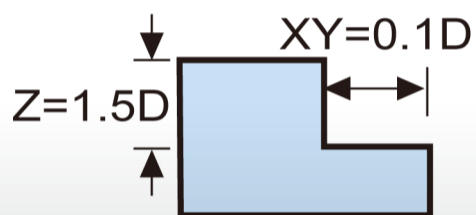


Work Material	Carbon Steels S45C.S50C HB150-250		Alloy Steels SCM.SUS(HPM) HBC20-35		Prehardened Steels NAK(HPM) HRC40		Hardened Steels SKD61 HBC50	
Diameter	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
1	21000	400	18000	210	16000	160	9800	110
2	14000	400	9600	250	8000	180	4800	110
3	9500	450	6400	250	5300	200	3200	120
4	7200	550	4800	320	4000	200	2400	120
5	5700	700	3800	350	3200	220	1900	160
6	4800	700	3200	380	2650	220	1600	180
8	3600	600	2400	380	2000	220	1200	180
10	2900	600	1900	380	1600	220	950	180
12	2400	430	1600	300	1300	200	800	150

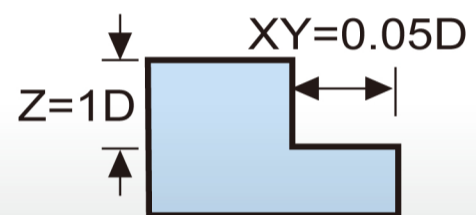
Side Milling
below Ø3



Side Milling
up to Ø4



Side Milling



Work Material	Alloy Steels SCM.SUS(HPM) HRC20-35		Prehardened Steels NAK80(HPM) HRC35-45		Hardened Steels SKD61 HBC45-55	
Velocity	V=170 m/min		V=110 m/min		V=80 m/min	
Diameter	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)	Speed (mm ⁻¹)	Feed (mm/mim)
3	18000	720	11500	465	8500	340
4	13500	810	8800	525	6400	380
5	10800	650	7000	420	5100	300
6	9000	720	5800	465	4250	340
8	6800	675	4400	440	3200	320
10	5400	755	3500	490	2550	355
12	4500	720	2900	465	2100	340
16	3400	745	2200	480	1600	350

